



# American Made Conveyor Solutions

## PRODUCT GUIDE



Custom Solutions for Unique Applications

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## Gator Singulator

— **450 FPM**

— **320 lb/FT Capacity**

— **48" Conveying Surface**

— **XLD Drive Bands**

— **Unidrive 24vdc Motor System**

— **Zone Speed Adjustment**

— **Photo Eye Monitoring**

As product enters the conveyor from multiple lines the singulator descrambles the packages. Two sets of skewed rollers move the packages toward the center of the conveyor where they rotate to a lengthwise orientation. Four speed changes occur as packages proceed to the discharge end, allowing the product to space and exit in a single file.

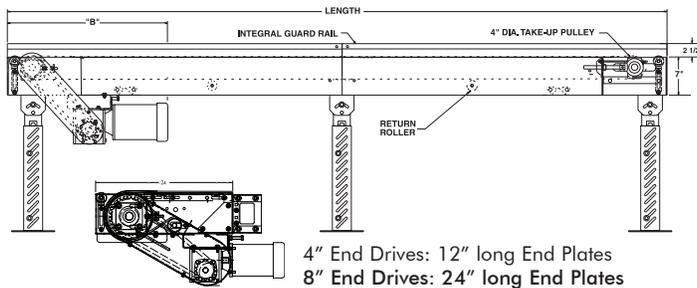
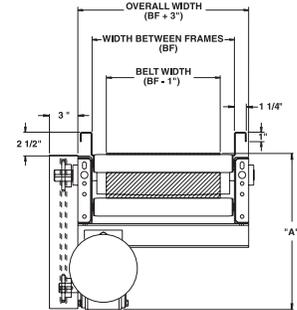
Dual center drives run 2 lanes of 1.9" dia. high-speed precision rollers. The rollers are skewed toward the center in a herringbone pattern driven by XLD drive bands, which allow for more rollers per motor at higher loads. The Gator Singulator is band-driven by the low profile Unidrive motor system for high-speed precision and near silent operation. Each zone is monitored with photo eyes for speed adjustment accuracy throughout the singulation process.



## 725TB | TROUGH BED BELT CONVEYOR



725TB trough bed belt conveyor is ideal for handling chips, slugs, scrap wood, paper waste, boxes, packages and cartons. The troughed frame design offers integral guard rails for many trash conveyor applications.



HP@ 60 FPM	"A" MAX		"B" MAX	
	4" DRV.	8" DRV.	4" DRV.	8" DRV.
1/2	16-5/8"	16-5/8"	27-3/32"	33-3/32"
3/4	17"	17"	27-23/32"	33-23/32"
1	17-1/4"	17-1/4"	28-15/32"	34-15/32"
1-1/2	18-1/8"	18-1/8"	31-3/32"	37-3/32"
2	19"	19"	32-3/32"	38-3/32"

### SPECIFICATIONS

- ▶ **BELTING:** PVC-120 black.
- ▶ **DRIVE PULLEY:** 4" dia. with 1-3/16" dia. shaft or 8" dia. with 1-7/16" dia. shaft, both machine crowned and fully lagged.
- ▶ **TAIL PULLEY:** 4" dia., machine crowned, with 1-3/16" dia. shaft.
- ▶ **END DRIVE:** Allows one-direction (unit) operation; add optional center drive for reversible application.
- ▶ **TAKE-UP:** Screw type unit at tail pulley provides 12" belt take-up.

- ▶ **SAFETY POP-OUT ROLLER:** Standard on both ends, 1.9" dia. x 16 ga. galv. steel roller, model 196G.
- ▶ **BEARINGS:** All pulley bearings are precision, heavy duty, lubricated, ball bearing units with cast iron housings.
- ▶ **BED:** 7" deep x 12 ga. box type bed with bed pan braces (all widths) and with 2-1/2" deep x 12 ga. formed trough with formed flanges on sides to provide extra strength.

- ▶ **MOTOR DRIVE:** 1/2 HP, 230/460/3, 60 cycle, Super "E" right angle gear motor.
- ▶ **ROLLER CHAIN:** Drive pulley is driven by No. 50 roller chain for 1-1/2 HP or less and No. 60 chain on larger drives. Chain take-up provided on motor base.
- ▶ **RETURN ROLLERS:** 1.9" dia. 16 ga. galv. steel, model 196G, adjustable.
- ▶ **BELT SPEED:** 60 FPM, constant.
- ▶ **ELECTRICAL CONTROLS:** Optional.

### ⚠ WARNING

Prevent pinch points that exist when belt conveyors are permanently attached to other conveyors or equipment!

**SPECIFICATION TABLE**

50'-0" lengths and under are equipped with 4" dia. drive pulley; over 50'-0" includes 8" dia. drive pulley

CONVEYOR LENGTH		10'	20'	30'	40'	50'	60'	70'	80'	90'	100'	DEDUCT
BELT	BED	UNIT WEIGHTS (lbs.)										PER FOOT
6"	7"	305	477	649	821	993	1166	1338	1510	1682	1854	17
12"	13"	360	569	778	988	1197	1406	1615	1825	2034	2243	21
18"	19"	415	661	907	1154	1400	1646	1893	2139	2386	2632	25
24"	25"	469	753	1036	1320	1603	1887	2170	2454	2737	3021	28
30"	31"	524	845	1165	1486	1807	2127	2448	2769	3089	3410	32
36"	37"	579	937	1295	1652	2010	2368	2726	3083	3441	3799	36

■ 3 week shipment

**OPTIONAL EQUIPMENT**

► **BELTING:** Black PVC ruff-top; PVC-120 white food grade COS; PVC-150 black COS; Consult factory for other belting.

► **CENTER DRIVE:** Reversible drive with integral belt take-up of 24". Specify location. Center drive option available on units 6'-0" long and above.

► **SIDE MOUNTED END DRIVE:**  
**OVERHEAD END DRIVE:** Provides minimum conveyor height of 8" TOB (4" dia. drive pulley); 10" TOB (8" dia. drive pulley).

► **BELT SPEED:** Constant speed 10-120 FPM; DC variable speed; AC inverter variable speed. Other constant or variable speeds available.

**NOTE:** CAPACITY CHANGES WITH SPEED.

► **AUXILIARY TAKE-UP:** Provides 24" of belt take-up. Specify location. See Power Accessories.

► **UNDERTRUSSED BED:** Available to provide clearance underneath unit at bed joint locations. Specify location for undertrussing and desired clearance underneath unit. Consult factory.

► **MOTORS:** Available through 3 HP in Super "E", explosion proof, dirty duty, brake motor, 115/230/1, 575/3, etc.

► **FLOOR SUPPORTS:** Conveyor shown with optional supports. Supports, knee braces, casters and polytier supports available. See Conveyor Accessories.

► **CEILING HANGERS:** 5/8" dia. threaded rod with hardware to attach rods to conveyor. Provides 6' clear-

ance between ceiling and TOB (furnished in place of floor supports). See Conveyor Accessories.

► **GUARD RAILS:** Available in 2", 4", 6", 9" and 12" heights (model FSG) to attach to troughed frame to increase trough depth. Note: 6", 9", and 12" sides are not available with 6" belt or 7" bed conveyors. 9" and 12" sides are not available with 12" or 13" Conveyors. See Conveyor Accessories.

► **ELECTRICAL CONTROLS:** Magnetic starter (one direction or reversible); One direction manual starter; Momentary start/stop push button station; For-ward/reversing /stop push button station. Mounting and pre-wiring for units up to 12' long.



DETAIL OF INTERMEDIATE BED SECTION

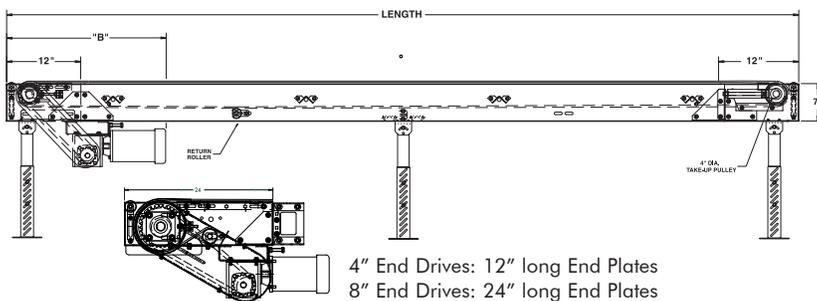
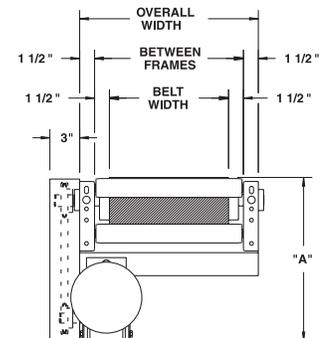


OPTIONAL OVERHEAD MOUNTED DRIVE

## 700SB | MEDIUM DUTY SLIDER BED BELT CONVEYOR



Slider bed belt conveyors remain the most popular of all powered conveyors, providing an economical means of transporting goods for packing, testing, inspecting and various assembly line operations



HP@ 60 FPM	"A" MAX		"B" MAX	
	4" DRV.	8" DRV.	4" DRV.	8" DRV.
1/2	16-5/8"	16-5/8"	27-3/32"	33-3/32"
3/4	17"	17"	27-23/32"	33-23/32"
1	17-1/4"	17-1/4"	28-15/32"	34-15/32"
1-1/2	18-1/8"	18-1/8"	31-3/32"	37-3/32"
2	19"	19"	32-3/32"	38-3/32"

### SPECIFICATIONS

- ▶ **BELTING:** PVC-120 black.
- ▶ **DRIVE PULLEY:** 4" dia. with 1-3/16" dia. shaft or 8" dia. with 1-7/16" dia. shaft, both machine crowned and fully lagged.
- ▶ **TAIL PULLEY:** 4" dia., machine crowned, with 1-3/16" dia. shaft.
- ▶ **END DRIVE:** Allows one-direction (unit) operation; add optional center drive for reversible application.
- ▶ **TAKE-UP:** Screw type unit at tail pulley provides 12" belt take-up.
- ▶ **SAFETY POP-OUT ROLLER:** Standard on both ends, 1.9" dia. x 16 ga. galv. steel roller, model 196G.
- ▶ **BEARINGS:** All pulley bearings are precision, heavy duty, lubricated, ball bearing units with cast iron housings.
- ▶ **BED:** 7" x 1-1/2" x 12 ga. channel frame with 14 ga. slider bed.
- ▶ **BELT SPEED:** 60 FPM, constant.
- ▶ **MOTOR DRIVE:** 1/2 HP, 230/460/3, 60 cycle, Super "E" right angle gear motor.
- ▶ **ROLLER CHAIN:** Drive pulley is driven by No. 50 roller chain for 1-1/2 HP or less and No. 60 chain on larger drives. Chain take-up provided on motor base.
- ▶ **RETURN ROLLERS:** 1.9" dia. x 16 ga. galv. steel, model 196G, adjustable.
- ▶ **ELECTRICAL CONTROLS:** Optional.

### ⚠ WARNING

Prevent pinch points that exist when belt conveyors are permanently attached to other conveyors or equipment!

**SPECIFICATION TABLE**

50'-0" lengths and under are equipped with 4" dia. drive pulley; over 50'-0" includes 8" dia. drive pulley

CONVEYOR LENGTH		10'	20'	30'	40'	50'	60'	70'	80'	90'	100'	DEDUCT
BELT	BED	UNIT WEIGHTS (lbs.)										PER FOOT
6"	9"	260	389	518	647	776	904	1033	1162	1291	1420	13
12"	15"	315	482	650	818	986	1154	1322	1490	1657	1825	17
18"	21"	369	576	783	990	1196	1403	1610	1817	2024	2230	21
24"	27"	424	670	915	1161	1407	1653	1898	2144	2390	2636	25
30"	33"	478	763	1048	1333	1617	1902	2187	2471	2756	3041	29
36"	39"	533	857	1180	1504	1828	2151	2475	2799	3122	3446	32

■ 3 week shipment

**OPTIONAL EQUIPMENT**

► **BELTING:** Black PVC ruff-top; PVC-120 white food grade COS; PVC-150 black COS; Consult factory for other belting.

► **CENTER DRIVE:** Reversible drive with integral belt take-up of 24". Specify location. Center drive option available on units 6'-0" long and above.

► **SIDE MOUNTED END DRIVE:** Provides minimum conveyor height of 10" TOB (4" dia. drive pulley); 12" TOB (8" dia. drive pulley).

► **OVERHEAD END DRIVE:** Provides minimum conveyor height of 8" TOB (4" dia. drive pulley); 10" TOB (8" dia. drive pulley).

► **NOSE-OVER:** Provides smooth transition from incline to horizontal position. Single nose-over adjusts 0-20°; double nose-over adjusts 0-35°. Feeders also available. See Power Accessories.

► **AUXILIARY TAKE-UP:** Provides 24" of belt take-up. Specify location. See Power Accessories.

► **SIDE TABLES:** Available in 9", 15" and 21" widths (14 ga.) one or both sides. See Power Accessories.

► **UNDERTRUSSED BED:** Available to provide clearance underneath unit at bed joint locations. Specify location for undertrussing and desired clearance underneath unit. Consult factory.

► **CEILING HANGERS:** 5/8" dia. threaded rod with hardware to attach rods to conveyor. Provides 6' clearance between ceiling and TOB (furnished in place of floor supports). See Conveyor Accessories.

► **BELT SPEED:** Constant speed 10-120 FPM; DC variable speed; AC inverter variable speed. Other constant or variable speeds available.

**NOTE:** CAPACITY CHANGES WITH SPEED.

► **FLOOR SUPPORTS:** Conveyor shown with optional supports. Supports, knee braces, casters and polytier supports available. See Conveyor Accessories.

► **GUARD RAILS:** 1-3/4" x 1" formed channel (model GC), adjusts horizontally to 10" wider than belt and vertically to 6" above belt; formed steel fixed (model FSG in 2", 4", 6", 8", 12", and 18" heights; fixed channel (model FC); 1-1/2" angle (model GA1-1/2). See Conveyor Accessories.

► **MOTORS:** Available through 3 HP in Super "E", explosion proof, dirty duty, brake motor, 115/230/1, 575/3, etc.

► **ELECTRICAL CONTROLS:** Magnetic starter (one direction or reversible); One direction manual starter; Momentary start/stop push button station; Forward/reversing /stop push button station. Mounting and pre-wiring for units up to 12' long.



OPTIONAL DC VARIABLE SPEED CONTROLLER

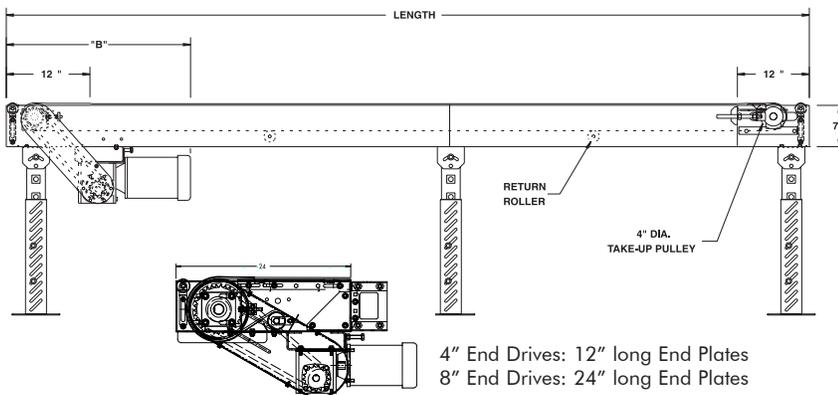
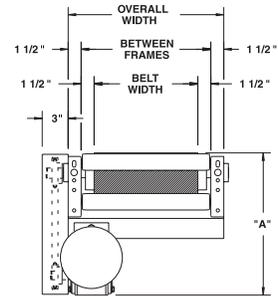


OPTIONAL CENTER DRIVE

## 700BSB | MEDIUM DUTY BOX STYLE SLIDER BED BELT CONVEYOR



Model 700BSB features a box style slider bed which offers a smooth work surface, ideal for workers stationed beside this conveyor. The 700BSB is an economical choice for tasks such as packing, testing and inspecting.



4" End Drives: 12" long End Plates  
8" End Drives: 24" long End Plates

HP@ 60 FPM	"A" MAX		"B" MAX	
	4" DRV.	8" DRV.	4" DRV.	8" DRV.
1/2	16-5/8"	16-5/8"	27-3/32"	33-3/32"
3/4	17"	17"	27-23/32"	33-23/32"
1	17-1/4"	17-1/4"	28-15/32"	34-15/32"
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2	19"	19"	32-3/32"	38-3/32"

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- ▶ **TAIL PULLEY:** 4" dia., machine crowned, with 1-3/16" dia. shaft.
- ▶ **END DRIVE:** Allows one-direction (unit) operation; add optional center drive for reversible application.
- ▶ **SAFETY POP-OUT ROLLER:** Standard on both ends, 1.9" dia. x 16 ga. galv. steel roller, model 196G.
- ▶ **TAKE-UP:** Screw type unit at tail pulley provides 12" belt take-up.
- ▶ **BED:** 7" deep x 12 ga. box type construction.
- ▶ **BEARINGS:** All pulley bearings are precision, heavy duty, lubricated, ball bearing units with cast iron housings.
- ▶ **RETURN ROLLERS:** 1.9" dia. x 16 ga. steel, model 196G, adjustable.
- ▶ **MOTOR DRIVE:** 1/2 HP, 230/460/3, 60 cycle, Super "E" right angle gear motor.
- ▶ **ROLLER CHAIN:** Drive pulley is driven by No. 50 roller chain for 1-1/2 HP or less and No. 60 chain on larger drives. Chain take-up provided on motor base.
- ▶ **BELT SPEED:** 60 FPM, constant.
- ▶ **ELECTRICAL CONTROLS:** Optional.

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BELT	BED	UNIT WEIGHTS (lbs.)										PER FOOT
6"	9"	267	391	515	640	764	888	1012	1137	1261	1385	12
12"	15"	325	497	669	840	1012	1183	1355	1527	1698	1870	17
18"	21"	384	603	822	1041	1260	1479	1698	1917	2136	2355	22
24"	27"	442	709	975	1241	1508	1774	2040	2307	2573	2839	27
30"	33"	501	814	1128	1442	1756	2069	2383	2697	3010	3324	31
36"	39"	559	920	1281	1642	2003	2365	2726	3087	3448	3809	36

■ 3 week shipment

OPTIONAL EQUIPMENT

► **BELTING:** Black PVC ruff-top; PVC-120 white food grade COS; PVC-150 black COS; Consult factory for other belting.

► **CENTER DRIVE:** Reversible drive with integral belt take-up of 24". Specify location. Center drive option available on units 6'-0" long and above.

► **SIDE MOUNTED END DRIVE:** Provides minimum conveyor height of 10" TOB (4" dia. drive pulley); 12" TOB (8" dia. drive pulley).

► **OVERHEAD END DRIVE:** Provides minimum conveyor height of 8" TOB (4" dia. drive pulley); 10" TOB (8" dia. drive pulley).

► **AUXILIARY TAKE-UP:** Provides 24" of belt take-up. Specify location. See Power Accessories.

► **NOSE-OVER:** Provides smooth transition from incline to horizontal position. Single nose-over adjusts 0-20°; double nose-over adjusts 0-35°. Feeders also available. See Power Accessories.

► **UNDERTRUSSED BED:** Available to provide clearance underneath unit at bed joint locations. Specify location for undertrussing and desired clearance underneath unit. Consult factory.

► **SIDE TABLES:** Available in 9", 15" and 21" widths (14 ga.) one or both sides. See Power Accessories.

► **FLOOR SUPPORTS:** Conveyor shown with optional supports. Supports, knee braces, casters and polytier supports available. See Conveyor Accessories.

► **CEILING HANGERS:** 5/8" dia. threaded rod with hardware to attach rods to conveyor. Provides 6' clearance between ceiling and TOB (furnished in place of floor supports). See Conveyor Accessories.

► **GUARD RAILS:** 1-3/4" x 1" formed channel (model GC), adjusts horizontally to 10" wider than belt and vertically to 6" above belt; formed steel fixed (model FSG in 2", 4", 6", 8", 12", and 18" heights; fixed channel (model FC); 1-1/2" angle (model GA1-1/2). See Conveyor Accessories.

► **BELT SPEED:** Constant speed 10-120 FPM; DC variable speed; AC inverter variable speed. Other constant or variable speeds available. **NOTE:** CAPACITY CHANGES WITH SPEED.

► **MOTORS:** Available through 3 HP in Super "E", explosion proof, dirty duty, brake motor, 115/230/1, 575/3, etc.

► **ELECTRICAL CONTROLS:** Magnetic starter (one direction or reversible); One direction manual starter; Momentary start/stop push button station; Forward/reversing /stop push button station. Mounting and pre-wiring for units up to 12' long.

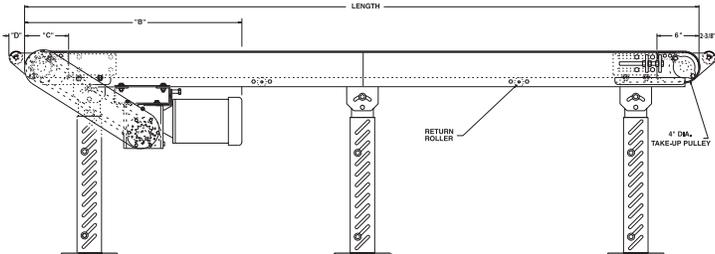
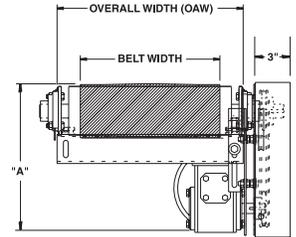


OPTIONAL CENTER DRIVE

## 450BOS | BOX STYLE SLIDER BED BELT CONVEYOR W/ ROUND END PLATES



Model 450BOS slider bed belt conveyor is one of the most popular and common means of transporting goods for packing, testing, inspecting and a variety of assembly line operations. 450BOS features a box style slider bed, ideal for workers stationed alongside the conveyor.



HP@ 60 FPM	"A" MAX		"B" MAX	
	4" DRV.	8" DRV.	4" DRV.	8" DRV.
1/2	13-13/16"	13-13/16"	29-3/32"	32-3/32"
3/4	14-3/16"	14-3/16"	29-23/32"	32-23/32"
1	14-1/2"	14-1/2"	30-15/32"	33-15/32"
1-1/2	15-9/16"	15-9/16"	32-19/32"	35-19/32"
2	16-7/16"	16-7/16"	33-19/32"	36-19/32"

### SPECIFICATIONS

- ▶ **BELTING:** PVC-120 black.
- ▶ **DRIVE PULLEY:** 4" dia. with 1-3/16" dia. shaft or 8" dia. with 1-7/16" dia. shaft, both machine crowned and fully lagged, mounted in round style end plates.
- ▶ **TAIL PULLEY:** 4" dia., machine crowned, with 1-3/16" dia. shaft, mounted in round style end plates.
- ▶ **END DRIVE:** Allows one-direction (unit) operation; add optional center drive for reversible application.

- ▶ **TAKE-UP:** Belt take-up provided at tail pulley with screw type unit.
- ▶ **BELT SPEED:** 60 FPM, constant.
- ▶ **BED:** 4-1/2" deep x 12 ga. box type construction with bed pan braces (30" OAW and above) and round style end plates.
- ▶ **BEARINGS:** All pulley bearings are precision, heavy duty, lubricated, ball bearing units with cast iron housings.

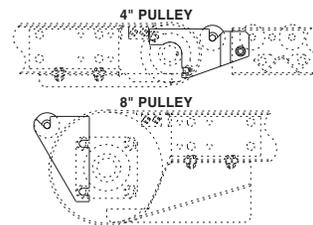
- ▶ **RETURN ROLLERS:** 1.9" dia. x 16 ga. steel, model 196G, adjustable.
- ▶ **MOTOR DRIVE:** 1/2 HP, 230/460/3, 60 cycle, Super "E" right angle gear motor.
- ▶ **ROLLER CHAIN:** Drive pulley is driven by No. 50 roller chain for 1-1/2 HP or less and No. 60 chain on larger drives. Chain take-up provided on motor base.
- ▶ **ELECTRICAL CONTROLS:** Optional.

### SPECIFICATIONS

- ▶ **CONSTRUCTION:** Brackets are 10 ga. HRS painted steel and bolt at end of powered conveyor to butt couplings. Gravity conveyor attaches to connector bracket.

- ▶ **POP-OUT ROLLERS:** Mounts into slot on bracket for safety design. Use of connector bracket eliminates dangerous pinch points.

**CBOS-4-24**  
CBOS-(pulley diameter\*)-(overall width)



### ⚠ WARNING

Prevent pinch points that exist when belt conveyors are permanently attached to other conveyors or equipment! Use connector brackets with safety pop out rollers shown above.

**SPECIFICATION TABLE**

50'-0" lengths and under are equipped with 4" dia. drive pulley; over 50'-0" includes 8" dia. drive pulley

CONVEYOR LENGTH		10'	20'	30'	40'	50'	60'	70'	80'	90'	100'	DEDUCT
BELT	BED	UNIT WEIGHTS (lbs.)										PER FOOT
6"	10"	203	295	387	479	571	663	755	847	939	1031	9
12"	16"	263	395	528	660	793	925	1058	1190	1323	1455	13
18"	22"	323	496	669	842	1015	1188	1361	1534	1706	1879	17
24"	28"	383	596	810	1023	1237	1450	1663	1877	2090	2304	21
30"	34"	443	697	951	1205	1458	1712	1966	2220	2474	2728	25
36"	40"	503	797	1092	1386	1680	1975	2269	2563	2858	3152	29

■ 3 week shipment

**OPTIONAL EQUIPMENT**

► **BELTING:** Black PVC ruff-top; PVC-120 white food grade COS; PVC-150 black COS; Consult factory for other belting.

► **CENTER DRIVE:** Reversible drive with integral belt take-up of 24". Specify location. Center drive option available on units 7'-0" long and above.

► **SIDE MOUNTED END DRIVE:** Provides minimum conveyor height of 10" TOB (4" dia. drive pulley); 11" TOB (8" dia. drive pulley).

► **OVERHEAD END DRIVE:** Provides minimum conveyor height of 6" TOB (4" dia. drive pulley); 10" TOB (8" dia. drive pulley).

► **AUXILIARY TAKE-UP:** Provides 24" of belt take-up. Specify location. See Power Accessories.

► **SIDE TABLES:** Available in 9", 15" and 21" widths (14 ga.) one or both sides. See Power Accessories.

► **FLOOR SUPPORTS:** Conveyor shown with optional supports. Supports,

knee braces, casters and polytier supports available. See Conveyor Accessories.

► **NOSE-OVER:** Provides smooth transition from incline to horizontal position. Single nose-over adjusts 0-20°; double nose-over adjusts 0-35°. See Power Accessories.

► **UNDERTRUSSED BED:** Available to provide clearance underneath unit at bed joint locations. Specify location for undertrussing and desired clearance underneath unit. Consult factory.

► **CEILING HANGERS:** 5/8" dia. threaded rod with hardware to attach rods to conveyor. Provides 6' clearance between ceiling and TOB (furnished in place of floor supports). See Conveyor Accessories.

► **MOTORS:** Available through 3 HP in Super "E", explosion proof, dirty duty, brake motor, 115/230/1, 575/3, etc.

► **GUARD RAILS:** 1-3/4" x 1" formed channel (model GC), adjusts horizontal-

ly to 10" wider than belt and vertically to 6" above belt; formed steel fixed (model FSG in 2", 4", 6", 8", 12", and 18" heights; fixed channel (model FC); 1-1/2" angle (model GA1-1/2). See Conveyor Accessories.

► **BELT SPEED:** Constant speed 10-120 FPM; DC variable speed; AC inverter variable speed. Other constant or variable speeds available. **NOTE:** CAPACITY CHANGES WITH SPEED.

► **ELECTRICAL CONTROLS:** Magnetic starter (one direction or reversible); One direction manual starter; Momentary start/stop push button station; Forward/reversing /stop push button station. Mounting and pre-wiring for units up to 12' long.

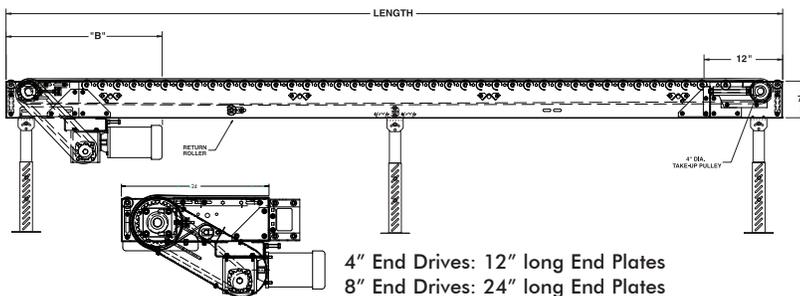
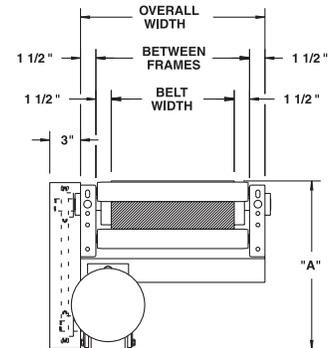


4" END DRIVE WITH ROUND END PLATES

# 796RB | MEDIUM DUTY ROLLER BED BELT CONVEYOR



Model 796RB, medium duty roller bed belt conveyor, is well suited for transporting unit loads with lesser horsepower requirements than slider bed belt conveyors.



HP@ 60 FPM	"A" MAX		"B" MAX	
	4" DRV.	8" DRV.	4" DRV.	8" DRV.
1/2	16-5/8"	16-5/8"	27-3/32"	33-3/32"
3/4	17"	17"	27-23/32"	33-23/32"
1	17-1/4"	17-1/4"	28-15/32"	34-15/32"
1-1/2	18-1/8"	18-1/8"	31-3/32"	37-3/32"
2	19"	19"	32-3/32"	38-3/32"

## SPECIFICATIONS

- ▶ **BELTING:** PVC-120 black.
- ▶ **CARRIER ROLLERS:** 1.9" dia. x 16 ga. galv. steel rollers, model 196G.
- ▶ **DRIVE PULLEY:** 4" dia. with 1-3/16" dia. shaft or 8" dia. with 1-7/16" dia. shaft, both machine crowned and fully lagged.
- ▶ **TAIL PULLEY:** 4" dia., machine crowned, with 1-3/16" dia. shaft.
- ▶ **END DRIVE:** Allows one-direction (unit) operation; add optional center drive for reversible application.
- ▶ **SAFETY POP-OUT ROLLER:** Standard on both ends, 1.9" dia. x 16 ga. galv. steel roller, model 196G.
- ▶ **SQUARING RODS:** Adjustable rods on underside of bed allow frame to be squared for improved belt tracking and are standard on all units over 30'.
- ▶ **BED:** 7" x 1-1/2" x 12 ga. channel frame. Bed sections attached with couplings and floor supports.
- ▶ **BEARINGS:** All pulley bearings are precision, heavy duty, lubricated, ball bearing units with cast iron housings.
- ▶ **TAKE-UP:** Screw type unit at tail pulley provides 12" belt take-up.
- ▶ **BELT SPEED:** 60 FPM, constant.
- ▶ **RETURN ROLLERS:** 1.9" dia. x 16 ga. galv. steel, model 196G, adjustable.
- ▶ **ROLLER CHAIN:** Drive pulley is driven by No. 50 roller chain for 1-1/2 HP or less and No. 60 chain on larger drives. Chain take-up provided on motor base.
- ▶ **MOTOR DRIVE:** 1/2 HP, 230/460/3, 60 cycle, Super "E" right angle gear motor.
- ▶ **ELECTRICAL CONTROLS:** Optional.

### WARNING

Prevent pinch points that exist when belt conveyors are permanently attached to other conveyors or equipment!

## SPECIFICATION TABLE

50'-0" lengths and under are equipped with 4" dia. drive pulley; over 50'-0" includes 8" dia. drive pulley

CONVEYOR LENGTH			10'	20'	30'	40'	50'	60'	70'	80'	90'	100'	Deduct
BELT	BF	OAW	UNIT WEIGHTS (lbs.) with 3" Roller Center (For other centers, deduct weights below)										Per Foot
12"	15"	18"	346	564	781	999	1217	1434	1652	1870	2087	2305	22
18"	21"	24"	413	683	953	1223	1493	1764	2034	2304	2574	2845	27
24"	27"	30"	479	802	1125	1447	1770	2093	2416	2739	3062	3384	32
30"	33"	36"	546	921	1296	1672	2047	2422	2798	3173	3549	3924	38
36"	39"	42"	612	1040	1468	1896	2324	2752	3180	3608	4036	4464	43
42"	45"	48"	679	1159	1640	2120	2601	3081	3562	4042	4523	5003	48
48"	51"	54"	745	1278	1811	2344	2877	3411	3944	4477	5010	5543	53

Deduct the following weights (lbs.) for other than 3" centers

Roller Centers	12" BELT		18" BELT		24" BELT		30" BELT		36" BELT		42" BELT		48" BELT	
	Per 5'	Per 10'												
4-1/2"	-15	-30	-20	-40	-25	-50	-30	-60	-35	-70	-40	-80	-45	-90
6"	-30	-60	-40	-80	-50	-100	-60	-120	-70	-140	-80	-160	-90	-180
9"	-42	-78	-56	-104	-70	-130	-84	-156	-98	-182	-112	-208	-99	-234
12"	-45	-90	-60	-120	-75	-150	-90	-180	-105	-210	-120	-240	-135	-270

■ 3 week shipment

## OPTIONAL EQUIPMENT

► **BELTING:** Black PVC ruff-top; PVC-120 white food grade COS; PVC-150 black COS; Consult factory for other belting.

► **CENTER DRIVE:** Reversible drive with integral belt take-up of 24". Specify location. Center drive option available 6'-0" long units & above.

► **SIDE MOUNTED END DRIVE:** Provides minimum conveyor height of 10" TOB (4" dia. drive pulley); 12" TOB (8" dia. drive pulley).

► **OVERHEAD END DRIVE:** Provides minimum conveyor height of 8" TOB (4" dia. drive pulley); 10" TOB (8" dia. drive pulley).

► **AUXILIARY TAKE-UP:** Provides 24" of belt take-up. Specify location. See Power Accessories.

► **SIDE TABLES:** Available in 9", 15" and 21" widths (14 ga.) one or both sides. See Power Accessories.

► **FLOOR SUPPORTS:** Conveyor shown with optional supports. Supports, knee braces, casters and polytier supports available. See Conveyor Accessories.

► **CEILING HANGERS:** 5/8" dia. threaded rod with hardware to attach rods to conveyor. Provides 6' clearance between ceiling and TOB (furnished in place of floor supports). See Conveyor Accessories.

► **UNDERTRUSSED BED:** Available to provide clearance underneath unit at bed joint locations. Specify location for undertrussing and desired clearance underneath unit. Consult factory.

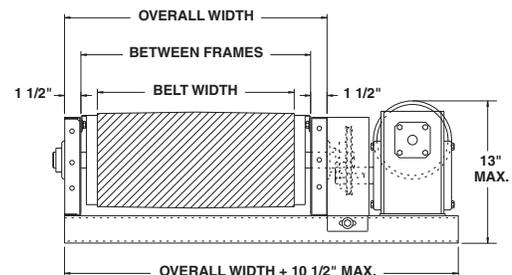
► **BELT SPEED:** Constant speed 10-120 FPM; DC variable speed; AC inverter variable speed. Other constant or variable speeds available. **NOTE:** CAPACITY CHANGES WITH SPEED.

► **MOTORS:** Available through 3 HP in Super "E", explosion proof, dirty duty, brake motor, 115/230/1, 575/3, etc.

► **NOSE-OVER:** Provides smooth transition from incline to horizontal position. Single nose-over adjusts 0-20°; double nose-over adjusts 0-35°. See Power Accessories.

► **GUARD RAILS:** 1-3/4" x 1" formed channel (model GC), adjusts horizontally to 10" wider than belt and vertically to 6" above belt; formed steel fixed (model FSG in 2", 4", 6", 8", 12", and 18" heights; fixed channel (model FC); 1-1/2" angle (model GA1-1/2). See Conveyor Accessories.

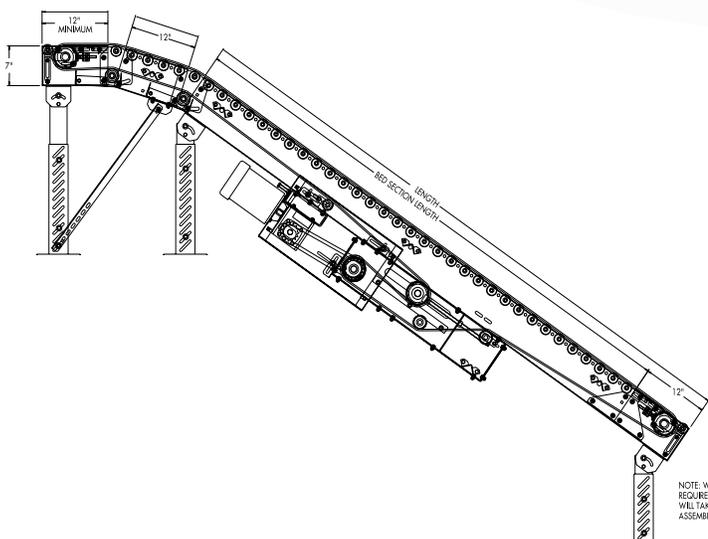
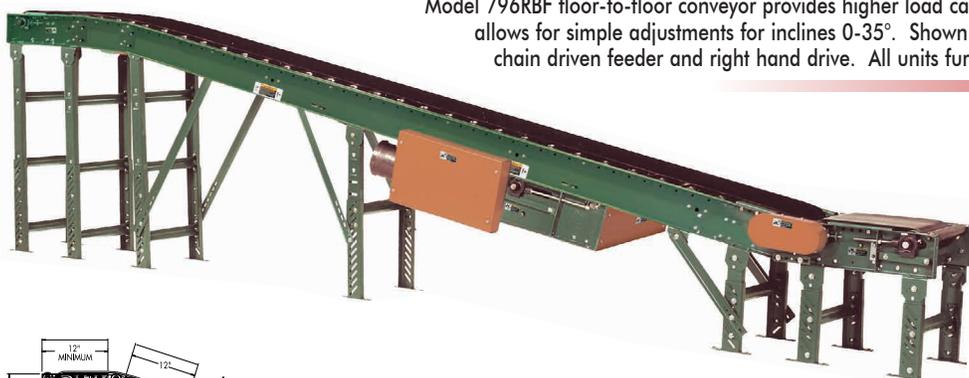
► **ELECTRICAL CONTROLS:** Magnetic starter (one direction or reversible); One direction manual starter; Momentary start/stop push button station; Forward/reversing /stop push button station. Mounting and pre-wiring for units up to 12' long.



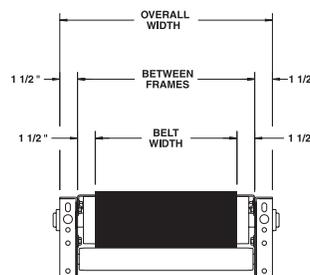
OPTIONAL SIDE MOUNTED DRIVE

## 796RBF | ROLLER BED INCLINED FLOOR-TO-FLOOR BELT CONVEYOR

Model 796RBF floor-to-floor conveyor provides higher load capacity, reversible flow and nose-over allows for simple adjustments for inclines 0-35°. Shown with optional supports, knee braces, chain driven feeder and right hand drive. All units furnished standard with left hand drive.



NOTE: WHEN CHAIN FEEDER IS REQUIRED END DRIVE ASSEMBLY WILL TAKE PLACE OF REED END ASSEMBLY FOR CONNECTION.



HP@ 60 FPM	"A" MAX		"B" MAX	
	4" DRV.	8" DRV.	4" DRV.	8" DRV.
1/2	16-5/8"	17-5/8"	58-5/32"	58-5/32"
3/4	17"	17-5/8"	58-25/32"	58-25/32"
1	17-1/4"	17-5/8"	59-17/32"	59-17/32"
1-1/2	18-1/8"	18-1/8"	61-21/32"	61-21/32"
2	19"	19"	62-21/32"	62-21/32"

### SPECIFICATIONS

- ▶ **BELTING:** Black PVC ruff-top.
- ▶ **CARRIER ROLLERS:** 1.9" dia. X 16 ga. steel, model 196G.
- ▶ **DRIVE PULLEY:** 8" dia. with 1-7/16" dia. shaft, both machine crowned and fully lagged.
- ▶ **TAIL PULLEY:** 4" dia., machine crowned, with 1-3/16" dia. shaft.
- ▶ **RETURN ROLLERS:** 1.9" dia. x 16 ga. galv. steel, model 196G, adjustable.
- ▶ **CENTER DRIVE:** Reversible drive with 24" integral belt take-up.
- ▶ **SAFETY POP-OUT ROLLER:** Standard on both ends, 1.9" dia. x 16 ga. galv. steel roller, model 196G.
- ▶ **BELT SPEED:** 60 FPM, constant.

- ▶ **BED:** 7" x 1-1/2" x 12 ga. channel frame. Bed sections attached with couplings and floor supports.
- ▶ **NOSE-OVER:** Provides smooth transition from incline to horizontal position. Single nose-over adjusts 0-20°; double nose-over adjusts 0-35° (specify single or double).
- ▶ **BEARINGS:** All pulley bearings are precision, heavy duty, lubricated, ball bearing units with cast iron housings.
- ▶ **MOTOR DRIVE:** 1/2 HP, 230/460/3, 60 cycle, Super "E" right angle gear motor.

- ▶ **ROLLER CHAIN:** Drive pulley is driven by No. 50 roller chain for 1-1/2 HP or less and No. 60 chain on larger drives. Chain take-up provided on motor base.
- ▶ **FLOOR SUPPORTS:** Optional.
- ▶ **ELECTRICAL CONTROLS:** Optional.

### **⚠ WARNING**

Prevent pinch points that exist when belt conveyors are permanently attached to other conveyors or equipment!

SPECIFICATION TABLE

CONVEYOR LENGTH			10'	20'	30'	40'	50'	Deduct
BELT	BF	OAW	Unit weights (lbs.) with 6" roller centers (For other centers, deduct weights below)					Per Foot
12"	15"	18"	730	930	1130	1331	1531	22
18"	21"	24"	857	1111	1364	1618	1872	27
24"	27"	30"	983	1291	1598	1906	2213	32
30"	33"	36"	1110	1471	1832	2194	2555	38
36"	39"	42"	1237	1652	2066	2481	2896	43
42"	45"	48"	1363	1832	2300	2769	3238	48
48"	51"	54"	1234	1776	2319	2861	3403	54

Deduct the following weights (lbs.) for other than 6" centers

Roller Centers	12" BELT		18" BELT		24" BELT		30" BELT		36" BELT		42" BELT		48" BELT	
	Per 5'	Per 10'												
9"	-9	-18	-12	-24	-15	-30	-18	-36	-21	-42	-24	-48	-27	-54
12"	-15	-30	-20	-40	-25	-50	-30	-60	-35	-75	-40	-80	-45	-90

■ 3 week shipment

OPTIONAL EQUIPMENT

► **BELTING:** Consult factory for other belting.

► **SIDE MOUNTED END DRIVE:** Available as option when necessary to move center drive for unit clearance. Minimum horizontal nose-over length required is 3' (2' horizontal may be used if product does not overhang conveyor OAW).

► **192S CARRIER ROLLERS:** 1.9" dia. x 12 ga. steel carrier rollers, model 192S, available in model 792RBF.

► **UNDERTRUSSED BED:** Available to provide clearance underneath unit at bed joint locations. Specify location for undertrussing and desired clearance underneath unit. Consult factory.

► **FLOOR SUPPORTS:** Conveyor shown with optional supports. Various height adjustable supports and knee braces available. See Conveyor Accessories.

► **POWERED FEEDER:** Integral belt feeder or separate chain driven belt feeder.

► **CEILING HANGERS:** 5/8" dia. threaded rod w/ hardware to attach rods (specify rod length) to conveyor. See Conveyor Accessories.

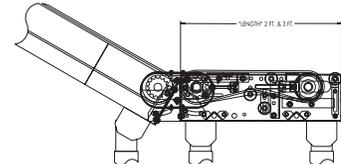
► **GUARD RAILS:** 1-3/4" x 1" formed channel (model GC), adjusts horizontally to 10" wider than belt and vertically to 6" above belt; formed steel fixed (model FSG in 2", 4", 6", 8", 12", and 18" heights. See Conveyor Accessories.

► **BELT SPEED:** Constant speed 3-120 FPM; DC variable speed; AC inverter variable speed. Other constant or variable speeds available. **NOTE: CAPACITY CHANGES WITH SPEED.**

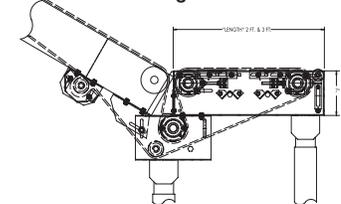
► **MOTORS:** Available through 3 HP in Super "E", explosion proof, dirty duty, brake motor, 115/230/1, 575/3, etc.

► **ELECTRICAL CONTROLS:** Magnetic starter (one direction or reversible); One direction manual starter; Momentary start/stop push button station; Forward/reversing/stop push button station.

Chain Feeder



Integral Feeder



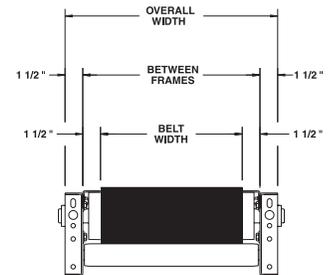
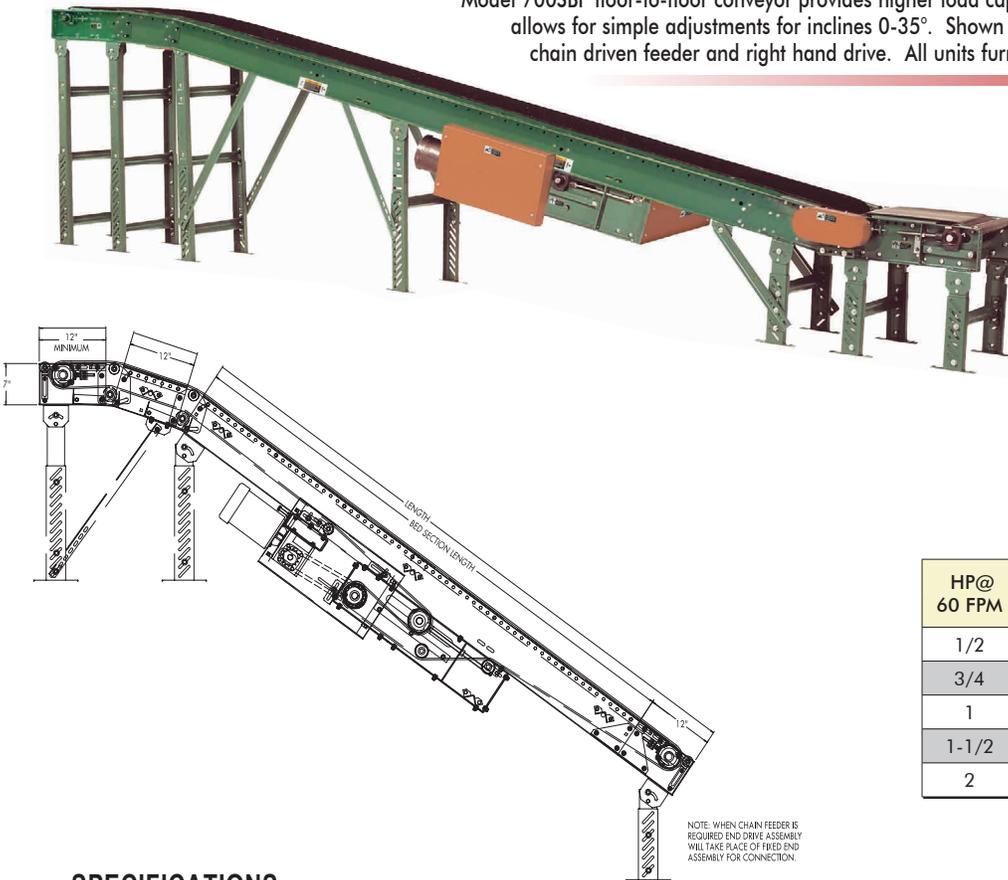
OPTIONAL CHAIN DRIVEN FEEDER



OPTIONAL INTEGRAL FEEDER

## 700SBF | SLIDER BED INCLINED FLOOR-TO-FLOOR BELT CONVEYOR

Model 700SBF floor-to-floor conveyor provides higher load capacity, reversible flow and nose-over allows for simple adjustments for inclines 0-35°. Shown with optional supports, knee braces, chain driven feeder and right hand drive. All units furnished standard with left hand drive.



HP@ 60 FPM	"A" MAX		"B" MAX	
	4" DRV.	8" DRV.	4" DRV.	8" DRV.
1/2	16-5/8"	17-5/8"	58-5/32"	58-5/32"
3/4	17"	17-5/8"	58-25/32"	58-25/32"
1	17-1/4"	17-5/8"	59-17/32"	59-17/32"
1-1/2	18-1/8"	18-1/8"	61-21/32"	61-21/32"
2	19"	19"	62-21/32"	62-21/32"

### SPECIFICATIONS

- ▶ **BELTING:** Black PVC ruff-top.
- ▶ **DRIVE PULLEY:** 8" dia. with 1-7/16" dia. shaft, both machine crowned and fully lagged.
- ▶ **TAIL PULLEY:** 4" dia., machine crowned, with 1-3/16" dia. shaft.
- ▶ **RETURN ROLLERS:** 1.9" dia. x 16 ga. galv. steel, model 196G, adjustable.
- ▶ **CENTER DRIVE:** Reversible drive with 24" integral belt take-up.
- ▶ **BELT SPEED:** 60 FPM, constant.
- ▶ **SAFETY POP-OUT ROLLER:** Standard on both ends, 1.9" dia. x 16 ga. galv. steel roller, model 196G.

- ▶ **NOSE-OVER:** Provides smooth transition from incline to horizontal position. Single nose-over adjusts 0-20°; double nose-over adjusts 0-35° (specify single or double).
- ▶ **BEARINGS:** All pulley bearings are precision, heavy duty, lubricated, ball bearing units with cast iron housings.
- ▶ **BED:** 7" x 1-1/2" x 12 ga. channel frame with 14 ga. slider bed 9"-39" BF; 12 ga. slider bed 45" & 51" BF.

- ▶ **ROLLER CHAIN:** Drive pulley is driven by No. 50 roller chain for 1-1/2 HP or less and No. 60 chain on larger drives. Chain take-up provided on motor base.
- ▶ **MOTOR DRIVE:** 1/2 HP, 230/460/3, 60 cycle, Super "E" right angle gear motor.
- ▶ **FLOOR SUPPORTS:** Optional.
- ▶ **ELECTRICAL CONTROLS:** Optional.

### ⚠ WARNING

Prevent pinch points that exist when belt conveyors are permanently attached to other conveyors or equipment!

SPECIFICATION TABLE

CONVEYOR LENGTH			10'	20'	30'	40'	50'	Deduct
BELT	BF	OAW	Units weights (lbs.)					Per Foot
6"	9"	12"	392	506	621	735	849	11
12"	15"	18"	501	657	813	969	1125	16
18"	21"	24"	610	808	1006	1204	1402	20
24"	27"	30"	719	959	1199	1438	1678	24
30"	33"	36"	828	1110	1391	1673	1955	28
36"	39"	42'	937	1261	1584	1908	2231	32

■ 3 week shipment

OPTIONAL EQUIPMENT

► **BELTING:** Consult factory for other belting.

► **SIDE MOUNTED END DRIVE:** Available as option when necessary to move center drive for unit clearance. Minimum horizontal nose-over length required is 3' (2' horizontal may be used if product does not overhang conveyor OAW).

► **BED:** Available in boxed slider bed.

► **UNDERTRUSSED BED:** Available to provide clearance underneath unit at bed joint locations. Specify location for undertrussing and desired clearance underneath unit. Consult factory.

► **FLOOR SUPPORTS:** Conveyor shown with optional supports. Various height adjustable supports and knee braces available. See Conveyor Accessories.

► **POWERED FEEDER:** Integral belt feeder or separate chain driven belt feeder.

► **MOTORS:** Available through 3 HP in Super "E", explosion proof, dirty duty, brake motor, 115/230/1, 575/3, etc.

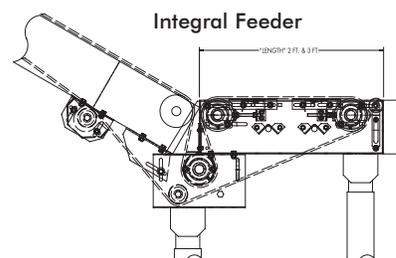
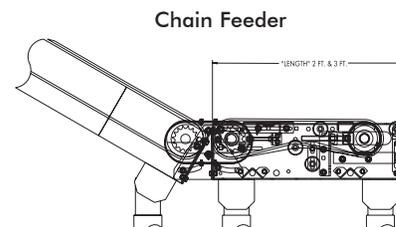
► **CEILING HANGERS:** 5/8" dia. threaded rod w/ hardware to attach rods (specify rod length) to conveyor. See Conveyor Accessories.

► **GUARD RAILS:** 1-3/4" x 1" formed channel (model GC), adjusts horizontally to 10" wider than belt and vertically to 6" above belt; formed steel fixed (model FSG in 2", 4", 6", 8", 12", and 18" heights. See Conveyor Accessories.

► **BELT SPEED:** Constant speed 3-120 FPM; DC variable speed; AC inverter variable speed. Other constant or variable speeds available.

**NOTE:** CAPACITY CHANGES WITH SPEED.

► **ELECTRICAL CONTROLS:** Magnetic starter (one direction or reversible); One direction manual starter; Momentary start/stop push button station; Forward/reversing/stop push button station.



OPTIONAL CHAIN DRIVEN FEEDER

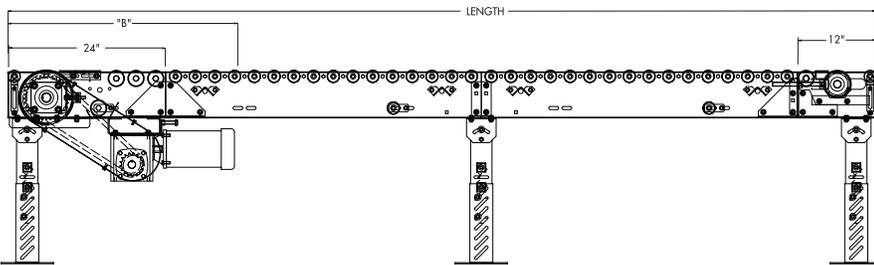
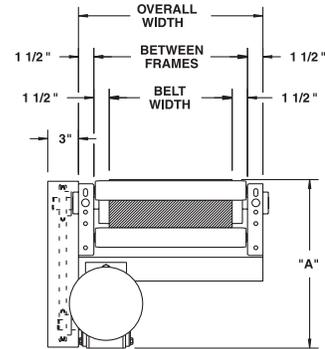


OPTIONAL INTEGRAL FEEDER

## 751RB | HEAVY DUTY ROLLER BED BELT CONVEYOR



Roach 751RB is the choice for heavier unit loads. The heavy duty roller bed construction makes model 751RB ideal for transporting heavy loads with low power requirements.



HP@ 60 FPM	"A" MAX	"B" MAX
	8" DRV.	8" DRV.
1	17-1/4"	34-15/32"
1-1/2"	18-1/8"	37-3/32"
2	19"	38-3/32"
3	19-1/2"	39-9/32"

### SPECIFICATIONS

- ▶ **BELTING:** PVC-120 black.
- ▶ **CARRIER ROLLERS:** 2-1/2" dia. x 11 ga. steel, model 251S.
- ▶ **DRIVE PULLEY:** 8" dia. with 1-7/16" dia. shaft on 15"-39" BF; 12" dia. with 1-15/16" dia. shaft above 39" BF; both machine crowned and fully lagged.
- ▶ **TAIL PULLEY:** 4" dia. with 1-3/16" dia. shaft on 15"-39" BF; 6" dia. with 1-7/16" dia. shaft above 39" BF; both machine crowned.
- ▶ **RETURN ROLLERS:** 1.9" dia. x 16 ga. steel, model 196G, adjustable.
- ▶ **BELT SPEED:** 35 FPM, constant.
- ▶ **END DRIVE:** Allows one-direction (unit) operation; add optional center drive for reversible application.
- ▶ **TAKE-UP:** Screw type unit at tail pulley provides 12" belt take-up.
- ▶ **BEARINGS:** All pulley bearings are precision, heavy duty, lubricated, ball bearing units with cast iron housings.
- ▶ **BED:** 7" x 1-1/2" x 10 ga. channel frame. Bed sections attach with couplings and floor supports.
- ▶ **SAFETY POP-OUT ROLLERS:** Standard on both ends, 1.9" x 12 ga. steel, model 192S on 15"-39" BF, 1.9" x 9 ga. steel, model 199S on 45"-57" BF.
- ▶ **SQUARING RODS:** Adjustable rods on underside of bed allow frame to be squared for improved belt tracking and are standard on all units over 30'.

- ▶ **ROLLER CHAIN:** Drive pulley is driven by No. 50 roller chain for 1-1/2 HP or less and No. 60 chain on larger drives. Chain take-up provided on motor base.
- ▶ **MOTOR DRIVE:** 1 HP, 230/460/3, 60 cycle, Super "E" right angle gear motor.
- ▶ **ELECTRICAL CONTROLS:** Optional.

### ⚠ WARNING

Prevent pinch points that exist when belt conveyors are permanently attached to other conveyors or equipment!

SPECIFICATION TABLE

■ 3 week shipment

CONVEYOR LENGTH			10'	20'	30'	40'	50'	60'	70'	80'	90'	100'	Deduct
BF	OAW	BELT	UNIT WEIGHTS (lbs.) with 6" Roller Centers (For other centers, deduct weights below)										Per Foot
15"	18"	12"	499	892	1285	1677	2070	2463	2856	3248	3641	4034	39
21"	24"	18"	619	1104	1588	2073	2557	3042	3526	4011	4495	4980	49
27"	30"	24"	739	1315	1892	2468	3044	3620	4197	4773	5349	5925	57
33"	36"	30"	859	1527	2193	2863	3531	4199	4867	5535	6203	6871	67
39"	42"	36"	979	1739	2499	3258	4018	4778	5538	6297	7057	7817	76
45"	48"	42"	1099	1951	2802	3654	4505	5357	6208	7060	7911	8763	85
51"	54"	48"	1219	2162	3106	4049	4992	5935	6879	7822	8765	9708	94
57"	60"	54"	1339	2374	3409	4444	5479	6514	7549	8584	9619	10654	104

Deduct the following weights (lbs.) for other than 3" centers

Roller Centers	15" BF	21" BF	27" BF	33" BF	39" BF	45" BF	51" BF	57" BF
	Per 10'							
4-1/2"	-72	-90	-112	-136	-158	-178	-200	-220
6"	-144	-180	-224	-272	-316	-356	-400	-440
9"	-186	-234	-300	-354	-410	-464	-518	-572
12"	-216	-270	-336	-408	-474	-534	-600	-660

OPTIONAL EQUIPMENT

► **BELTING:** Black PVC ruff-top; PVC-120 white food grade COS; PVC-150 black COS; Consult factory for other belting.

► **CENTER DRIVE:** Reversible drive with integral belt take-up of 24". Specify location. Center drive option available on units 6'-0" long and above.

► **SIDE MOUNTED END DRIVE:** Provides minimum conveyor height of 12" TOB (8" dia. drive pulley); 16" TOB (12" dia. drive pulley).

► **OVERHEAD END DRIVE:** Provides minimum conveyor height of 12" TOB (8" dia. drive pulley); 16" TOB (12" dia. drive pulley).

► **AUXILIARY TAKE-UP:** Provides 24" of belt take-up. Specify location. See Power Accessories.

► **FLOOR SUPPORTS:** Conveyor shown with optional supports. Supports, knee braces, casters and polytief supports available. See Conveyor Accessories.

► **GUARD RAILS:** HFSG in 2", 4" and 6" heights; 1-1/2" angle (model HGA1-1/2). See Conveyor Accessories.

► **NOSE-OVER:** Provides smooth transition from incline to horizontal position. Consult factory.

► **SIDE TABLES:** Available in 9", 15" and 21" widths. Consult factory.

► **BELT SPEED:** Constant speed 12-120 FPM; DC variable speed; AC inverter variable speed. Other constant or variable speeds available.

**NOTE:** CAPACITY CHANGES WITH SPEED.

► **CEILING HANGERS:** Heavy duty with hardware to attach rods to conveyor. Consult factory.

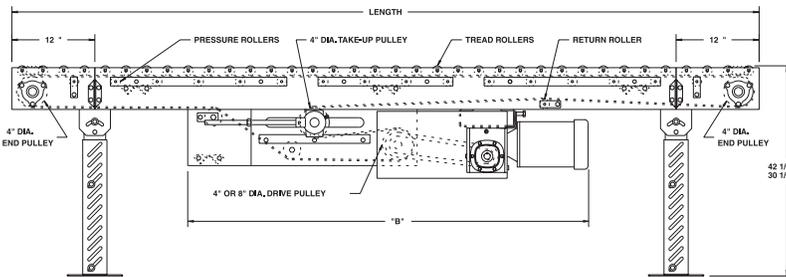
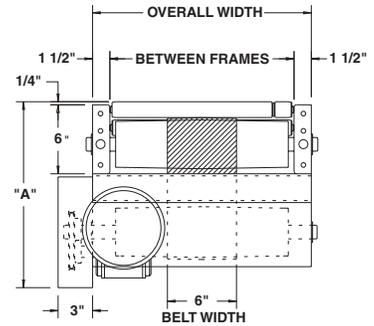
► **MOTORS:** Available through 3 HP in Super "E", explosion proof, dirty duty, brake motor, 115/230/1, 575/3, etc.

► **ELECTRICAL CONTROLS:** Magnetic starter (one direction or reversible); One direction manual starter; Momentary start/stop push button station; Forward/reversing /stop push button station. Mounting and pre-wiring for units up to 12' long.

## 638CALR | LIGHT DUTY BELT DRIVEN LIVE ROLLER



638CALR is ideally suited for horizontal conveying of items where transfers, side loading or unloading, or temporary accumulation is required in light duty applications or when small items are conveyed requiring close standard roller spacing.



HP@ 60 FPM	"A" MAX		"B" MAX	
	4" DRV.	8" DRV.	4" DRV.	8" DRV.
1/2	15-5/8"	16-5/8"	58-5/32"	58-5/32"
3/4	16"	16-5/8"	58-25/32"	58-25/32"
1	16-1/4"	16-5/8"	59-17/32"	59-17/32"
1-1/2	17-1/8"	17-1/8"	61-21/32"	61-21/32"
2	18"	18"	62-21/32"	62-21/32"

### SPECIFICATIONS

- ▶ **TREAD ROLLERS:** 1-3/8" dia. x 18 ga. galv. steel steel, model 138G with 5/16" hex.
- ▶ **PRESSURE ROLLERS:** 1-3/8" dia. x 18 ga. galv. steel, model 138G with 5/16" hex.
- ▶ **RETURN ROLLERS:** 1-3/8" dia. x 18 ga. galv. steel, model 138G with 5/16" hex, adjustable.
- ▶ **BELTING:** 6" wide black PVC-120 COS.
- ▶ **CENTER DRIVE:** Reversible drive w/ 24" integral belt take-up. Specify location.
- ▶ **DRIVE PULLEY:** 4" dia. with 1-3/16" dia. shaft or 8" dia. with 1-7/16" dia. shaft; both crowned and fully lagged.
- ▶ **END PULLEY:** 4" dia., crowned, with 1-3/16" dia. shaft.
- ▶ **SPEED:** 60 FPM, constant.
- ▶ **BED:** 6" x 1-1/2" x 12 ga. channel frame slotted for tread rollers to pop-out. When unit is installed at 7'-0" elevation or higher, rollers must be retained in conveyor frame. Specify desired elevation. Bed sections attached with couplings and floor supports.
- ▶ **SQUARING RODS:** Adjustable rods on underside of bed allow frame to be squared for improved belt tracking and are standard on all units over 30'.
- ▶ **MOTOR DRIVE:** 1/2 HP, 230/460/3, 60 cycle, Super "E" right angle gear motor.
- ▶ **BEARINGS:** All pulley bearings are precision, heavy duty, lubricated, ball bearing units with cast iron housings.
- ▶ **ROLLER CHAIN:** Drive pulley is driven by No. 50 chain for 1-1/2 HP or less and No. 60 chain on larger drives. Chain take-up provided on motor base.
- ▶ **ELECTRICAL CONTROLS:** Optional.

### ⚠ WARNING

Pop-out rollers should be retained in frame if unit is elevated to 7'-0" and above.

## SPECIFICATION TABLE

50'-0" lengths and under are equipped with 4" dia. drive pulley; over 50'-0" will have an 8" dia. drive pulley

CONVEYOR LENGTH			10'	20'	30'	40'	50'	60'	70'	80'	90'	100'	Deduct
BF	OAW	BELT	UNIT WEIGHTS (lbs.) with 1-1/2" Roller Center (For other centers, deduct weights below)										Per Foot
10"	13"	2-1/4"	403	614	825	1036	1247	1458	1669	1880	2091	2302	21
16"	19"	2-1/4"	502	776	1051	1325	1599	1874	2148	2422	2697	2971	27
22"	25"	2-1/4"	601	939	1276	1614	1952	2289	2627	2965	3302	3640	34

Deduct the following weights (lbs.) for other than 1-1/2" centers

CONVEYOR LENGTH		6'	10'	15'	20'	25'	30'	40'	50'	60'	70'	80'	90'	100'
BF	Roller Centers													
10"	3"	-36	-60	-90	-120	-150	-180	-240	-300	-360	-420	-480	-540	-600
16"	3"	-54	-90	-135	-180	-225	-270	-360	-450	-540	-630	-720	-810	-900
22"	3"	-72	-120	-180	-240	-300	-360	-480	-600	-720	-840	-960	-1080	-1200
10"	4-1/2"	-48	-80	-120	-160	-200	-240	-320	-400	-480	-560	-640	-720	-800
16"	4-1/2"	-72	-120	-180	-240	-300	-360	-480	-600	-720	-840	-960	-1080	-1200
22"	4-1/2"	-96	-160	-240	-320	-400	-480	-640	-800	-960	-1120	-1280	-1440	-1600

■ 3 week shipment

## OPTIONAL EQUIPMENT

► **BELTING:** 6" wide black PVC-150; 12" wide PVC-120.

► **END DRIVE:** Mounted underneath conveyor. Minimum possible height is 20" TOR for underneath mounted end drive. Belt take-up required for end drive (if substituting end drive for center drive).

► **SIDE MOUNTED END DRIVE:** Provides overall conveyor height of 9".

► **AUXILIARY TAKE-UP:** Provides 24" of belt take-up. Specify location. See Power Accessories.

► **FLOOR SUPPORTS:** Conveyor shown with optional supports. Supports, knee braces, casters and polytyer supports available. See Conveyor Accessories.

► **CEILING HANGERS:** 5/8" dia. threaded rod with hardware to attach rods to conveyor. Provides 6' clearance between ceiling and TOR (furnished in place of floor supports). See Conveyor Accessories.

► **MOTORS:** Available through 3 HP in Super "E", explosion proof, dirty duty, brake motor, 115/230/1, 575/3, etc.

► **SPEED:** Constant speed 3-120 FPM; DC variable speed; AC inverter variable speed. Other constant or variable speeds available.

**NOTE:** CAPACITY CHANGES WITH SPEED.

► **GUARD RAILS:** 1-3/4" x 1" formed channel (model GC), adjusts horizontally to 8" wider than roller and vertically to 6" above roller; formed steel fixed (model FSG in 2", 4" and 6" heights; fixed channel (model FC); 1-1/2" angle (model GA1-1/2). See Conveyor Accessories.

► **ELECTRICAL CONTROLS:** Magnetic starter (one direction or reversible); One direction manual starter; Momentary start/stop push button station; For-ward/reversing /stop push button station. Mounting and pre-wiring for units up to 12' long.

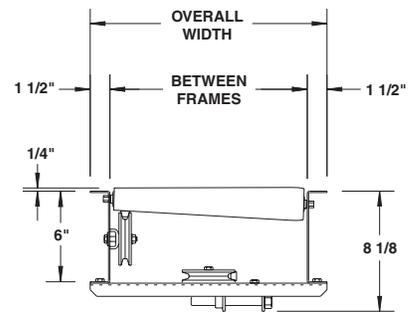


POP-OUT ROLLERS (some rollers raised for clarity)

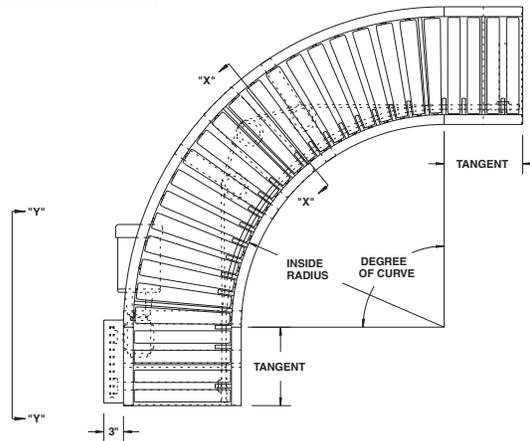
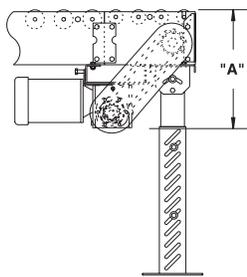
## 138LRC | LIGHT DUTY BELT DRIVEN LIVE ROLLER CURVE



Model 138LRC features tapered rollers to maintain product orientation. Reversible, it is also commonly slave driven from 138LR making it the ideal curve in light duty applications.



HP@60 FPM	"A" MAX
1/2	15-5/8"
3/4	16"
1	16-1/4"
1-1/2	17-1/8"
2	18"



### SPECIFICATIONS

- ▶ **TREAD ROLLERS:** 1.9" dia. to 1-3/8" dia. x 16 ga. tapered rollers, model 138T; 1-3/8" dia. x 18 ga., model 138G w/ 5/16" hex, galv. steel straight tangent rollers.
- ▶ **ROLLER CENTERS:** 1-9/16" measured at inside radius of unit.
- ▶ **PRESSURE SHEAVES:** Provides drive belt pressure to upper tread rollers.
- ▶ **BELT:** "B" section V-belt.
- ▶ **TAKE-UP:** Screw type adjustable sheave with flat idler sheaves to maintain belt tension.
- ▶ **TANGENTS:** 12" both ends on 90° unit; 18" both ends on 45° unit.
- ▶ **BED:** 6" x 1-1/2" x 12 ga. formed steel channel frame.
- ▶ **SPEED:** 60 FPM, constant.
- ▶ **BEARINGS:** End shafts are supported by precision, heavy duty, lubricated, ball bearing units with cast iron housings.

- ▶ **ROLLER CHAIN:** Drive shaft is driven by No. 50 chain.
- ▶ **MOTOR DRIVE:** 1/2 HP, 230/460/3, 60 cycle, Super "E" right angle gear motor, located at infeed end of curve below bed.
- ▶ **DRIVE LOCATION:** Drive located on outside of curve. Specify left hand tangent length, right hand tangent length and drive location ("left hand drive" or "right hand drive"). NOTE: Drive hand determined with reference point located at outside of curve. For models slave driven (less drive), specify drive shaft location. See "determining drive location" on page 24.
- ▶ **CAPACITY:** 300 lb. total distributed live load.

### OPTIONAL EQUIPMENT

**SPECIAL WIDTHS:** Consult factory for pricing of ALL widths not shown.

**GUARD RAILS:** See Conveyor Accessories for various type guard rails available.

**FLOOR SUPPORTS:** Conveyor Shown with optional supports. See Conveyor Accessories for various elevation and types.

**TANGENTS:** Lengths other than listed available. Combined total length must not exceed 6'-0".

**BELT SPEED:** Constant speed 10-120 FPM; AC & DC variable speed. Other constant or variable speeds available. NOTE: CAPACITY CHANGES WITH SPEED.

**MOTORS:** Available through 2 HP in TEFC, ex. proof, dirty duty, brake motor, 115/230/1, 575/3, etc.

**ELECTRICAL CONTROLS:** Magnetic & manual starters; push buttons, etc.

WEIGHTS (lbs.)				
BF	OAW	Inside Radius	90°	45°
10"	13"	2'-8-1/2"	317	309
16"	19"	2'-8-1/2"	362	350
22"	25"	2'-8-1/2"	407	388

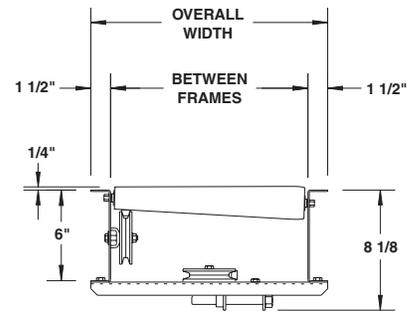
NOTE: This unit is not recommended for accumulating loads.

■ 3 week shipment

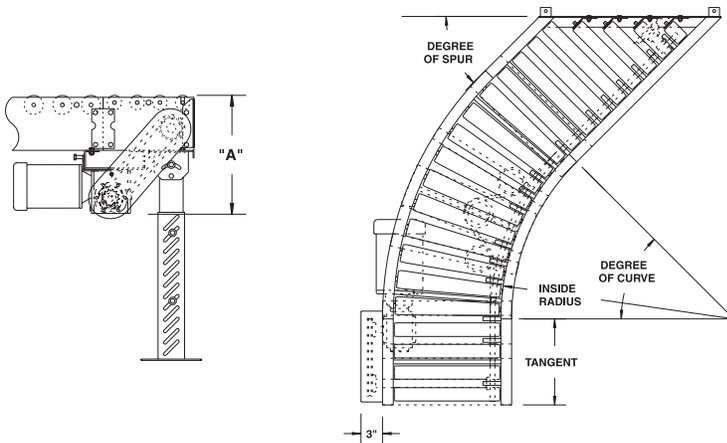
# 138LRCS | LIGHT DUTY BELT DRIVEN LIVE ROLLER CURVE SPUR



For product diversion to spur line or for merging, model 138LRCS is ideal in light duty applications.



HP@60 FPM	"A" MAX
1/2	15-5/8"
3/4	16"
1	16-1/4"
1-1/2	17-1/8"
2	18"



## SPECIFICATIONS

- ▶ **TREAD ROLLERS:** 1.9" dia. to 1-3/8" dia. x 16 ga. tapered rollers, model 138T; 1-3/8" dia. x 18 ga., model 138G w/ 5/16" hex, galv. steel straight tangent rollers.
- ▶ **ROLLER CENTERS:** 1-9/16" measured at inside radius of unit.
- ▶ **PRESSURE SHEAVES:** Provides drive belt pressure to upper tread rollers.
- ▶ **BELT:** "B" section V-belt.
- ▶ **TAKE-UP:** Screw type adjustable sheave with flat idler sheaves provided to maintain belt tension.
- ▶ **TANGENTS:** 12" opposite spur end on 60°/30° unit; 18" opposite spur end on 45°/45° unit.
- ▶ **SPEED:** 60 FPM, constant.
- ▶ **BEARINGS:** End shafts are supported by precision, heavy duty, lubricated, ball bearing units with cast iron housings.

- ▶ **BED:** 6" x 1-1/2" x 12 ga. formed steel channel frame.
- ▶ **ROLLER CHAIN:** Drive shaft is driven by No. 50 chain.
- ▶ **MOTOR DRIVE:** 1/2 HP, 230/460/3, 60 cycle, Super "E" right angle gear motor, located under tangent straight section bed.
- ▶ **SPUR HAND/DRIVE LOCATION:** Drive located on outside of curve. Specify hand of spur as "left hand" or "right hand" and location of drive specified as "left hand drive" or "right hand drive". Drive location determined with reference point located at outside of curve (see "determining drive location" on pg. 24). For models slave driven (less drive), specify drive shaft location.
- ▶ **CAPACITY:** 300 lb. total distributed live load.

## OPTIONAL EQUIPMENT

**SPECIAL WIDTHS:** Consult factory for pricing of ALL widths not shown.

**GUARD RAILS:** See Conveyor Accessories for various type guard rails available.

**FLOOR SUPPORTS:** Conveyor Shown with optional supports. See Conveyor Accessories for various elevation and types.

**TANGENTS:** Lengths other than listed available. Combined total length must not exceed 3'-0".

**BELT SPEED:** Constant speed 10-120 FPM; AC & DC variable speed. Other constant or variable speeds available. **NOTE: CAPACITY CHANGES WITH SPEED.**

**MOTORS:** Available through 2 HP in TEFC, ex. proof, dirty duty, brake motor, 115/230/1, 575/3, etc.

**ELECTRICAL CONTROLS:** Magnetic & manual starters; push buttons, etc.

WEIGHTS (lbs.)				
BF	OAW	Inside Radius	45°/45°	60°/30°
10"	13"	2'-8-1/2"	384	393
16"	19"	2'-8-1/2"	453	492
22"	25"	2'-8-1/2"	528	588

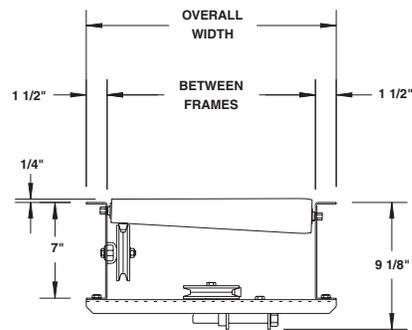
NOTE: This unit is not recommended for accumulating loads.

■ 3 week shipment

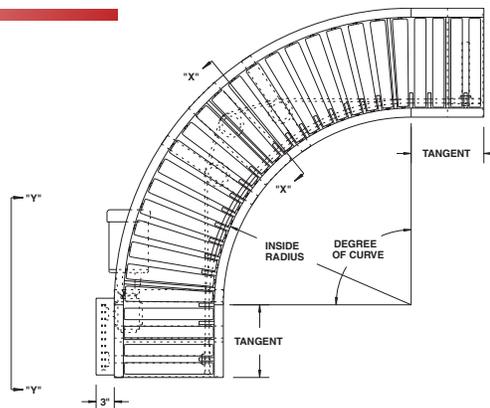
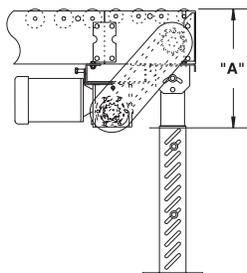
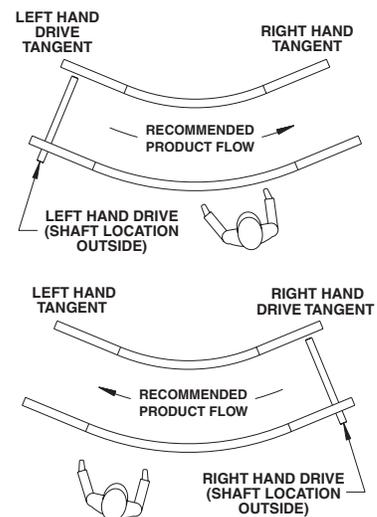
# 196LRC | MEDIUM DUTY BELT DRIVEN LIVE ROLLER CURVE



Roach model 196LRC features tapered rollers to maintain product orientation. Reversible, it is also commonly slave driven from 796CALR conveyors.



### DETERMINING DRIVE LOCATION



### SPECIFICATIONS

- ▶ **TREAD ROLLERS:** 2-1/2" dia. to 1-11/16" dia. x 14 ga. steel tapered rollers, model 254T; 1.9" dia. x 16 ga. galv. steel straight tangent rollers, model 196G.
- ▶ **PRESSURE SHEAVES:** Provides drive belt pressure to upper tread rollers.
- ▶ **BELT:** "B" section V-belt.
- ▶ **TAKE-UP:** Screw type adjustable sheaves provided to maintain belt tension.
- ▶ **TANGENTS:** 1'-0" both ends on 90°; 1'-6" both ends on 45°; 1'-0" both ends on 180°. Tangent roller centers provided on 3" RC.
- ▶ **SPEED:** 60 FPM, constant.
- ▶ **BED:** 7" x 1-1/2" x 12 ga. formed steel channel frame.

- ▶ **BEARINGS:** End shafts are supported by precision, heavy duty, lubricated, ball bearing units with cast iron housings.
- ▶ **ROLLER CHAIN:** Drive shaft is driven by No. 50 chain.
- ▶ **DRIVE LOCATION:** Drive located on outside of curve. Specify left hand tangent length, right hand tangent length and drive location ("left hand drive" or "right hand drive"). NOTE: Drive hand determined with reference point located at outside of curve. For models slave driven (less drive), specify drive shaft location.
- ▶ **CAPACITY:** 500 lb. total distributed live load.

- ▶ **MOTOR DRIVE:** 1/2 HP, 230/460/3, 60 cycle, Super "E" right angle gear motor, located at infeed end of curve below bed on 45° and 90° curves; 3/4 HP supplied on all 180° curves.

- ▶ **SPECIAL WIDTHS:** Consult factory for pricing of ALL widths not shown.

- ▶ **ELECTRICAL CONTROLS:** Optional.

HP@60 FPM	"A" MAX
1/2	16-5/8"
3/4	17"
1	17-1/4"
1-1/2	18-1/8"
2	19"

NOTE: This unit is not recommended for accumulating loads.

## SPECIFICATION TABLE

MODEL			196LRC - 180°			196-LRC - 90°			196LRC - 45°		
BF	OAW	INSIDE RADIUS	TAPERED ROLLERS	STRAIGHT ROLLERS	WT.	TAPERED ROLLERS	STRAIGHT ROLLERS	WT.	TAPERED ROLLERS	STRAIGHT ROLLERS	WT.
13"	16"	2'-8-1/2'	40	8	298	20	8	207	10	12	161
15"	18"	2'-8-1/2'	40	8	341	20	8	231	10	12	176
17"	20"	2'-8-1/2'	40	8	383	20	8	255	10	12	190
19"	22"	2'-8-1/2'	40	8	426	20	8	279	10	12	205
21"	24"	2'-8-1/2'	40	8	468	20	8	303	10	12	220
23"	26"	2'-8-1/2'	40	8	511	20	8	327	10	12	234
25"	28"	2'-8-1/2'	40	8	553	20	8	351	10	12	249
27"	30"	2'-8-1/2'	40	8	596	20	8	374	10	12	264
31"	34"	4'-0"	56	8	681	28	8	422	14	12	293
33"	36"	4'-0"	56	8	723	28	8	446	14	12	308
37"	40"	4'-0"	56	8	808	28	8	494	14	12	337
39"	42"	4'-0"	56	8	851	28	8	518	14	12	352

■ 3 week shipment

### OPTIONAL EQUIPMENT

► **SIDE MOUNTED END DRIVE:** Provides minimum overall conveyor height of 10".

► **DRIVE:** Located on inside radius of curve.

► **SPEED:** Constant speed 10-120 FPM; DC variable speed; AC inverter variable speed. Other constant or variable speeds available.

► **FLOOR SUPPORTS:** Conveyor shown with optional supports. See Conveyor Accessories for various elevation and types.

► **CEILING HANGERS:** 5/8" dia. threaded rod with hardware to attach rods to conveyor. Provides 6' clearance between ceiling and TOR (furnished in place of floor supports). See Conveyor Accessories.

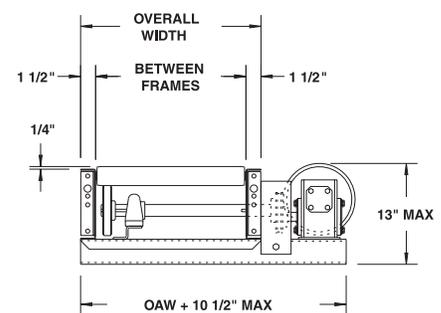
► **TANGENT LENGTHS:** 1'-6", 2'-0", 2'-6", 3'-0", 3'-6", 4'-0", 4'-6" and 5'-0" tangent lengths available on 45° and 90°. Total combined length of tangents not to exceed 6'-0".

► **GUARD RAILS:** 1-3/4" x 1" formed channel (model GC), adjusts horizontally to 8" wider than roller and vertically to 6" above roller; formed steel fixed (model FSG in 2", 4", 6", 8", 12" and 18" heights; 1-1/2" angle (model GA1-1/2). See Conveyor Accessories.

► **MOTORS:** Available through 3 HP in Super "E", explosion proof, dirty duty, brake motor, 115/230/1, 575/3, etc.

► **ELECTRICAL CONTROLS:** Magnetic starter (one direction or reversible); One direction manual starter; Momentary start/stop push button station; Forward/reversing/stop push button station.

OPTIONAL SIDE MOUNTED END DRIVE



UNDERNEATH MOUNTED DRIVE

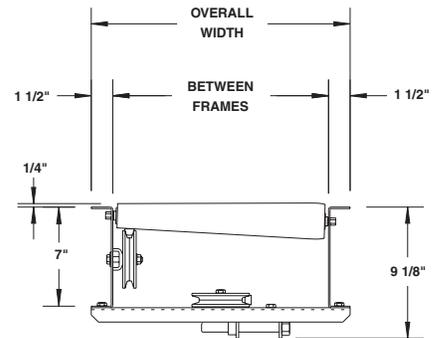


STRAIGHT TANGENT (located both ends of curve)

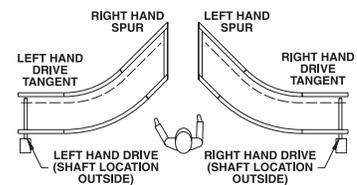
# 196LRCS | MEDIUM DUTY BELT DRIVEN LIVE ROLLER CURVE SPUR



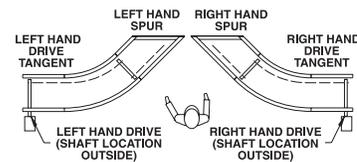
Model 196LRC features tapered rollers to maintain product orientation. Reversible, it is also commonly slave driven from 796CALR conveyors.



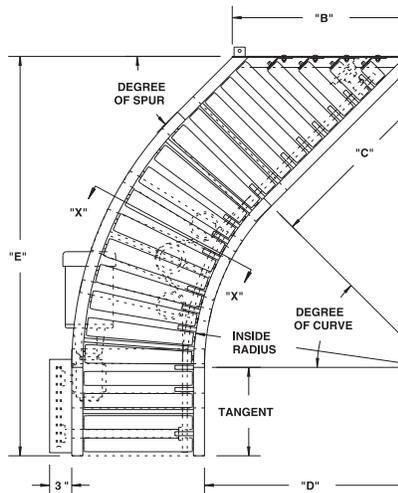
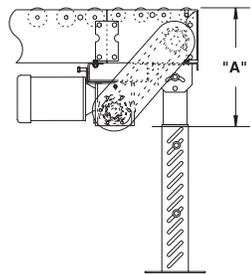
**DETERMINING DRIVE LOCATION**



**PERPENDICULAR LINE APPLICATION**



**PARALLEL LINE APPLICATION**



**SPECIFICATIONS**

- ▶ **TREAD ROLLERS:** 2-1/2" dia. to 1-11/16" dia. x 14 ga. tapered rollers (model 254T); 1.9" dia. x 16 ga. (model 196G) straight tangent rollers.
- ▶ **PRESSURE SHEAVES:** Provides drive belt pressure to upper tread rollers.
- ▶ **BELT:** "B" section V-belt.
- ▶ **TAKE-UP:** Screw type adjustable sheave with flat idler sheaves provided to maintain belt tension.
- ▶ **TANGENTS:** 12" opposite spur end on 60/30 unit; 18" opposite spur end on 45/45 unit.
- ▶ **BED:** 7" x 1-1/2" x 12 ga. formed steel channel frame.

- ▶ **BEARINGS:** End shafts are supported by precision, heavy duty, lubricated, ball bearing units with cast iron housings.
- ▶ **MOTOR DRIVE:** 1/2 HP, 230/460/3, 60 cycle, Super "E" right angle gear motor, located at infeed end of curve below bed.
- ▶ **SPUR HAND/DRIVE LOCATION:** Drive located on outside of curve. Specify hand of spur as "left hand" or "right hand" and location of drive specified as "left hand drive" or "right hand drive". NOTE: Drive location determined with reference point located at outside of curve. For models slave driven (less drive), specify drive shaft location.

- ▶ **BELT SPEED:** 60 FPM, constant.
- ▶ **ROLLER CHAIN:** Drive shaft is driven by No. 50 chain.
- ▶ **CAPACITY:** 500 lb. total distributed live load.
- ▶ **ELECTRICAL CONTROLS:** Optional.

HP@60 FPM	"A" MAX
1/2	16-5/8"
3/4	17"
1	17-1/4"
1-1/2	18-1/8"
2	19"

NOTE: This unit is not recommended for accumulating loads.

SPECIFICATION TABLE

UNIT			196LRCS - 45°/45°					196-LRCS - 60°/30°				
BF	OAW	INSIDE RADIUS	"B"	"C"	"D"	"E"	WT. (lbs.)	"B"	"C"	"D"	"E"	WT. (lbs.)
13"	16"	2'-8-1/2'	22-5/8"	26-1/2"	27-13/16"	58-21/32"	154	32"	37-1/8"	47-21/32"	57-13/32"	175
15"	18"	2'-8-1/2'	25-15/32"	28-1/2"	29-1/4"	60-3/32"	173	36"	40-9/16"	50-21/32"	59-1/8"	200
17"	20"	2'-8-1/2'	28-9/32"	30-1/2"	30-21/32"	61-1/2"	192	40"	44-1/32"	53-21/32"	60-7/8"	225
19"	22"	2'-8-1/2'	31-1/8"	32-1/2"	32-1/16"	62-29/32"	211	44"	47-1/2"	56-21/32"	62-19/32"	250
21"	24"	2'-8-1/2'	33-15/16"	34-1/2"	33-15/16"	65-5/16"	230	48"	50-31/32"	59-21/32"	64-11/32"	274
23"	26"	2'-8-1/2'	36-25/32"	36-1/2"	34-29/32"	65-23/32"	249	52"	54-9/16"	62-21/32"	66-1/16"	299
25"	28"	2'-8-1/2'	39-19/32"	38-1/2"	36-5/16"	67-5/32"	268	56"	57-29/32"	65-21/32"	67-13/16"	324
27"	30"	2'-8-1/2'	42-7/16"	40-1/2"	37-23/32"	68-9/16"	287	60"	61-3/8"	68-21/32"	69-17/32"	349
31"	34"	4'-0"	48-3/32"	44-1/2"	45-3/32"	82-11/32"	325	68"	68-9/32"	82-13/32"	86-13/32"	399
33"	36"	4'-0"	50-29/32"	46-1/2"	46-1/2"	83-25/32"	344	72"	71-3/4"	85-13/32"	88-5/32"	423
37"	40"	4'-0"	56-9/16"	50-1/2"	49-11/32"	86-19/32"	382	80"	78-11/16"	91-13/32"	91-5/8"	473
39"	42"	4'-0"	59-13/32"	52-1/2"	50-3/4"	88-1/32"	401	84"	82-5/32"	94-13/32"	93-11/32"	498

■ 3 week shipment

OPTIONAL EQUIPMENT

► **SIDE MOUNTED END DRIVE:**

Provides minimum overall conveyor height of 10".

► **DRIVE:** Located on inside radius of curve.

► **MOTORS:** Available through 3 HP in Super "E", explosion proof, dirty duty, brake motor, 115/230/1, 575/3, etc.

► **SPEED:** Constant speed 10-120 FPM; DC variable speed; AC inverter variable speed. Other constant or variable speeds available.

► **CEILING HANGERS:** 5/8" dia.

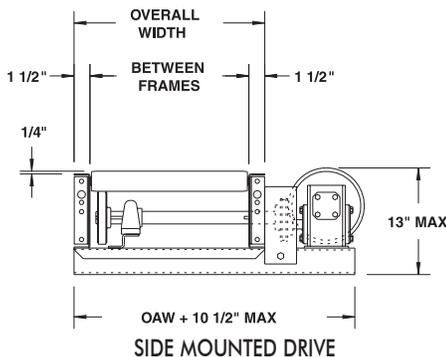
threaded rod with hardware to attach rods to conveyor. Provides 6' clearance between ceiling and TOR (furnished in place of floor supports). See Conveyor Accessories.

► **GUARD RAILS:** 1-3/4" x 1" formed channel (model GC), adjusts horizontally to 8" wider than roller and vertically to 6" above roller; formed steel fixed (model FSG in 2", 4", 6", 8", 12" and 18" heights; 1-1/2" angle (model GA1-1/2). See Conveyor Accessories.

► **ELECTRICAL CONTROLS:**

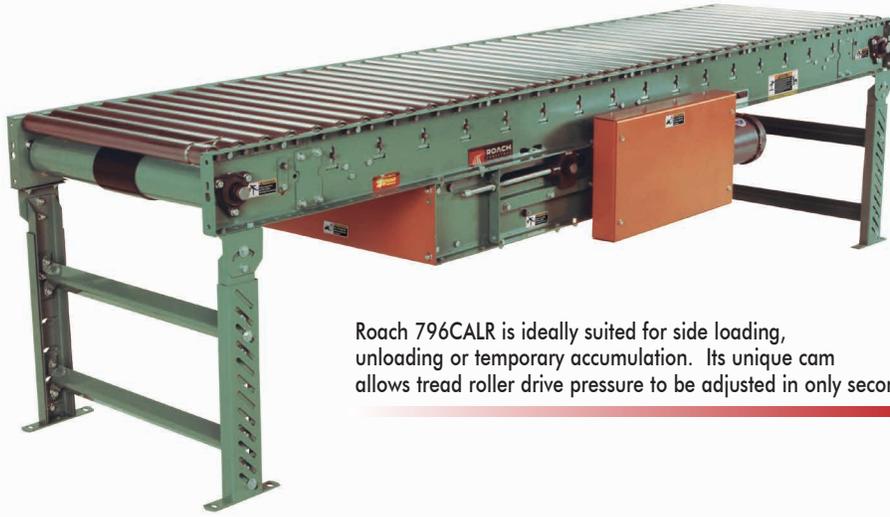
Magnetic starter (one direction or reversible); One direction manual starter; Momentary start/stop push button station; Forward/reversing /stop push button station.

► **FLOOR SUPPORTS:** Conveyor shown with optional supports. See Conveyor Accessories for various elevation and types.

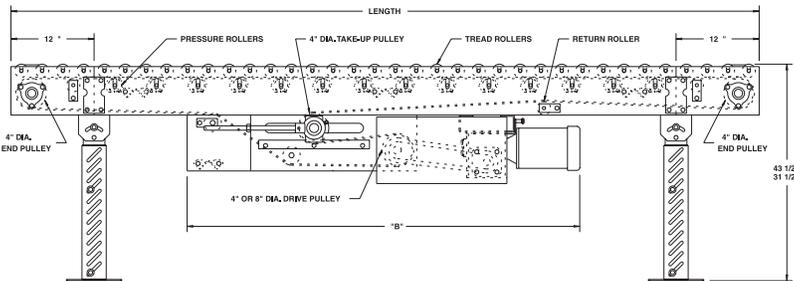
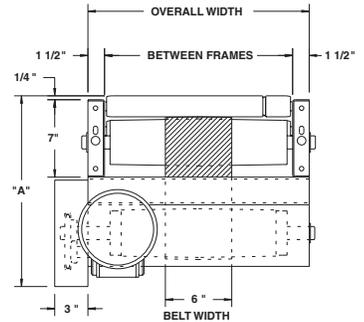


UNDERNEATH MOUNTED DRIVE

# 796CALR | MEDIUM DUTY CAM ADJUSTED LIVE ROLLER



Roach 796CALR is ideally suited for side loading, unloading or temporary accumulation. Its unique cam allows tread roller drive pressure to be adjusted in only seconds.



HP@ 60 FPM	"A" MAX		"B" MAX	
	4" DRV.	8" DRV.	4" DRV.	8" DRV.
1/2	16-5/8"	17-5/8"	58-5/32"	58-5/32"
3/4	17"	17-5/8"	58-25/32"	58-25/32"
1	17-1/4"	17-5/8"	59-17/32"	59-17/32"
1-1/2	18-1/8"	18-1/8"	61-21/32"	61-21/32"
2	19"	19"	62-21/32"	62-21/32"

## SPECIFICATIONS

- ▶ **TREAD ROLLERS:** 1.9" dia. x 16 ga. galv. steel rollers, model 196G.
- ▶ **PRESSURE ROLLERS:** 1.9" dia. x 16 ga. galv. steel, model 196G, cam adjustable.
- ▶ **BELTING:** 6" wide black PVC-120 COS.
- ▶ **CENTER DRIVE:** Reversible drive with 24" integral belt take-up. For units under 8'-0" overall length, drive components must be stacked. Consult factory for minimum unit elevation.
- ▶ **SQUARING RODS:** Adjustable rods on underside of bed allow frame to be squared for improved belt tracking and are standard on all units over 30'.

- ▶ **DRIVE PULLEY:** 4" dia. with 1-3/16" dia. shaft or 8" dia. with 1-7/16" dia. shaft, both crowned and fully lagged.
- ▶ **END PULLEY:** 4" dia., crowned, with 1-3/16" dia. shaft.
- ▶ **RETURN ROLLERS:** 1.9" dia. x 16 ga. galv. steel, model 196G, adjustable.
- ▶ **BED:** 7" x 1-1/2" x 12 ga. channel frame slotted for tread rollers to pop-out. When unit is installed at 7'-0" elevation or higher, rollers must be retained in conveyor frame. Specify desired elevation. Bed sections attached with couplings and floor supports.

- ▶ **BEARINGS:** All pulley bearings are precision, heavy duty, lubricated, ball bearing units with cast iron housings.
- ▶ **MOTOR DRIVE:** 1/2 HP, 230/460/3, 60 cycle, Super "E" right angle gear motor.
- ▶ **ROLLER CHAIN:** Drive pulley is driven by No. 50 roller chain for 1-1/2 HP or less and No. 60 chain on larger drives. Chain take-up provided on motor base.
- ▶ **SPEED:** 60 FPM, constant.
- ▶ **ELECTRICAL CONTROLS:** Optional.

**⚠ WARNING**

Pop-out rollers should be retained in frame if unit is elevated to 7'-0" and above.

## SPECIFICATION TABLE

50'-0" lengths and under are equipped with 4" dia. drive pulley; over 50'-0" includes 8" dia. drive pulley

CONVEYOR LENGTH			10'	20'	30'	40'	50'	60'	70'	80'	90'	100'	Deduct
BF	OAW	BELT	UNIT WEIGHTS (lbs.) with 3" Roller Center (For other centers, deduct weights below)										Per Foot
15"	18"	6"	489	755	1021	1287	1553	1819	2085	2351	2617	2883	27
19"	22"	6"	552	859	1167	1474	1781	2089	2396	2704	3011	3318	31
21"	24"	6"	584	912	1240	1568	1896	2224	2552	2880	3208	3536	33
25"	28"	6"	647	1016	1385	1755	2124	2494	2863	3232	3602	3971	37
27"	30"	6"	678	1068	1458	1848	2238	2629	3019	3409	3799	4189	39
33"	36"	6"	773	1225	1677	2129	2581	3033	3486	3938	4390	4842	45
39"	42"	6"	867	1381	1895	2410	2924	3438	3952	4467	4981	5495	51

Deduct the following weights (lbs.) for other than 3" centers

Tread Roller Centers	15" BF		19" BF		21" BF		25" BF		27" BF		33" BF		39" BF	
	Per 5'	Per 10'												
4-1/2"	-23	-45	-28	-55	-30	-60	-35	-69	-37	-75	-45	-90	-53	-105
6"	-45	-90	-54	-108	-60	-120	-69	-138	-75	-150	-90	-180	-105	-210
9"	-63	-117	-75	-142	-84	-156	-94	-180	-105	-195	-126	-234	-147	-273
12"	-67	-135	-84	-164	-90	-180	-103	-207	-112	-225	-135	-270	-157	-315

■ 3 week shipment

## OPTIONAL EQUIPMENT

► **END DRIVE:** Mounted underneath conveyor. Minimum possible height is 20" TOR for underneath mounted end drive. Belt take-up required for end drive (if substituting end drive for center drive).

► **SIDE MOUNTED END DRIVE:** Provides overall conveyor height of 10".

► **192S TREAD ROLLERS:** 1.9" dia. x 12 ga. steel tread rollers, model 192S, available in model 792CALR.

► **AUXILIARY TAKE-UP:** Provides 24" of belt take-up. Specify location. See Power Accessories.

► **SPEED:** Constant speed 3-120 FPM; DC variable speed; AC inverter variable speed. Other constant or variable speeds available.

**NOTE:** CAPACITY CHANGES WITH SPEED.

► **BELTING:** 6" wide black PVC-150; 12" wide PVC-120.

► **GUARD RAILS:** 1-3/4" x 1" formed channel (model GC), adjusts horizontally to 8" wider than roller and vertically to 6" above roller; formed steel fixed (model FSG in 2", 4" and 6" heights; fixed channel (model FC); 1-1/2" angle (model GA1-1/2). See Conveyor Accessories.

► **CEILING HANGERS:** 5/8" dia. threaded rod with hardware to attach rods to conveyor. Provides 6' clearance between ceiling and TOR (furnished in place of floor supports). See Conveyor Accessories.

► **FLOOR SUPPORTS:** Conveyor shown with optional supports. Supports, knee braces, casters and polytier supports available. See Conveyor Accessories.

► **MOTORS:** Available through 3 HP in Super "E", explosion proof, dirty duty, brake motor, 115/230/1, 575/3, etc.

► **ELECTRICAL CONTROLS:** Magnetic starter (one direction or reversible); One direction manual starter; Momentary start/stop push button station; Forward/reversing /stop push button station. Mounting and pre-wiring for units up to 12' long.

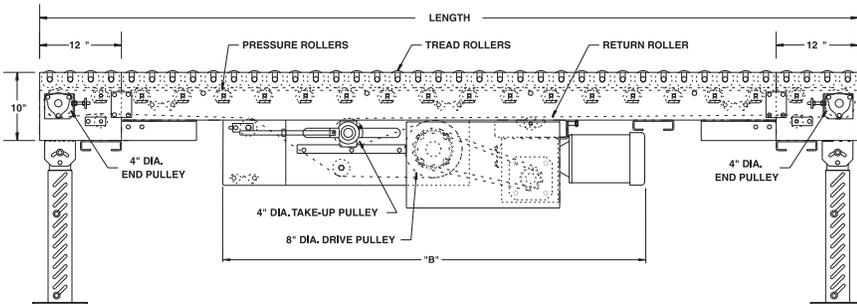
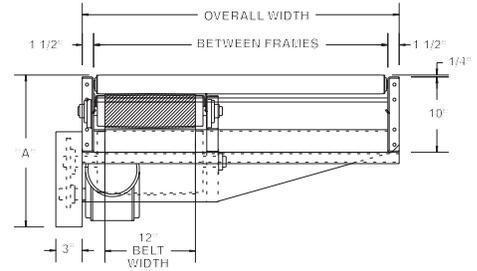


POP-OUT ROLLERS (some rollers raised for clarity)

## 251CALR | HEAVY DUTY CAM ADJUSTED LIVE ROLLER



Roach 251CALR is the choice to horizontally convey heavier unit loads where transfers, side loading or unloading is required. Its standard center drive allows for reversible operation.



HP@ 35 FPM	"A" MAX	"B" MAX
1	17-5/8"	59-17/32"
1-1/2	18-1/8"	61-21/32"
2	19"	62-21/32"

NOTE: Chart applies for 8" dia. drive pulley only.

### SPECIFICATIONS

- ▶ **TREAD ROLLERS:** 2-1/2" dia. x 11 ga. steel, model 251S.
- ▶ **PRESSURE ROLLERS:** 1.9" dia. x 16 ga. galv. steel, model 196G; same BF as conveyor up to 39" BF; units 43" BF and above, rollers are 21" BF with STANDARD 12" wide belt; 27" BF if OPTIONAL 24" belt is used.
- ▶ **BELTING:** 12" wide PVC-120.
- ▶ **RETURN ROLLERS:** 1.9" dia. x 16 ga. galv. steel, model 196G, adjustable.
- ▶ **CENTER DRIVE:** Reversible drive with 24" integral belt take-up. Specify location. For units under 8'-0" overall length, drive components must be stacked.

- ▶ **END PULLEY:** 4" dia. with 1-3/16" dia. shaft on 15"-39" BF; 6" dia. with 1-7/16" dia. shaft above 39" BF; both crowned.
- ▶ **DRIVE PULLEY:** 8" dia. with 1-7/16" dia. shaft on 15"-39" BF; 12" dia. with 1-15/16" dia. shaft above 39" BF; both crowned and fully lagged.
- ▶ **BEARINGS:** Precision ABEC bearings.
- ▶ **BED:** 7" x 1-1/2" x 10 ga. formed steel channel frame slotted for tread rollers to pop-out. When unit is installed at 7'-0" elevation or higher, rollers must be retained in conveyor frame. Specify desired elevation. Bed sections attached with couplings and floor supports.

- ▶ **MOTOR DRIVE:** 1 HP, 230/460/3, 60 cycle, Super "E" right angle gear motor.
- ▶ **SPEED:** 35 FPM, constant.
- ▶ **ROLLER CHAIN:** Drive pulley is driven by No. 50 chain for 1-1/2 HP or less and No. 60 chain on larger drives. Chain take-up provided on motor base.
- ▶ **ELECTRICAL CONTROLS:** Optional.

### ⚠ WARNING

Pop-out rollers should be retained in frame if unit is elevated to 7'-0" and above.

SPECIFICATION TABLE

CONVEYOR LENGTH			10'	20'	30'	40'	50'	60'	70'	80'	90'	100'	Deduct
BF	OAW	BELT	UNIT WEIGHTS (lbs.) with 3" Roller Centers (For other centers, deduct weights below)										Per Foot
15"	18"	12'	852	1336	1821	2305	2790	3274	3759	4243	4728	5212	48
21"	24"	12'	1052	1645	2239	2832	3425	4019	4612	5206	5799	6392	59
27"	30"	12'	1252	1954	2657	3359	4061	4763	5466	6168	6870	7573	70
33"	36"	12'	1452	2263	3074	3886	4697	5508	6319	7130	7942	8753	81
39"	42"	12'	1652	2572	3492	4412	5333	6253	7173	8093	9013	9933	92
43"	46"	12'	1852	2881	3910	4939	5968	6997	8026	9055	10084	11113	103
51"	54"	12'	2052	3190	4328	5466	6604	7742	8880	10018	11156	12294	114
57"	60"	12"	2252	3499	4746	5993	7240	8486	9733	10980	12227	13474	125

■ 3 week shipment

Deduct the following weights (lbs.) for other than 3" centers

Tread Roller Centers	15" BF	21" BF	27" BF	33" BF	39" BF	45" BF	51" BF	57" BF
	Per 10'							
4-1/2"	-108	-136	-174	-208	-240	-272	-304	-336
6"	-178	-228	-292	-348	-402	-456	-510	-564
9"	-240	-308	-394	-470	-544	-618	-692	-766
12"	-266	-342	-438	-522	-602	-682	-762	-842

OPTIONAL EQUIPMENT

► **END DRIVE:** Mounted underneath conveyor. Minimum possible height is 20" TOR for underneath mounted end drive. Belt take-up required for end drive (if substituting end drive for center drive).

► **SIDE MOUNTED END DRIVE:** Provides overall conveyor height of 14-1/4". Specify elevation required on order.

► **AUXILIARY TAKE-UP:** Provides 24" of belt take-up. Specify location. See Power Accessories.

► **GUARD RAILS:** Formed steel fixed model HFSG in 2", 4" and 6" heights; 1-1/2" angle model HGA1-1/2). See Conveyor Accessories.

► **CEILING HANGERS:** 5/8" dia. threaded rod with hardware to attach rods to conveyor. Provides 6' clearance between ceiling and TOR (furnished in place of floor supports). Consult factory.

► **BELTING:** 12" wide black PVC-150; 24" wide PVC-120.

► **FLOOR SUPPORTS:** Conveyor shown with optional supports. Supports, knee braces, casters and polytier supports available. See Conveyor Accessories.

► **SPEED:** Constant speed 8-120 FPM (12" dia. drive pulley); DC variable speed; AC inverter variable speed. Other constant or variable speeds available. **NOTE: CAPACITY CHANGES WITH SPEED.**

► **MOTORS:** Available through 3 HP in Super "E", explosion proof, dirty duty, brake motor, 115/230/1, 575/3, etc.

► **ELECTRICAL CONTROLS:** Magnetic starter (one direction or reversible); One direction manual starter; Momentary start/stop push button station; Forward/reversing /stop push button station. Mounting and pre-wiring for units up to 12' long.

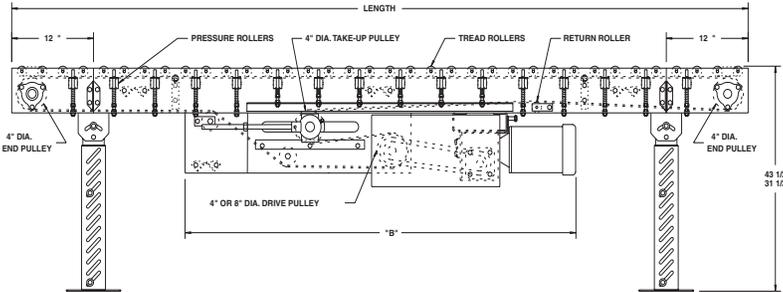
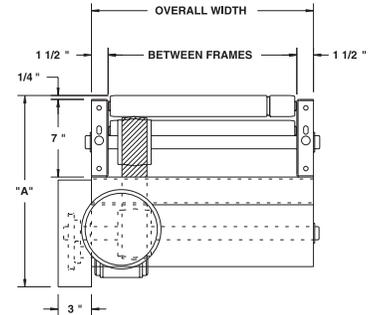


CALR CAM AND SERIAL PLATE

# 196ZPA | MEDIUM DUTY ZERO PRESSURE LIVE ROLLER ACCUMULATOR



Roach 196ZPA safely accumulates packages with zero back pressure utilizing zone singulation operation. Loads up to 125 lbs./ft. may be effectively handled with its unique design. This conveyor features NO minimum weight limitations. Sensor rollers are utilized to accumulate products with previously difficult minimal weight restrictions.



HP@ 60 FPM	"A" MAX		"B" MAX	
	4" DRV.	8" DRV.	4" DRV.	8" DRV.
1/2	16-5/8"	17-5/8"	58-5/32"	58-5/32"
3/4	17"	17-5/8"	58-25/32"	58-25/32"
1	17-1/4"	17-5/8"	59-17/32"	59-17/32"
1-1/2	18-1/8"	18-1/8"	61-21/32"	61-21/32"
2	19"	19"	62-21/32"	62-21/32"

## SPECIFICATIONS

- ▶ **TREAD ROLLERS:** 1.9" dia. x 16 ga. galv. steel, model 196G.
- ▶ **PRESSURE ROLLERS:** 1.9" dia. x 16 ga. galv. steel, model 196G.
- ▶ **RETURN ROLLERS:** 1.9" dia. x 16 ga. galv. steel, model 196G, adjustable.
- ▶ **BELTING:** 2-1/4" wide "high strength" PVC-150 belt. **\*NOTE:** WHEN SLAVE DRIVING OTHER UNITS, OPTIONAL 6" WIDE PVC-120 DRIVE BELT MUST BE USED ON UNITS 20' LONG AND ABOVE.
- ▶ **CENTER DRIVE:** Reversible drive with 24" integral belt take-up. For units under 8'-0" overall length, drive components must be stacked. Consult factory for minimum unit elevation.
- ▶ **END PULLEY:** 4" dia., crowned, with 1-3/16" dia. shaft.
- ▶ **DRIVE PULLEY:** \*4" dia. with 1-3/16" dia. shaft or 8" dia. with 1-7/16" dia. shaft, both crowned and fully lagged.
- ▶ **SPEED:** 60 FPM, constant.
- ▶ **BED:** 7" x 1-1/2" x 12 ga. channel frame slotted for tread rollers to pop-out. When unit is installed at 7'-0" elevation or higher, rollers must be retained in conveyor frame. Specify desired elevation. Bed sections attached with couplings and floor supports.

▶ **SQUARING RODS:** Adjustable rods on underside of bed allow frame to be squared for improved belt tracking and are standard on all units over 30'.

▶ **BEARINGS:** All pulley bearings are precision, heavy duty, lubricated, ball bearing units with cast iron housings.

▶ **MOTOR DRIVE:** 1/2 HP, 230/460/3, 60 cycle, Super "E" right angle gear motor.

▶ **ROLLER CHAIN:** Drive pulley is driven by No. 50 roller chain for 1-1/2 HP or less and No. 60 chain on larger drives. Chain take-up provided on motor base.

▶ **ELECTRICAL CONTROLS:** Optional.

### ⚠ WARNING

Pop-out rollers should be retained in frame if unit is elevated to 7'-0" and above.

\*When using 2-1/4" wide drive belt, 4" dia. drive pulley supplied up to 20'-0" long; 8" dia. pulley supplied over 20'-0" unit lengths.  
 \*When using OPTIONAL 6" wide drive belt, 4" dia. drive pulley supplied up to 50'-0" long; 8" dia. pulley supplied over 50'-0" unit lengths.  
 \*When slave driving other units, OPTIONAL 6" wide drive belt must be used on units 20'-0" and above.

CONVEYOR LENGTH			10'	20'	30'	40'	50'	60'	70'	80'	90'	100'	Deduct
BF	OAW	BELT	UNIT WEIGHTS (lbs.) with 3" Roller Centers (For other centers, deduct weights below)										Per Foot
15"	18"	2-1/4"	460	720	979	1239	1498	1758	2017	2277	2536	2796	26
19"	22"	2-1/4"	515	816	1116	1417	1718	2018	2319	2619	2920	3221	30
21"	24"	2-1/4"	543	864	1185	1506	1827	2148	2470	2791	3112	3433	32
25"	28"	2-1/4"	598	960	1322	1685	2047	2409	2771	3133	3495	3858	36
27"	30"	2-1/4"	626	1008	1391	1774	2156	2539	2922	3305	3687	4070	38
33"	36"	2-1/4"	708	1153	1597	2041	2485	2930	3374	3818	4263	4707	44
39"	42"	2-1/4"	791	1297	1803	2309	2815	3320	3826	4332	4838	5344	51

Deduct the following weights (lbs.) for other than 3" centers

Tread Roller Centers	15" BF		19" BF		21" BF		25" BF		27" BF		33" BF		39" BF	
	Per 5'	Per 10'												
4-1/2"	-23	-45	-28	-55	-30	-60	-35	-69	-37	-75	-45	-90	-53	-105
6"	-45	-90	-54	-108	-60	-120	-69	-138	-75	-150	-90	-180	-105	-210

■ 3 week shipment

## OPTIONAL EQUIPMENT

► **END DRIVE:** Mounted underneath conveyor. Minimum possible height is 20" TOR for underneath mounted end drive. Belt take-up required for end drive (if substituting end drive for center drive).

► **SIDE MOUNTED END DRIVE:** Provides overall conveyor height of 10".

► **BELTING:** 6" wide black PVC-120; 6" wide black PVC-150; 12" wide PVC-120.

► **GUARD RAILS:** 1-3/4" x 1" formed channel (model GC), adjusts horizontally to 8" wider than roller and vertically to 6" above roller; formed steel fixed (model FSG in 2", 4" and 6" heights; fixed channel (model FC); 1-1/2" angle (model GA1-1/2). See Conveyor Accessories.

► **CEILING HANGERS:** 5/8" dia. threaded rod with hardware to attach rods to conveyor. Provides 6' clearance between ceiling and TOR (furnished in place of floor supports). See Conveyor Accessories.

► **FLOOR SUPPORTS:** Conveyor shown with optional supports. Supports, knee braces, casters and polytier supports available. See Conveyor Accessories.

► **SPEED:** Constant speed 3-120 FPM; DC variable speed; AC inverter variable speed. Other constant or variable speeds available.  
**NOTE: CAPACITY CHANGES WITH SPEED.**

► **192S TREAD ROLLERS:** 1.9" dia. x 12 ga. steel tread rollers, model 192S.

► **AUXILIARY TAKE-UP:** Provides 24" of belt take-up. Specify location. See Power Accessories.

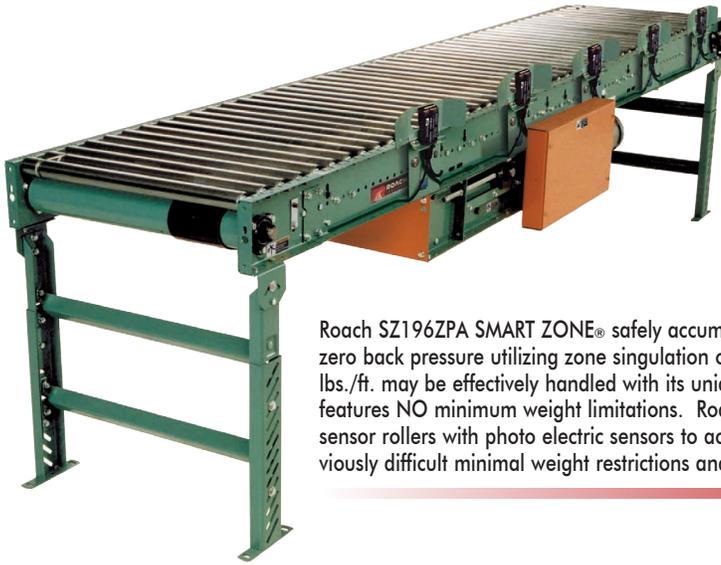
► **MOTORS:** Available through 3 HP in Super "E", explosion proof, dirty duty, brake motor, 115/230/1, 575/3, etc.

► **ELECTRICAL CONTROLS:** Magnetic starter (one direction or reversible); One direction manual starter; Momentary start/stop push button station; Forward/reversing/stop push button station. Mounting and pre-wiring for units up to 12' long.



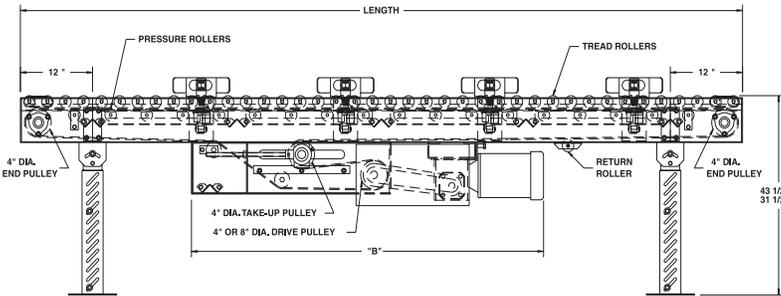
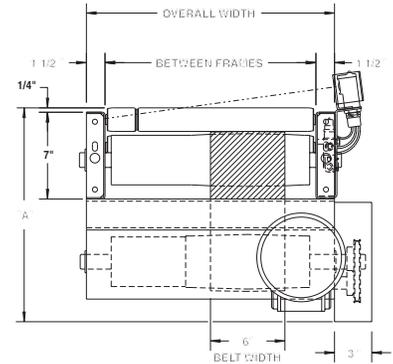
VARIABLE PRESSURE ADJUSTMENT

## SZ196ZPA SMART ZONE® | MEDIUM DUTY ZERO PRESSURE LIVE ROLLER ACCUMULATOR



Roach SZ196ZPA SMART ZONE® safely accumulates packages with zero back pressure utilizing zone singulation operation. Loads up to 125 lbs./ft. may be effectively handled with its unique design. This conveyor features NO minimum weight limitations. Roach SMART ZONE® replaces sensor rollers with photo electric sensors to accumulate products with previously difficult minimal weight restrictions and is easy to install.

**SMART ZONE:**  
Retroflective photo eyes include a 24V DC power supply operated by a 110V AC input.



HP@ 60 FPM	"A" MAX		"B" MAX	
	4" DRV.	8" DRV.	4" DRV.	8" DRV.
1/2	16-5/8"	17-5/8"	58-5/32"	58-5/32"
3/4	17"	17-5/8"	58-25/32"	58-25/32"
1	17-1/4"	17-5/8"	59-17/32"	59-17/32"
1-1/2	18-1/8"	18-1/8"	61-21/32"	61-21/32"
2	19"	19"	62-21/32"	62-21/32"

### SPECIFICATIONS

- ▶ **TREAD ROLLERS:** 1.9" dia. x 16 ga. galv. steel, model 196G.
- ▶ **PRESSURE ROLLERS:** 1.9" dia. x 16 ga. galv. steel, model 196G; 8" BF with 6" wide belt.
- ▶ **BELTING:** 6" wide black PVC-120 COS.
- ▶ **DRIVE PULLEY:** 4" dia. with 1-3/16" dia. shaft or 8" dia. with 1-7/16" dia. shaft, both crowned and fully lagged.
- ▶ **END PULLEY:** 4" dia., crowned, with 1-3/16" dia. shaft.
- ▶ **RETURN ROLLERS:** 1.9" dia. x 16 ga. galv. steel, model 196G, adjustable.
- ▶ **BEARINGS:** All pulley bearings are precision, heavy duty, lubricated, ball bearing units with cast iron housings.
- ▶ **SPEED:** 60 FPM, constant.
- ▶ **ACCUMULATION:** Zone singulation operation; 2'-0" long zones. 1'-0" of live roller over end plates at each end of conveyor remains "live" during operation (# of zones x zone length + 2' = overall conveyor length). Zones are pneumatically actuated using photo electric sensors.
- ▶ **BED:** 7" x 1-1/2" x 12 ga. channel frame slotted for tread rollers to pop-out. When unit is installed at 7'-0" elevation or higher, rollers must be retained in conveyor frame. Specify desired elevation. Bed sections attached with couplings and floor supports.
- ▶ **FRL:** Unit is provided with filter, regulator, lubricator with 1/4" ports.
- ▶ **PNEUMATIC ACTUATION:** Maximum air line pressure should not exceed 30 PSI.
- ▶ **SQUARING RODS:** Adjustable rods on underside of bed allow frame to be squared for improved belt tracking and are standard on all units over 30'.
- ▶ **MOTOR DRIVE:** 1/2 HP, 230/460/3, 60 cycle, Super "E" right angle gear motor.
- ▶ **ROLLER CHAIN:** Drive pulley is driven by No. 50 roller chain for 1-1/2 HP or less and No. 60 chain on larger drives. Chain take-up provided on motor base.

**⚠ WARNING**

Pop-out rollers should be retained in frame if unit is elevated to 7'-0" and above.

## SPECIFICATION TABLE

50'-0" lengths and under are equipped with 4" dia. drive pulley; over 50'-0" includes 8" dia. drive pulley

CONVEYOR LENGTH			10'	20'	30'	40'	50'	60'	70'	80'	90'	100'	Deduct
BF	OAW	BELT	UNIT WEIGHTS (lbs.) with 3" Roller Centers (For other centers, deduct weights below)										Per Foot
15"	18"	6"	520	824	1127	1431	1734	2038	2341	2645	2948	3252	30
19"	22"	6"	576	912	1248	1584	1920	2255	2591	2927	3263	3599	34
21"	24"	6"	605	956	1308	1660	2012	2364	2716	3068	3420	3772	35
25"	28"	6"	661	1045	1429	1813	2198	2582	2966	3350	3734	4119	38
27"	30"	6"	689	1089	1490	1890	2290	2691	3091	3491	3892	4292	40
33"	36"	6"	774	1222	1671	2120	2568	3017	3466	3915	4363	4812	45
39"	42"	6"	858	1355	1852	2349	2846	3344	3841	4338	4835	5332	50

Deduct the following weights (lbs.) for other than 3" centers

Tread Roller Centers	15" BF		19" BF		21" BF		25" BF		27" BF		33" BF		39" BF	
	Per 5'	Per 10'												
4"	-23	-45	-28	-55	-30	-60	-35	-69	-37	-75	-45	-90	-53	-105
6"	-45	-90	-54	-108	-60	-120	-69	-138	-75	-150	-90	-180	-105	-210

■ 3 week shipment

## OPTIONAL EQUIPMENT

► **ACCUMULATION:** 30" and 60" zones available in 3" and 6" roller centers; 40" and 60" zones available in 4" roller centers.

► **SLUG RELEASE:** Products may be slug released rather than individual product release in normal zone singulation; accumulation mode will not be disturbed when slug release option utilized.

► **BELTING:** 6" wide black PVC-150; 12" wide PVC-120.

► **END DRIVE:** Mounted underneath conveyor. Minimum possible height is 20" TOR for underneath mounted end drive. Belt take-up required for end drive (if substituting end drive for center drive).

► **AUXILIARY TAKE-UP:** Provides 24" of belt take-up; specify location. See Power Accessories.

► **FLOOR SUPPORTS:** Conveyor shown with optional supports. Supports, knee braces, casters and polytiter supports available. See Conveyor Accessories.

► **CEILING HANGERS:** 5/8" dia. threaded rod with hardware to attach rods to conveyor. Provides 6' clearance between ceiling and TOR (furnished in place of floor supports). See Conveyor Accessories.

► **192S TREAD ROLLERS:** 1.9" dia. x 12 ga. steel tread rollers, model 192S, available in model SZ192ZPA SMART ZONE®.

► **SPEED:** Constant speed 15-120 FPM; DC variable speed; AC inverter variable speed. Other constant or variable speeds available.

**NOTE:** CAPACITY CHANGES WITH SPEED.

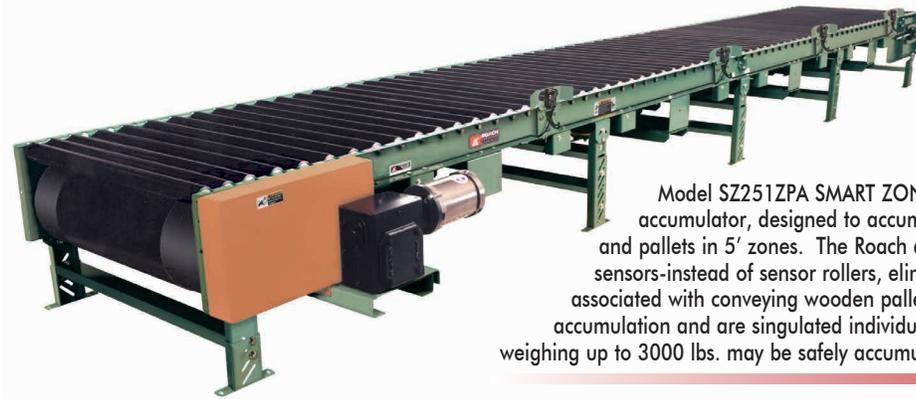
► **MOTORS:** Available through 3 HP in Super "E", explosion proof, dirty duty, brake motor, 115/230/1, 575/3, etc.

► **DEFUSED SMARTZONE:** Photoeyes mounted below tread rollers.



PHOTO SENSOR MOUNT

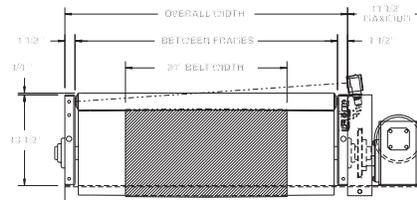
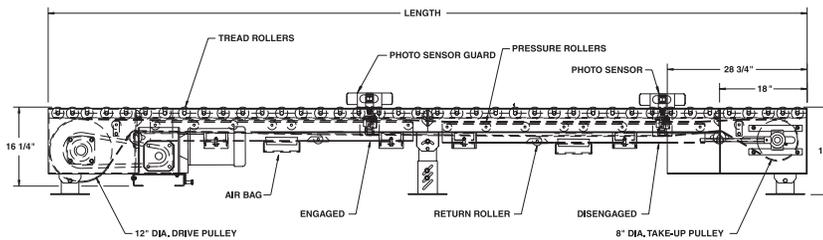
# SZ251ZPA SMART ZONE® | HEAVY DUTY ZERO PRESSURE ACCUMULATOR



Model SZ251ZPA SMART ZONE® is a heavy duty zero pressure accumulator, designed to accumulate heavy products, containers and pallets in 5' zones. The Roach design incorporates photo electric sensors-instead of sensor rollers, eliminating many common problems associated with conveying wooden pallets. Products do not touch during accumulation and are singulated individually off of conveyor. Heavy loads weighing up to 3000 lbs. may be safely accumulated with Roach SMART ZONE®.

### SMART ZONE:

Retroreflective photo eyes include a 24V DC power supply operated by a 110V AC input.



### SPECIFICATIONS

- ▶ **TREAD ROLLERS:** 2-1/2" dia. x 11 ga. steel, model 251S.
- ▶ **PRESSURE ROLLERS:** 1.9" dia. x 16 ga. galv. steel, model 196G; 27" BF for all widths.
- ▶ **RETURN ROLLERS:** 1.9" dia. x 16 ga. galv. steel, model 196G, adjustable.
- ▶ **BELTING:** 24" wide PVC-120 COS.
- ▶ **SIDE MOUNT END DRIVE:** Allows one direction unit operation.
- ▶ **DRIVE PULLEY:** 12" dia., with 1-15/16" dia. shaft, crowned and fully lagged.
- ▶ **TAIL PULLEY:** 8" dia., crowned, with 1-3/16" dia. shaft.
- ▶ **TAKE-UP:** Screw type unit at tail pulley provides 12" belt take-up.
- ▶ **BEARINGS:** Precision ABEC bearings.
- ▶ **BED:** 5" x 1-1/2" x 3/16" formed steel channel frame slotted for tread rollers to pop-out. When unit is installed at 7'-0" elevation or higher, rollers must be retained in conveyor. Specify desired elevation. Bed sections are bolted together with butt couplings and floor supports.
- ▶ **SPEED:** 35 FPM, constant.
- ▶ **ACCUMULATION:** 5'-0" long zones with zone singulation operation. 1'-6" of live roller over end plates at each end of conveyor remains "live" during operation (# of zones x zone length + 3'-0" = overall conveyor length). Zones are pneumatically actuated by using photo electric sensors.
- ▶ **FRL:** Unit is provided with filter, regulator and lubricator with 3/8" ports for 60 PSI operational pressure.
- ▶ **MOTOR DRIVE:** 1 HP, 230/460/3, 60 cycle, Super "E" right angle gear motor.
- ▶ **ROLLER CHAIN:** No. 60 chain provided at drive pulley. Chain take-up provided on motor base.

### ⚠ WARNING

Pop-out rollers should be retained in frame if unit is elevated to 7'-0" and above.

**SPECIFICATION TABLE**

CONVEYOR LENGTH		13'	18'	23'	28'	33'	38'	43'	48'	53'	58'	63'	68'	73'	78'	83'	Deduct
BF	Conv. Surface	UNIT WEIGHTS (lbs.) with 4" Roller Centers															Per Foot
39"	42"	1430	1974	2459	2944	3429	3914	4399	4884	5369	5854	6339	6824	7309	7794	8279	103
43"	46"	1520	2105	2623	3141	3658	4176	4694	5211	5729	6247	6765	7282	7800	8318	8836	110
51"	54"	1667	2308	2875	3443	4010	4577	5145	5712	6279	6846	7414	7981	8548	9116	9683	121
57"	60"	1783	2476	3084	3692	4301	4901	5518	6126	6734	7343	7951	8560	9168	9776	10385	130
		UNIT WEIGHTS (lbs.) with 6" Roller Centers															
39"	42"	1222	1686	2091	2496	2901	3306	3711	4116	4521	4926	5331	5736	6141	6456	6951	87
43"	46"	1299	1799	2232	2665	3097	3530	3963	4395	4828	5261	5694	6126	6569	6942	7425	93
51"	54"	1407	1948	2415	2883	3350	3817	4285	4752	5219	5686	6154	6621	7088	7556	8023	101
57"	60"	1502	1970	2468	3828	3575	4065	4572	5070	5568	6067	6565	7064	7562	8060	8559	111

■ 6 week shipment

**OPTIONAL EQUIPMENT**

► **BELTING:** 12" wide PVC-120; 24" wide PVC-150.

► **DRIVE PULLEY:** 8" dia. with 1-7/16" dia. shaft, crowned and fully lagged.

► **SLUG RELEASE:** Products may be slug released rather than individual product release in normal zone singulation; accumulation mode will not be disturbed when slug release option utilized.

► **FLOOR SUPPORTS:** Conveyor shown with optional supports. Supports, knee braces, casters and polytier supports available. See Conveyor

Accessories.

► **SPEED:** Constant speed 8-120 FPM; DC variable speed; AC inverter variable speed. Other constant or variable speeds available.

**NOTE:** CAPACITY CHANGES WITH SPEED.

► **MOTORS:** Available through 3 HP in Super "E", explosion proof, dirty duty, brake motor, 115/230/1, 575/3, etc.

► **ELECTRICAL CONTROLS:**

Magnetic starter; One direction manual starter; Momentary start/stop push button station; start/stop push button station.

► **DEFUSED SMARTZONE:** Photoeyes mounted below tread rollers.



PHOTO SENSOR MOUNT



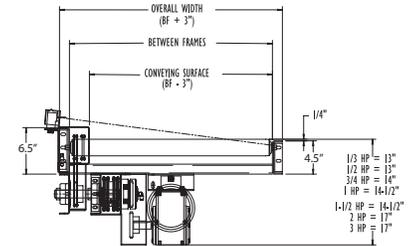
HEAVY DUTY AIR BAG

# SZA192CDA | MEDIUM DUTY CHAIN DRIVEN ZERO PRESSURE ACCUMULATOR

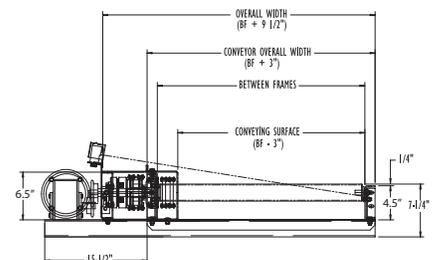


SZA192CDA SMART ZONE® is a medium duty roll-to-roll chain driven zero pressure accumulator, designed to safely accumulate medium duty loads in 5' zones. Roach SMART ZONE® incorporates photo electric sensors to detect product loads instead of sensor rollers-which eliminates many problems associated with sensor rollers. Products do not touch during accumulation and are singulated individually off of conveyor. SMART ZONE® is easy to install and simple to maintain.

## AIR CLUTCH OPERATED ZONES



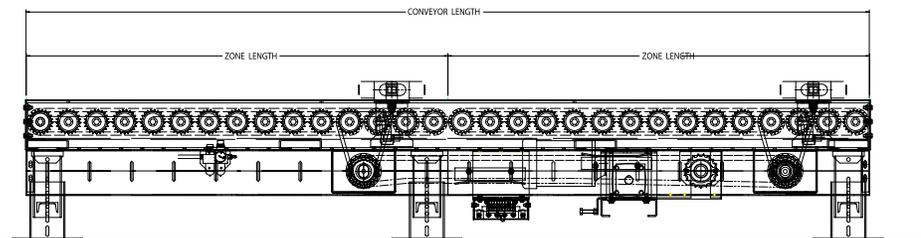
SZA192CDA AIR CLUTCH UNDERNEATH



SZA192CDA AIR CLUTCH SIDEMOUNT

## SMART ZONE:

Retroreflective photo eyes include a 24V DC power supply operated by a 110V AC input.



## SPECIFICATIONS

- ▶ **TREAD ROLLERS:** 1.9" dia. x 12 ga., model 192S.
- ▶ **CHAIN DRIVE:** Roller-to-roller No. 40 roller chain. Zone-to-zone No. 60 roller chain.
- ▶ **CHAIN GUARD:** All chains are completely enclosed along the entire length of conveyor.
- ▶ **CENTER DRIVE:** Drive either side mounted or underside mounted (specify). Drive shafts are supported by precision, heavy duty, lubricated, ball bearing units.
- ▶ **ROLLER CENTERS:** 4" or 6" RC ONLY.
- ▶ **SPEED:** 35 FPM, constant.
- ▶ **ACCUMULATION ZONE:** 5'-0" zone lengths, zone singulation operation, photo electric sensor controlled zones with air clutch. (60 psi max)
- ▶ **BED:** 6-1/2" x 1-1/2" x 10 ga. and 4-1/2" x 1-1/2" x 10 ga. formed steel channel frame. Bed sections are bolted together with butt couplings and floor supports.
- ▶ **BEARINGS:** Removable type, heavy duty ball bearings, zinc-plated, grease packed, labyrinth seal.

- ▶ **FRL:** Unit is provided with filter, regulator and lubricator with 3/8" ports for 60 PSI operational pressure.
- ▶ **MOTOR DRIVE:** 1/2 HP, 230/460/3, 60 cycle, Super "E" right angle gear motor.
- ▶ **CAPACITY:** 300 lbs./ft. up to a maximum of 1200 lb. pallet load.

SPECIFICATION TABLE

■ 6 week shipment

CONVEYOR LENGTH		10'	20'	30'	40'	50'	60'	70'	80'	90'	100'
BF	Conv. Surface	UNIT WEIGHTS (lbs.) with 4" Roller Centers									
15"	12"	761	1341	1922	2502	3083	3663	4244	4824	5405	5986
21"	18"	832	1476	2119	2762	3406	4049	4692	5336	5979	6622
27"	24"	922	1646	2369	3093	3816	4539	5262	5977	6706	7435
33"	30"	998	1802	2598	3393	4189	4985	5780	6582	7379	8176
39"	36"	1075	1929	2784	3638	4493	5347	6202	7056	7915	8774
45"	42"	1156	2081	3007	3932	4857	5783	6709	7634	8568	9502
51"	48"	1226	2213	3199	4186	5173	6159	7146	8133	9132	10131
		UNIT WEIGHTS (lbs.) with 6" roller centers									
15"	12"	711	1241	1772	2302	2833	3363	3894	4424	4955	5486
21"	18"	772	1356	1939	2522	3106	3680	4272	4856	5439	6022
27"	24"	842	1486	2129	2773	3416	4059	4702	5337	5986	6635
33"	30"	898	1602	2298	2993	3689	4385	5080	5789	6479	7176
39"	36"	965	1709	2454	3198	3943	4687	5432	6176	6925	7674
45"	42"	1026	1821	2617	3412	4207	5003	5799	6594	7398	8202
51"	48"	1086	1933	2779	3626	4473	5319	6166	7013	7872	8731

OPTIONAL EQUIPMENT

- ▶ **ZONE LENGTHS:** 3' through 10' in 4" or 6" increments as per roller centers and zone chain pitch. Frame lengths will vary with zone lengths.
- ▶ **BED:** 6-1/2" x 1-1/2" x 7 ga. and 4-1/2" x 1-1/2" x 7 ga. formed steel channel frame.
- ▶ **TREAD ROLLERS:** 1.9" dia. x 9 ga. steel, model 199S tread rollers.

- ▶ **FLOOR SUPPORTS:** Conveyor shown with optional supports. Supports, knee braces, casters and polytier supports available. See Conveyor Accessories.
  - ▶ **SIDE MOUNTED CLUTCH:** Consult factory for low elevation model SZ192CDAS with side mounted clutch.
  - ▶ **SPEED:** Constant speed 20-120 FPM; DC variable speed; AC inverter variable speed. Other constant or variable speeds available. Minimum unit speed is 20 FPM for model CDA.
- NOTE:** CAPACITY CHANGES WITH SPEED.

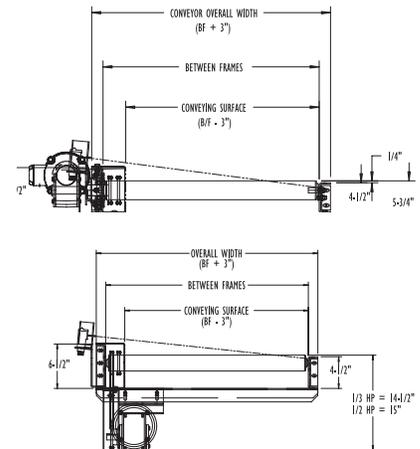
- ▶ **MOTORS:** Available through 3 HP in Super "E", explosion proof, dirty duty, brake motor, 115/230/1, 575/3, etc.
- ▶ **DEFUSED SMARTZONE:** Photoeyes mounted below tread rollers.

# SZD192CDA | MEDIUM DUTY CHAIN DRIVEN ZERO PRESSURE ACCUMULATOR

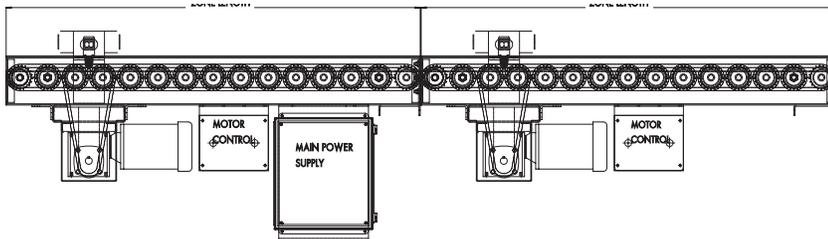


SZD192CDA SMART ZONE® is a medium duty roll-to-roll chain driven zero pressure accumulator, designed to safely accumulate medium duty loads in 5' zones. Roach SMART ZONE® incorporates photo electric sensors to detect product loads instead of sensor rollers which eliminates many problems associated with sensor rollers. Products do not touch during accumulation and are singulated individually off of conveyor. SMART ZONE® is easy to install and simple to maintain.

## DRIVE OPERATED ZONES



SZD192CDA UNDERNEATH DRIVE



## SMART ZONE:

Retroflective photo eyes include a 24V DC power supply operated by a 110V AC input.

## SPECIFICATIONS

- ▶ **TREAD ROLLERS:** 1.9" dia. x 12 ga., model 192S.
- ▶ **CHAIN DRIVE:** Roller-to-roller No. 40 roller chain. Zone-to-zone No. 60 roller chain.
- ▶ **CHAIN GUARD:** All chains are completely enclosed along the entire length of conveyor.
- ▶ **CENTER DRIVE:** Drive either side mounted or underside mounted (specify). Drive shafts are supported by precision, heavy duty, lubricated, ball bearing units.
- ▶ **ROLLER CENTERS:** 4" or 6" RC ONLY.
- ▶ **SPEED:** 35 FPM, constant.
- ▶ **ACCUMULATION ZONE:** 5'-0" zone lengths, zone singulation operation, photo electric sensor controlled zones with separate drives on each zone.
- ▶ **BED:** 6-1/2" x 1-1/2" x 10 ga. and 4-1/2" x 1-1/2" x 10 ga. formed steel channel frame. Bed sections are bolted together with butt couplings and floor supports.
- ▶ **BEARINGS:** Removable type, heavy duty ball bearings, zinc-plated, grease packed, labyrinth seal.
- ▶ **MOTOR DRIVE:** 1/2 HP, 230/460/3, 60 cycle, Super "E" right angle gear motor.
- ▶ **CAPACITY:** 300 lbs./ft. up to a maximum of 1200 lb. pallet load.

**SPECIFICATION TABLE**

■ 6 week shipment

CONVEYOR LENGTH		10'	20'	30'	40'	50'	60'	70'	80'	90'	100'
BF	Conv. Surface	UNIT WEIGHTS (lbs.) with 4" Roller Centers									
15"	12"	761	1341	1922	2502	3083	3663	4244	4824	5405	5986
21"	18"	832	1476	2119	2762	3406	4049	4692	5336	5979	6622
27"	24"	922	1646	2369	3093	3816	4539	5262	5977	6706	7435
33"	30"	998	1802	2598	3393	4189	4985	5780	6582	7379	8176
39"	36"	1075	1929	2784	3638	4493	5347	6202	7056	7915	8774
45"	42"	1156	2081	3007	3932	4857	5783	6709	7634	8568	9502
51"	48"	1226	2213	3199	4186	5173	6159	7146	8133	9132	10131
UNIT WEIGHTS (lbs.) with 6" roller centers											
15"	12"	711	1241	1772	2302	2833	3363	3894	4424	4955	5486
21"	18"	772	1356	1939	2522	3106	3680	4272	4856	5439	6022
27"	24"	842	1486	2129	2773	3416	4059	4702	5337	5986	6635
33"	30"	898	1602	2298	2993	3689	4385	5080	5789	6479	7176
39"	36"	965	1709	2454	3198	3943	4687	5432	6176	6925	7674
45"	42"	1026	1821	2617	3412	4207	5003	5799	6594	7398	8202
51"	48"	1086	1933	2779	3626	4473	5319	6166	7013	7872	8731

**OPTIONAL EQUIPMENT**

- ▶ **ZONE LENGTHS:** 3' through 10' in 4" or 6" increments as per roller centers and zone chain pitch. Frame lengths will vary with zone lengths.
- ▶ **BED:** 6-1/2" x 1-1/2" x 7 ga. and 4-1/2" x 1-1/2" x 7 ga. formed steel channel frame.
- ▶ **TREAD ROLLERS:** 1.9" dia. x 9 ga. steel, model 199S tread rollers.

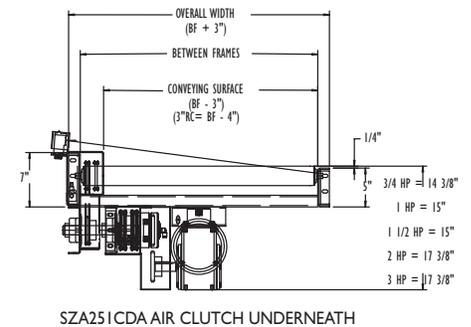
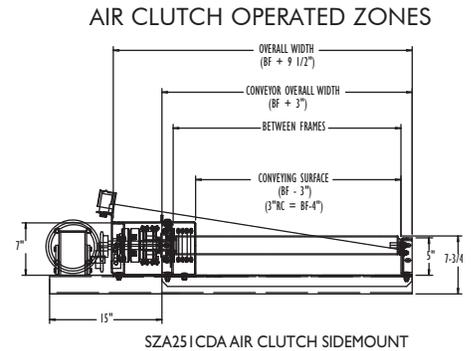
- ▶ **FLOOR SUPPORTS:** Conveyor shown with optional supports. Supports, knee braces, casters and polytier supports available. See Conveyor Accessories.
  - ▶ **SPEED:** Constant speed 20-120 FPM; DC variable speed; AC inverter variable speed. Other constant or variable speeds available. Minimum unit speed is 20 FPM for model CDA.
- NOTE:** CAPACITY CHANGES WITH SPEED.

- ▶ **MOTORS:** Available through 3 HP in Super "E", explosion proof, dirty duty, brake motor, 115/230/1, 575/3, etc.
- ▶ **DEFUSED SMARTZONE:** Photoeyes mounted below tread rollers.

# SZA251CDA | HEAVY DUTY CHAIN DRIVEN ZERO PRESSURE ACCUMULATOR

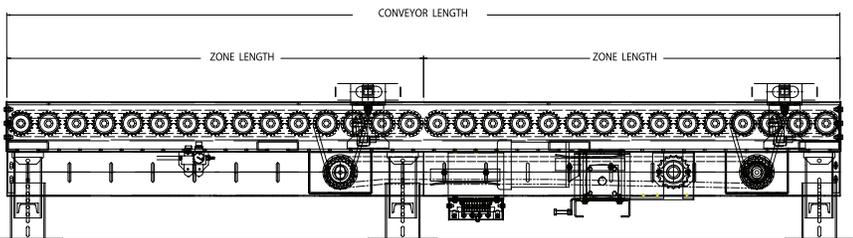


SZA251CDA SMART ZONE® is a heavy duty roll-to-roll chain driven zero pressure accumulator, designed to safely accumulate heavy products such as castings, drums, containers and heavy pallet loads in 5' zones. The Roach design incorporates photo electric sensors instead of sensor rollers which eliminates many of the problems associated with conveying wooden pallets. Products do not touch during accumulation and are singulated individually off of conveyor. SMART ZONE® is easy to install and simple to maintain.



**SMART ZONE:**

Retroflective photo eyes include a 24V DC power supply operated by a 110V AC input.



**SPECIFICATIONS**

- ▶ **TREAD ROLLERS:** 2-1/2" dia. x 11 ga. steel, model 251S.
- ▶ **CHAIN DRIVE:** Roller-to-roller No. 40 roller chain. Zone-to-zone No. 60 roller chain.
- ▶ **CENTER DRIVE:** Drive either side mounted or underside mounted (specify). Drive shafts are supported by precision, heavy duty, lubricated, ball bearing units.
- ▶ **ROLLER CENTERS:** 4" or 6" ONLY.
- ▶ **BED:** 7" x 1-1/2" x 7 ga. and 5" x 1-1/2" x 7 ga. formed steel channel frame. Bed sections bolted together with butt couplings and floor supports.
- ▶ **ACCUMULATION ZONE:** 5'-0" zone lengths, zone singulation operation, photo electric sensor controlled zones with air clutch. (60 psi max)
- ▶ **SPEED:** 35 FPM, constant.
- ▶ **CHAIN GUARD:** Chains are completely enclosed along entire length of conveyor.
- ▶ **BEARINGS:** Precision ABEC bearings.

- ▶ **FRL:** Unit is provided with filter, regulator and lubricator with 3/8" ports for 60 PSI operational pressure.
- ▶ **MOTOR DRIVE:** 3/4 HP, 230/460/3, 60 cycle, Super "E" right angle gear motor.
- ▶ **CAPACITY:** 1000 lbs./ft. up to a maximum of 3000 lb. pallet.

**SPECIFICATION TABLE**

■ 6 week shipment

CONVEYOR LENGTH		10'	20'	30'	40'	50'	60'	70'	80'	90'	100'
BF	Conv. Surface	<b>UNIT WEIGHTS (lbs.) with 4" Roller Centers</b>									
15"	12"	869	1557	2246	2934	3623	4311	5000	5688	6377	7066
21"	18"	958	1728	2497	3266	4036	4805	5574	6344	7113	7882
27"	24"	1063	1926	2789	3653	4516	5379	6242	7105	7975	8845
33"	30"	1151	2108	3057	4005	4954	5903	6851	7806	8756	9706
39"	36"	1246	2271	3297	4322	5348	6373	7399	8424	9454	10484
45"	42"	1342	2453	3565	4676	5787	6899	8011	9122	10242	11362
51"	48"	1427	2615	3802	4990	6178	7365	8553	9741	10941	12141
54"	51"	1475	2661	3936	5167	6398	7628	8859	10090	11315	12540
57"	54"	1523	2707	4070	5344	6618	7891	9165	10439	11689	12939
63"	60"	1620	2980	4339	5699	7059	8418	9778	11138	12508	13878
<b>UNIT WEIGHTS (lbs.) with 6" roller centers</b>											
15"	12"	811	1441	2073	2701	3331	3961	4591	5221	5851	6481
21"	18"	887	1587	2290	2993	3696	4399	5003	5707	6411	7117
27"	24"	963	1726	2489	3253	4016	4779	5542	6305	7078	7851
33"	30"	1039	1868	2697	3525	4354	5183	6011	6840	7674	8508
39"	36"	1116	2011	2907	3802	4698	5593	6489	7384	8288	9192
45"	42"	1192	2153	3115	4076	5037	5999	6961	7922	8896	9870
51"	48"	1267	2295	3322	4350	5308	6405	7433	8461	9495	10529
54"	51"	1305	2321	3407	4487	5513	6608	7669	8730	9809	10888
57"	54"	1343	2347	3530	4624	5718	6811	7905	8999	10123	11247
63"	60"	1420	2550	3739	4899	6051	7218	8378	9538	10732	11926

**OPTIONAL EQUIPMENT**

- ▶ **ZONE LENGTHS:** 3' through 10' in 4" or 6" increments as per roller centers and zone chain pitch. Frame lengths will vary with zone lengths.
- ▶ **BED:** 7" x 9.8 lbs./ft. and 5" x 6.7 lbs./ft. structural frames.
- ▶ **TREAD ROLLERS:** 2-9/16" x 7 ga. steel, model 297S tread rollers.

- ▶ **FLOOR SUPPORTS:** Conveyor shown with optional supports. Supports, knee braces, casters and polytier supports available. See Conveyor Accessories.

- ▶ **SPEED:** Constant speed 20-120 FPM; DC variable speed; AC inverter variable speed. Other constant or variable speeds available. Minimum unit speed is 20 FPM for model CDA.
- NOTE:** CAPACITY CHANGES WITH SPEED.

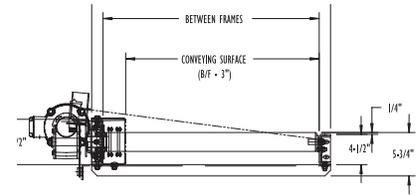
- ▶ **MOTORS:** Available through 3 HP in Super "E", explosion proof, dirty duty, brake motor, 115/230/1, 575/3, etc.
- ▶ **DEFUSED SMARTZONE:** Photoeyes mounted below tread rollers.

# SZD251CDA | HEAVY DUTY CHAIN DRIVEN ZERO PRESSURE ACCUMULATOR

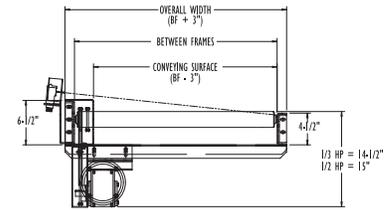


SZD251CDA SMART ZONE<sup>®</sup> is a heavy duty roll-to-roll chain driven zero pressure accumulator, designed to safely accumulate heavy products such as castings, drums, containers and heavy pallet loads in 5' zones. The Roach design incorporates photo electric sensors--instead of sensor rollers--which eliminates many of the problems associated with conveying wooden pallets. Products do not touch during accumulation and are singulated individually off of conveyor. SMART ZONE<sup>®</sup> is easy to install and simple to maintain.

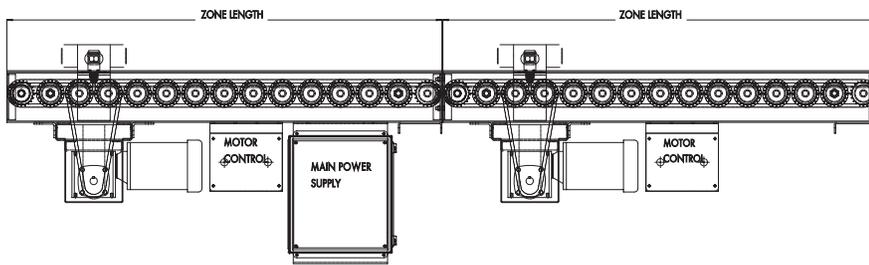
## DRIVE OPERATED ZONES



SZD192CDA SIDEMOUNT DRIVE



SZD192CDA UNDERNEATH DRIVE



## SMART ZONE:

Retroflective photo eyes include a 24V DC power supply operated by a 110V AC input.

## SPECIFICATIONS

- ▶ **TREAD ROLLERS:** 2-1/2" dia. x 11 ga. steel, model 251S.
- ▶ **CHAIN DRIVE:** Roller-to-roller No. 40 roller chain. Zone-to-zone No. 60 roller chain.
- ▶ **CENTER DRIVE:** Drive either side mounted or underside mounted (specify). Drive shafts are supported by precision, heavy duty, lubricated, ball bearing units.
- ▶ **ROLLER CENTERS:** 4" or 6" ONLY.
- ▶ **BED:** 7" x 1-1/2" x 7 ga. and 5" x 1-1/2" x 7 ga. formed steel channel frame. Bed sections bolted together with butt couplings and floor supports.
- ▶ **ACCUMULATION ZONE:** 5'-0" zone lengths, zone singulation operation, photo electric sensor controlled zones with separate drives on each zone.
- ▶ **SPEED:** 35 FPM, constant.
- ▶ **CHAIN GUARD:** Chains are completely enclosed along entire length of conveyor.
- ▶ **BEARINGS:** Precision ABEC bearings.
- ▶ **MOTOR DRIVE:** 1/2 HP, 230/460/3, 60 cycle, Super "E" right angle gear motor.
- ▶ **CAPACITY:** 1000 lbs./ft. up to a maximum of 4000 lb. pallet.
- ▶ **POWER SUPPLY PANEL:** Nema 12 enclosure with 20Amp main disconnect and contractor. Control transformer. 24vdc power supply Mounted and wired on conveyor. Customer to supply 480 V 3Ph 20Amp power, relaycontacts closure from emergency stop relay. E-stop push buttons and pull cord switches are not supplied.
- ▶ **ZONE COMPONENTS:** Line mounted starter with overload relay prewired to motor.
- ▶ **ZONE TO ZONE WIRING:** All zones prewired. Customer must reconnect cables at conveyor bed joints.

**SPECIFICATION TABLE**

■ 6 week shipment

CONVEYOR LENGTH		10'	20'	30'	40'	50'	60'	70'	80'	90'	100'
BF	Conv. Surface	UNIT WEIGHTS (lbs.) with 4" Roller Centers									
15"	12"	869	1557	2246	2934	3623	4311	5000	5688	6377	7066
21"	18"	958	1728	2497	3266	4036	4805	5574	6344	7113	7882
27"	24"	1063	1926	2789	3653	4516	5379	6242	7105	7975	8845
33"	30"	1151	2108	3057	4005	4954	5903	6851	7806	8756	9706
39"	36"	1246	2271	3297	4322	5348	6373	7399	8424	9454	10484
45"	42"	1342	2453	3565	4676	5787	6899	8011	9122	10242	11362
51"	48"	1427	2615	3802	4990	6178	7365	8553	9741	10941	12141
54"	51"	1475	2661	3936	5167	6398	7628	8859	10090	11315	12540
57"	54"	1523	2707	4070	5344	6618	7891	9165	10439	11689	12939
63"	60"	1620	2980	4339	5699	7059	8418	9778	11138	12508	13878
UNIT WEIGHTS (lbs.) with 6" Roller Centers											
15"	12"	811	1441	2073	2701	3331	3961	4591	5221	5851	6481
21"	18"	887	1587	2290	2993	3696	4399	5003	5707	6411	7117
27"	24"	963	1726	2489	3253	4016	4779	5542	6305	7078	7851
33"	30"	1039	1868	2697	3525	4354	5183	6011	6840	7674	8508
39"	36"	1116	2011	2907	3802	4698	5593	6489	7384	8288	9192
45"	42"	1192	2153	3115	4076	5037	5999	6961	7922	8896	9870
51"	48"	1267	2295	3322	4350	5308	6405	7433	8461	9495	10529
54"	51"	1305	2321	3407	4487	5513	6608	7669	8730	9809	10888
57"	54"	1343	2347	3530	4624	5718	6811	7905	8999	10123	11247
63"	60"	1420	2550	3739	4899	6051	7218	8378	9538	10732	11926

**OPTIONAL EQUIPMENT**

- ▶ **ZONE LENGTHS:** 3' through 10' in 4" or 6" increments as per roller centers and zone chain pitch. Frame lengths will vary with zone lengths.
- ▶ **BED:** 7" x 9.8 lbs./ft. and 5" x 6.7 lbs./ft. structural frames.
- ▶ **TREAD ROLLERS:** 2-9/16" x 7 ga. steel, model 297S tread rollers.

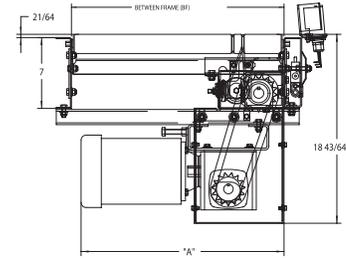
- ▶ **FLOOR SUPPORTS:** Conveyor shown with optional supports. Supports, knee braces, casters and polytier supports available. See Conveyor Accessories.
  - ▶ **SPEED:** Constant speed 20-120 FPM; DC variable speed; AC inverter variable speed. Other constant or variable speeds available. Minimum unit speed is 20 FPM for model CDA.
- NOTE:** CAPACITY CHANGES WITH SPEED.

- ▶ **MOTORS:** Available through 3 HP in Super "E", explosion proof, dirty duty, brake motor, 115/230/1, 575/3, etc.
- ▶ **DEFUSED SMARTZONE:** Photoeyes mounted below tread rollers.

# SZ796LSZ | W/PHOTOEYE CONTROLLED SMART ZONE® LINE SHAFT ZERO PRESSURE ACCUMULATOR

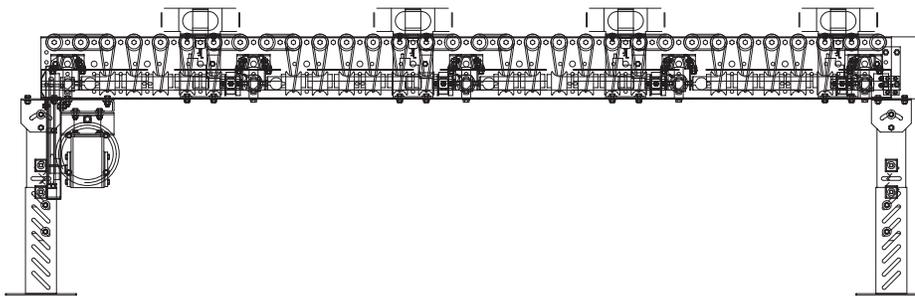


SZ796LSZ SMART ZONE® quietly accumulates a wide variety of product sizes and features NO minimum weight limitations. SMART ZONE® eliminates sensor rollers and replaces with photo electric sensors to accumulate products with previously difficult minimal weight restrictions. This zero pressure line shaft driven accumulator is ideal for numerous light to medium duty applications since curves, spurs and other modules may be driven by a single drive.



**SMART ZONE:**

Retroreflective photo eyes include a 24V DC power supply operated by a 110V AC input.



HP@ 60 FPM	"A" MAX
1/2	21"
3/4, 1	22"
1-1/2, 2	23"

**SPECIFICATIONS**

- ▶ **TREAD ROLLERS:** 1.9" dia. x 16 ga. galv. steel, model 196G grooved.
- ▶ **DRIVE BELT:** 3/16" dia., polyurethane belts. Nominal 15 lbs. per roller drive.
- ▶ **DRIVE SHAFT:** 1" dia. C1018 cold rolled steel shaft.
- ▶ **COUPLINGS:** Couplings located both ends (type "A"), one end only (type "B" or "C") or none (type "D"). See 'line shaft coupling chart' opposite page, and specify.
- ▶ **CENTER DRIVE:** Located approximately 16-1/2" from end of bed section on 4" RC; 18" on 3" and 6" RC.
- ▶ **SPEED:** 60 FPM, constant.

- ▶ **ACCUMULATION:** Zone singulation operation; 2'-0" zone length; zones are pneumatically actuated using photo electric sensors.
- ▶ **BEARINGS:** All bearings are precision, lubricated, ball bearing units with composite housings.
- ▶ **BED:** 7" x 1-1/2" x 12 ga. formed steel channel frame. Bed sections attached with splice plates and floor supports.
- ▶ **FRL:** Unit is provided with filter, regulator, lubricator with 1/4" ports.
- ▶ **PNEUMATIC ACTUATION:** Maximum air line pressure should not exceed 30 PSI.

- ▶ **MOTOR DRIVE:** 1/2 HP, 230/460/3, 60 cycle, Super "E" right angle gear motor.
- ▶ **ROLLER CHAIN:** Drive shaft is driven by No. 50 chain. Chain take-up provided on motor base.
- ▶ **CAPACITY:** See technical section for load capacity rating.

SPECIFICATION TABLE

■ 3 week shipment

CONVEYOR LENGTH		10'	20'	30'	40'	50'	60'	70'	80'	90'	100'	Deduct
BF	OAW	UNIT WEIGHTS (lbs.) with 3" Roller Centers (For other centers, deduct weights below)										Per Foot
15"	18"	551	928	1306	1683	2061	2438	2816	3193	3571	3948	38
19"	21"	589	1003	1417	1831	2244	2658	3072	3486	3900	4313	41
21"	24"	612	1049	1486	1923	2360	2797	3234	3671	4108	4545	44
25"	28"	646	1130	1613	2096	2580	3063	3546	4029	4513	4996	48
27"	30"	672	1178	1684	2191	2697	3203	3710	4216	4722	5229	51
33"	36"	724	1300	1876	2452	3027	3603	4179	4755	5331	5906	58
39"	42"	788	1504	2079	2724	3369	4015	4660	5305	5950	6595	72

Deduct the following weights (lbs.) for other than 3" centers

Tread Roller Centers	15" BF		19" BF		21" BF		25" BF		27" BF		33" BF		39" BF	
	Per 5'	Per 10'												
4"	-14	-28	-17	-34	-19	-37	-21	-42	-23	-45	-27	-53	-31	-62
6"	-18	-36	-34	-68	-37	-74	-42	-84	-45	-90	-53	-106	-62	-124

OPTIONAL EQUIPMENT

- ▶ **SIDE MOUNTED DRIVE:** Provides overall conveyor height of 10".
- ▶ **ACCUMULATION ZONES:** 18" and 30" long zones available, depending on roller centers.
- ▶ **FLOOR SUPPORTS:** Conveyor shown with optional supports. Supports, knee braces, casters and polytner supports available. See Conveyor Accessories.
- ▶ **CEILING HANGERS:** 5/8" dia. threaded rod with hardware to attach rods to conveyor. Provides 6' clearance between ceiling and TOR (furnished in place of floor supports). See Conveyor Accessories.

- ▶ **CONVEYOR SPEED:** Constant speed 15-120 FPM; DC variable speed; AC inverter variable speed. MINIMUM operating speed for line shaft conveyor is 30 FPM.
- ▶ **SLUG RELEASE:** Products may be slug released rather than individual product release in normal zone singulation; accumulation mode will not be disturbed when slug release option utilized.

- ▶ **MOTORS:** Available through 2 HP in Super "E", explosion proof, dirty duty, 115/230/1, 575/3, etc.
- ▶ **DEFUSED SMARTZONE:** Photoeyes mounted below tread rollers.

LINE SHAFT COUPLING CHART

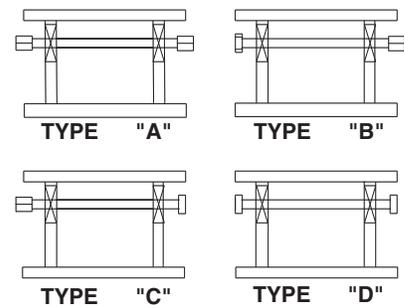


PHOTO SENSOR MOUNT

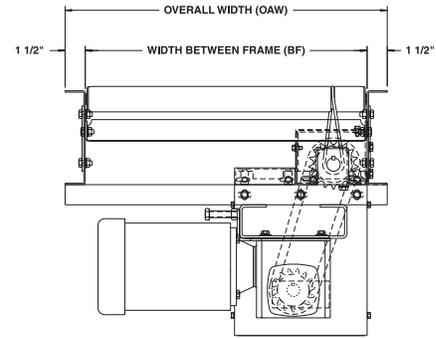


LINE SHAFT BEARING HOUSING

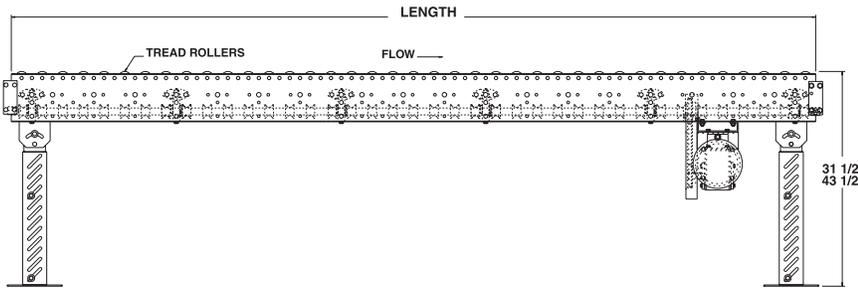
# 738LS | LIGHT DUTY LINE SHAFT DRIVEN LIVE ROLLER



Model 738LS has gained widespread usage with its unique design. Curves, spurs and a number of accessories may be driven by a SINGLE drive.



BF	10"	16"	22"
OAW	13"	19"	25"
Length	Unit Weights (lbs.) W/1-1/2" Roller Centers*		
10'	403	502	601
20'	614	776	939
30'	825	1051	1276
40'	1036	1325	1614
50'	1247	1599	1952
60'	1458	1874	2289
70'	1669	2148	2627
80'	1880	2422	2965
90'	2091	2697	3302
100'	2302	2971	3640
Deduct Per Foot	21	27	34



\*For other centers, deduct the following (RC/lbs. per ft.):  
 10" BF--3" RC/4 lbs.; 4" RC/5 lbs.; 6" RC/6 lbs.  
 16" BF--3" RC/6 lbs.; 4" RC/7.5 lbs.; 6" RC/9 lbs.  
 22" BF--3" RC/8 lbs.; 4" RC/10 lbs.; 6" RC/12 lbs.

## SPECIFICATIONS

- ▶ **TREAD ROLLERS:** 1-3/8" dia. x 18 ga. galv. steel steel, model 138G w/ 5/16" hex, grooved.
- ▶ **DRIVE BELT:** 1/8" dia., polyurethane belts. Nominal 10 lbs. per roller drive.
- ▶ **DRIVE SHAFT:** 1" dia. C1018 cold rolled steel shaft.
- ▶ **COUPLINGS:** Couplings located both ends (type "A"), one end only (type "B" or "C") or none (type "D"). See 'line shaft coupling chart' on page 49 & specify.
- ▶ **CENTER DRIVE:** Reversible drive; located approx. 18" from end of bed section for 3" and 6" RC; 16-1/2" for 4" RC.
- ▶ **BED:** 7" x 1-1/2" x 12 ga. formed steel channel frame. Bed sections attached w/ splice plates and floor supports.
- ▶ **SPEED:** 60 FPM, constant.
- ▶ **BEARINGS:** Precision, lubricated, ball bearing units with composite housings.
- ▶ **MOTOR DRIVE:** 1/2 HP, 230/460/3, 60 cycle, Super "E" right angle gear motor.
- ▶ **ROLLER CHAIN:** Drive shaft is driven by No. 50 chain. Chain take-up provided on motor base.
- ▶ **CAPACITY:** See Technical Section for load capacity rating.
- ▶ **ELECTRICAL CONTROLS:** Optional.

HP@ 60 FPM	"A" MAX
1/2	21"
3/4, 1	22"
1-1/2, 2	23"

■ 3 week shipment

## OPTIONAL EQUIPMENT

**SIDE MOUNTED DRIVE:** With 10" minimum elevation.

**FLOOR SUPPORTS:** Conveyor shown with optional supports. Supports, knee braces, casters, polytier supports & ceiling hangers available. See Conveyor Accessories.

**SPEED:** Constant 15-120 FPM, or variable (specify). MINIMUM operating speed for line shaft conveyor is 30 FPM. **NOTE: CAPACITY CHANGES WITH SPEED.**

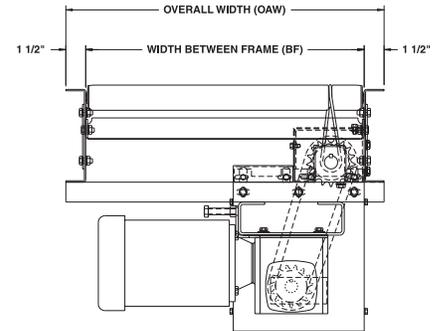
**MOTORS:** Available through 2 HP in Super "E", explosion proof, dirty duty, 115/230/1, 575/3.

**ELECTRICAL CONTROLS:** Manual start/stop push button switch; magnetic starter; others available.

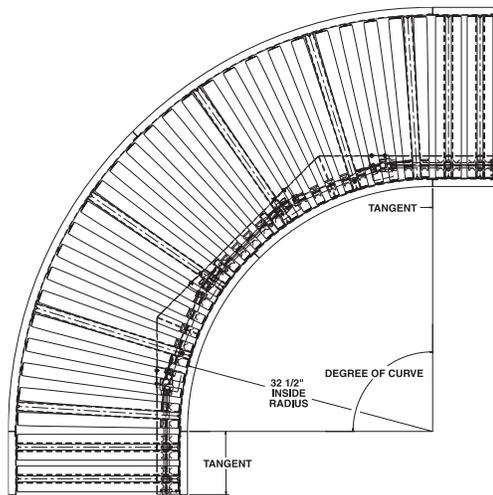
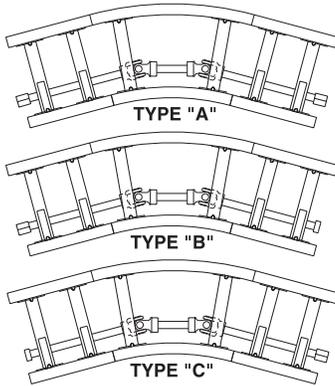
# 738LSC | LIGHT DUTY LINE SHAFT DRIVEN CURVE MODULE



Model 738LSC features tapered rollers to help product maintain orientation. NO drive is required since it is designed to be driven from 738LS straight line shaft driven sections and includes close roller centers as a standard feature.



### LINE SHAFT CURVE COUPLINGS



CURVE	90°	60°	45°	30°
	WT. (lbs)	WT. (lbs)	WT. (lbs)	WT. (lbs)
10"	219	167	155	132
16"	251	202	185	156
22"	290	242	213	183

\*Roller quantities listed for tapered rollers only. 1'-0" long tangents include 4 rollers and 1'-6" long tangents include 6 rollers per tangent.

### SPECIFICATIONS

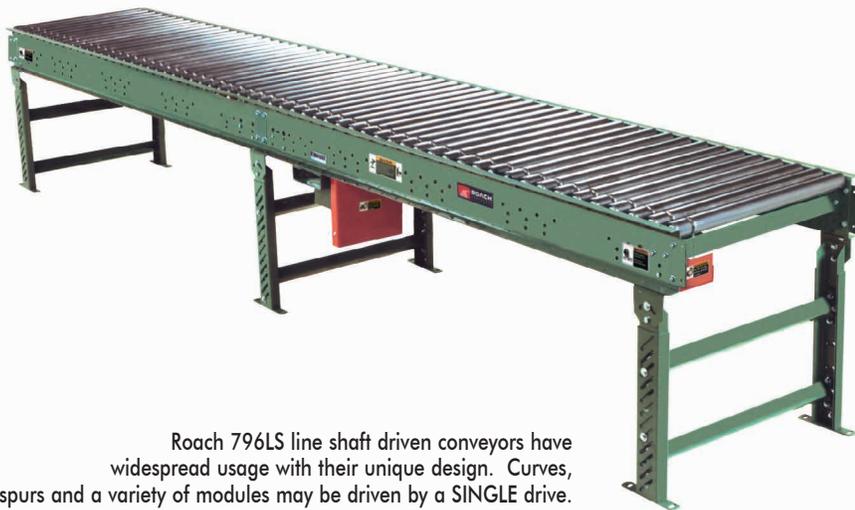
- ▶ **TREAD ROLLERS:** 1.9" dia. to 1-3/8" dia. x 16 ga. tapered steel, model 138T w/ 5/16" hex, grooved.
- ▶ **DRIVE BELT:** 3/16" dia., polyurethane belts. Nominal 7.5 lbs. per roller drive.
- ▶ **DRIVE SHAFT:** 1" dia. C1018 cold rolled steel shaft, located on inside radius. **NOTE:** Spools are keyed to provide positive drive (designed not to slip on drive shaft).
- ▶ **COUPLINGS:** Couplings located both ends (type "A") or one end only (type "B" or "C"). See 'line shaft curve couplings' above and specify.
- ▶ **UNIVERSAL JOINTS:** 4 per 90° and 60° curve; 2 per 45° and 30° curve.
- ▶ **BEARINGS:** Precision, lubricated, ball bearing units with composite housings. 6 bearings per 90° and 60° curve; 4 per 45° and 30°.
- ▶ **BED:** 7" x 1-1/2" x 12 ga. formed steel channel frame.
- ▶ **TANGENTS:** 1'-0" both ends on 60° and 90°; 1'-6" both ends on 30° and 45°. 1'-0" infeed, 1'-0" discharge and no center tangent on 180°. Tangent roller centers 3" RC.
- ▶ **MOTOR DRIVE:** Unit is designed to be driven by 738LS.
- ▶ **ELECTRICAL CONTROLS:** Optional.

### OPTIONAL EQUIPMENT

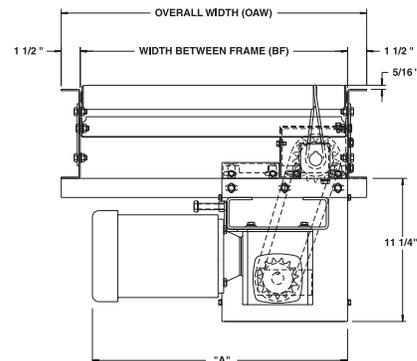
- FLOOR SUPPORTS:** Conveyor shown with optional supports. Supports, knee braces, casters, polytier supports & ceiling hangers available. See Conveyor Accessories.
- GUARD RAILS:** 1-3/4" x 1" formed channel (model GC), adjusts horizontally to 8" wider than roller and vertically to 6" above roller; formed steel fixed (model FSG in 2", 4" and 6" heights; fixed channel (model FC); 1-1/2" angle (model GA1-1/2). See Conveyor Accessories.
- MOTORS:** 1/2 HP 230v/460v/3 Super "E" motor with 24" tangeant (req) in place of STD tangeant.

■ 3 week shipment

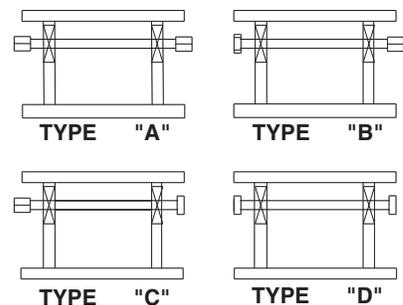
## 796LS | LINE SHAFT DRIVEN LIVE ROLLER



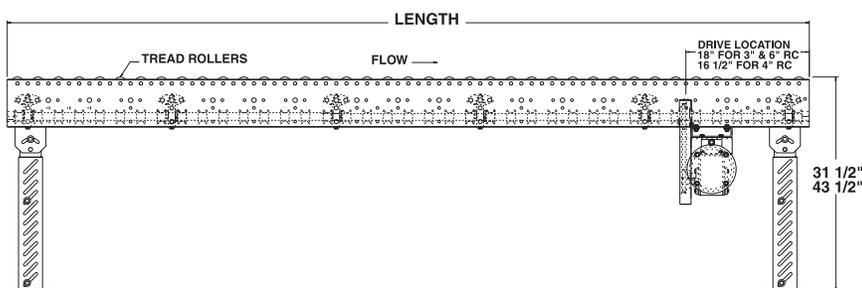
Roach 796LS line shaft driven conveyors have widespread usage with their unique design. Curves, spurs and a variety of modules may be driven by a SINGLE drive.



### LINE SHAFT COUPLING CHART



HP@ 60 FPM	"A" MAX
1/2	21"
3/4, 1	22"
1-1/2, 2	23"



### SPECIFICATIONS

- ▶ **TREAD ROLLERS:** 1.9" dia. x 16 ga. galv. steel, model 196G grooved.
- ▶ **DRIVE BELT:** 3/16" dia., polyurethane belts. Nominal 15 lbs. per roller drive.
- ▶ **DRIVE SHAFT:** 1" dia. C1018 cold rolled steel shaft.
- ▶ **COUPLINGS:** Couplings located both ends (type "A"), one end only (type "B" or "C") or none (type "D"). See 'line shaft coupling chart' and specify.

- ▶ **CENTER DRIVE:** Reversible drive; located approximately 18" from end of bed section for 3" and 6" RC; 16-1/2" for 4"RC.
- ▶ **BEARINGS:** Precision, lubricated, ball bearing units with composite housings.
- ▶ **SPEED:** 60 FPM, constant.
- ▶ **BED:** 7" x 1-1/2" x 12 ga. formed steel channel frame. Bed sections attached with splice plates and floor supports.

- ▶ **MOTOR DRIVE:** 1/2 HP, 230/460/3, 60 cycle, Super "E" right angle gear motor.
- ▶ **ROLLER CHAIN:** Drive shaft is driven by No. 50 chain. Chain take-up provided on motor base.
- ▶ **CAPACITY:** See Technical Section for load capacity rating.
- ▶ **ELECTRICAL CONTROLS:** Optional.

SPECIFICATION TABLE

CONVEYOR LENGTH		10'	20'	30'	40'	50'	60'	70'	80'	90'	100'	Deduct
BF	OAW	UNIT WEIGHTS (lbs.) with 3" Roller Centers (For other centers, deduct weights below)										Per Foot
15"	18"	319	561	803	1044	1286	1528	1770	2011	2253	2495	24
19"	22"	349	617	886	1154	1423	1691	1960	2228	2497	2765	27
21"	24"	363	645	927	1209	1491	1773	2054	2336	2618	2900	28
25"	28"	393	701	1010	1319	1627	1936	2244	2553	2861	3170	31
27"	30"	408	729	1051	1373	1695	2017	2339	2661	2983	3305	32
33"	36"	452	814	1176	1538	1900	2262	2624	2986	3348	3710	36
39"	42"	496	898	1300	1702	2104	2507	2909	3311	3713	4115	40

Deduct the following weights (lbs.) for other than 3" centers

Tread Roller Centers	15" BF		19" BF		21" BF		25" BF		27" BF		33" BF		39" BF	
	Per 5'	Per 10'												
4"	-14	-28	-17	-34	-19	-37	-21	-42	-23	-45	-27	-53	-31	-62
6"	-28	-56	-34	-68	-37	-74	-42	-84	-45	-90	-53	-106	-62	-124

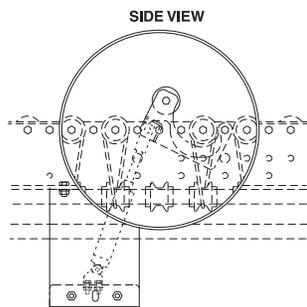
■ 3 week shipment

OPTIONAL EQUIPMENT

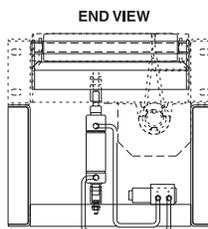
- ▶ **SIDE MOUNTED DRIVE:** Provides overall conveyor height of 10".
- ▶ **FLOOR SUPPORTS:** Conveyor shown with optional supports. Supports, knee braces, casters and polytier supports available. See Conveyor Accessories.
- ▶ **CEILING HANGERS:** 5/8" dia. threaded rod with hardware to attach rods to conveyor. Provides 6' clearance between ceiling and TOR (furnished in place of floor supports). See Conveyor Accessories.

- ▶ **CONVEYOR SPEED:** Constant speed 15-120 FPM; DC variable speed; AC inverter variable speed. MINIMUM operating speed for line shaft conveyor is 30 FPM.
- ▶ **GUARD RAILS:** 1-3/4" x 1" formed channel (model GC), adjusts horizontally to 8" wider than roller and vertically to 6" above roller; formed steel fixed (model FSG in 2", 4" and 6" heights; fixed channel (model FC); 1-1/2" angle (model GA1-1/2). See Conveyor Accessories.

- ▶ **MOTORS:** Available through 2 HP in Super "E", explosion proof, dirty duty, 115/230/1, 575/3, etc.
- ▶ **ELECTRICAL CONTROLS:** Magnetic starter (one direction or reversible); One direction manual starter; Momentary start/stop push button station; Forward/reversing /stop push button. Mounting and pre-wiring for units up to 12' long.



OPTIONAL PNEUMATIC ROLLER STOP



LINE SHAFT BEARING HOUSING

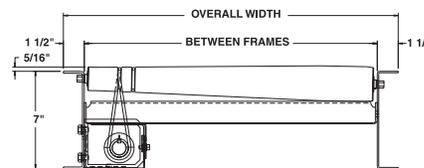
# 796LSC | LINE SHAFT DRIVEN CURVE MODULE



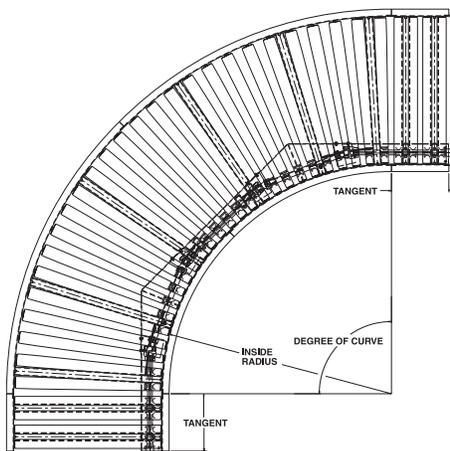
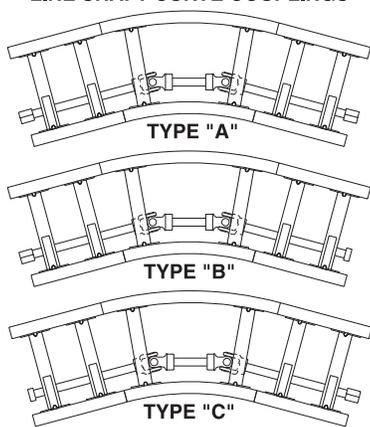
Roach line shaft driven curve, module 796LSC, features tapered rollers to help maintain product orientation and is designed to be driven from 796LS line shaft driven conveyor, thus reducing the overall number of drives required.

**SPECIFY MODEL NUMBER PER**

**EXAMPLE**  
**796LSC090-21-1212\***  
 796LSC (curve degree)-(between frames)-(left tangent length, right tangent length)  
 Available in 30°, 45°, 60°, 90° and 180°.  
 \*Not required for 180° curves. ONLY specify center tangent length if center tangent required.



**LINE SHAFT CURVE COUPLINGS**



**OPTIONAL EQUIPMENT**

**FLOOR SUPPORTS:** Conveyor shown with optional supports. See Conveyor Accessories.

**GUARD RAILS:** See Conveyor Accessories.

**MOTORS:** 1/2 HP 230v/460v/3 Super "E" motor with 24" tangent (req) in place of STD tangent.

**SPECIFICATIONS**

► **TREAD ROLLERS:** 2-1/2" dia. to 1-11/16" dia. x 14 ga. steel tapered rollers, model 254T.

► **DRIVE BELT:** 3/16" dia., polyurethane belts. Nominal 15 lbs. per roller drive.

► **DRIVE SHAFT:** 1" dia. C1018 cold rolled steel shaft, located on inside radius.

**NOTE:** Spools are keyed to provide positive drive (designed not to slip on drive shaft).

► **COUPLINGS:** Couplings located both ends (type "A") or one end only (type "B" or "C"). See 'line shaft curve couplings' above and specify.

► **TANGENTS:** 1'-0" both ends on 60° and 90°; 1'-6" both ends on 30° and 45°. 1'-0" infeed, 1'-0" discharge and no center tangent on 180°. Tangent roller centers 3" RC.

► **BEARINGS:** Precision, lubricated, ball bearing units with steel housings. 6 per 90° and 60° curve; 4 per 45° and 30°.

► **UNIVERSAL JOINTS:** 4 per 90° and 60° curve; 2 per 45° and 30° curve.

► **BED:** 7" x 1-1/2" x 12 ga. formed steel channel frame.

► **MOTOR DRIVE:** Driven by 796LS.

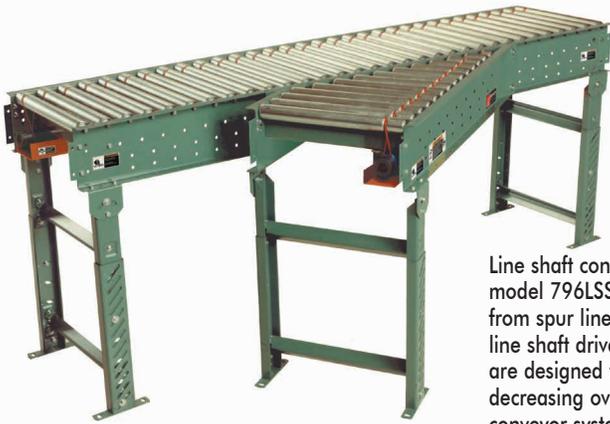
BF	INSIDE RADIUS	IR/RC OR/RC	ROLLER CENTERS			
			30°	45°	60°	90°
15"	32-1/2"	IR/RC OR/RC	2.84"	2.84"	2.84"	2.84"
			4.15"	4.15"	4.15"	4.15"
19"	32-1/2"	IR/RC OR/RC	2.84"	2.84"	2.84"	2.84"
			4.49"	4.49"	4.49"	4.49"
21"	32-1/2"	IR/RC OR/RC	2.84"	2.84"	2.84"	2.84"
			4.67"	4.67"	4.67"	4.67"
25"	32-1/2"	IR/RC OR/RC	2.84"	2.84"	2.84"	2.84"
			5.02"	5.02"	5.02"	5.02"
27"	32-1/2"	IR/RC OR/RC	2.84"	2.84"	2.84"	2.84"
			5.19"	5.19"	5.19"	5.19"
33"	48"	IR/RC OR/RC	3.14"	2.90"	3.14"	2.90"
			5.30"	4.89"	5.30"	4.89"
39"	48"	IR/RC OR/RC	3.14"	2.90"	3.14"	2.90"
			5.69"	5.26"	5.69"	5.26"

CURVE	180°		90°		60°		45°		30°	
	TAPERED ROLLERS*	WT. (lbs.)								
15"	36	404	18	229	12	180	9	169	6	146
19"	36	498	18	280	12	206	9	200	6	169
21"	36	545	18	305	12	210	9	216	6	180
25"	36	639	18	355	12	238	9	247	6	202
27"	36	687	18	381	12	250	9	262	6	214
33"	52	828	26	456	16	323	13	309	8	247
39"	52	970	26	532	16	370	13	355	8	281

■ 3 week shipment

\*Roller quantities in tangents: 1'-0" = 4 rollers; 1'-6" = 6 rollers per tangent.

# 796LSS | LINE SHAFT CONVERGING SPUR MODULE



Line shaft converging spur modules, model 796LSS, allow product to flow from spur lines and merge onto straight line shaft driven conveyor. Spur modules are designed to be driven by 796LS, thus decreasing overall number of drives in the conveyor system.

**SPECIFY MODEL NUMBER PER**

**EXAMPLE**

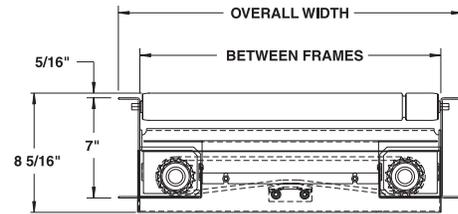
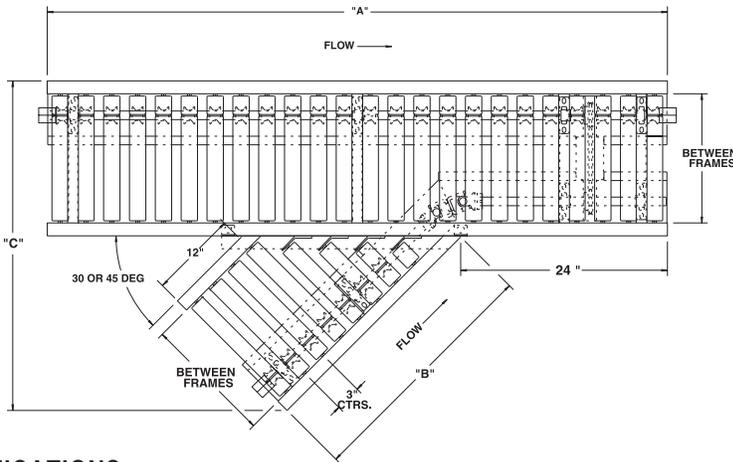
**796LSS-45-21-R**

796LSS (spur degree)-(between frames)-(left or right)

Available in 30° or 45°. Specify 796LSSO for spur module only less mainline module (similar to photo below).



Model 796LSSOX, spur only with powered crossover, shown above.



BF	15"	19"	21"	25"	27"	33"	39"
SPUR	UNIT WEIGHTS (lbs.)						
45°	212	268	296	351	379	463	546
30°	226	272	296	342	365	435	604

**SPECIFICATIONS**

- ▶ **TREAD ROLLERS:** 1.9" dia. x 16 ga. galv. steel, model 196G grooved, 3" centers.
- ▶ **DRIVE BELT:** 3/16" dia., polyurethane belts. Nominal 15 lbs. per roller drive.
- ▶ **DRIVE SHAFT:** 1" dia. C1018 cold rolled steel shaft. **NOTE:** Spools in spur section only are keyed to provide positive drive (designed not to slip on drive shaft).
- ▶ **COUPLINGS:** Couplings located

both ends or one end only. Specify where couplings required.

- ▶ **BED:** 7" x 1-1/2" x 12 ga. formed steel channel frame. Short side of spur is always 12" overall length.
- ▶ **BEARINGS:** Precision, lubricated, ball bearing units with composite housings.
- ▶ **MOTOR DRIVE:** Unit is designed to be driven by 796LS.

**ROLLER CHAIN:** Spur driven via crossover with No. 40 chain.

BF	30° SPUR			45° SPUR		
	"A"	"B"	"C"	"A"	"B"	"C"
15"	6'	40-7/8"	38-3/8"	6'	28-5/8"	38-1/4"
19"	8'	47-3/4"	45-7/8"	8'	32-5/8"	45-1/8"
21"	8'	51-1/4"	49-5/8"	8'	34-5/8"	48-1/2"
25"	8'	58-1/8"	57-1/8"	8'	38-5/8"	55-3/8"
27"	8'	61-5/8"	60-3/4"	8'	40-5/8"	58-3/4"
33"	10'	72"	72"	10'	46-5/8"	69"
39"	10'	82-3/8"	83-1/4"	10'	52-5/8"	79-1/4"

■ 4 week shipment

**OPTIONAL EQUIPMENT**

**FLOOR SUPPORTS:** Conveyor shown with optional supports. Supports, knee braces, casters, polytier supports & ceiling hangers available. See Conveyor Accessories.

**GUARD RAILS:** 1-3/4" x 1" formed channel (model GC), adjusts horizontally to 8" wider than roller and vertically to 6" above roller; formed steel fixed (model FSG in 2", 4" and 6" heights; fixed channel (model FC); 1-1/2" angle (model GA1-1/2).

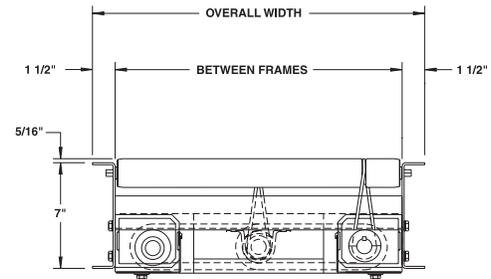
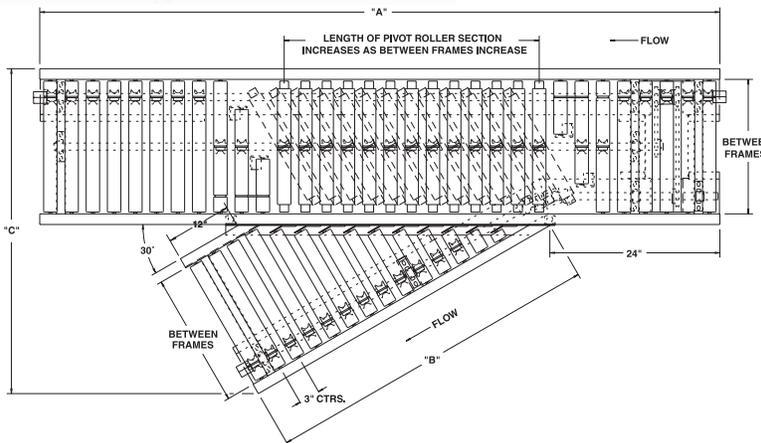
See Conveyor Accessories.

**NOTE:** Specify "right hand" or "left hand". To determine hand of spur, refer to Technical Section.

# 796LSDS | LINE SHAFT DIVERGING SWITCH MODULE



796LSDS is used in diverging applications where line shaft conveyor is suitable. The pivot section of rollers, pneumatically actuated, skews to divert packages onto spur quickly and efficiently.



### OPTIONAL EQUIPMENT

**FLOOR SUPPORTS:** Conveyor shown with optional supports. Supports, knee braces, casters, polytier supports & ceiling hangers available. See Conveyor Accessories.

**GUARD RAILS:** 1-3/4" x 1" formed channel (model GC), adjusts horizontally to 8" wider than roller and vertically to 6" above roller; formed steel fixed (model FSG in 2", 4" and 6" heights; fixed channel (model FC); 1-1/2" angle (model GA1-1/2). See Conveyor Accessories.

### SPECIFICATIONS

► **TREAD ROLLERS:** 1.9" dia. x 16 ga. galv. steel, model 196G grooved.

► **DRIVE BELT:** 3/16" dia., polyurethane belts. Nominal 15 lbs. per roller drive.

► **DRIVE SHAFT:** 1" dia. C1018 cold rolled steel shaft. NOTE: Spools in spur and spools in pivot roller section are keyed to provide positive drive (designed not to slip on drive shaft).

► **COUPLINGS:** Couplings located both ends or one end only. Specify where couplings required.

► **BED:** 7" x 1-1/2" x 12 ga. formed steel channel frame. Short side of spur is always 12" overall length.

► **ROLLER CHAIN:** Spur driven via crossover with No. 40 chain.

► **BEARINGS:** Precision, lubricated, ball bearing units with composite housings.

► **PNEUMATICALLY ACTUATED:** Diverging section of rollers is pneumatically actuated utilizing 60PSI maximum.

► **MOTOR DRIVE:** Unit is designed to be driven by 796LS.

► **DIRECTION OF FLOW:** Specify right hand or left hand. To determine hand of spur, refer to pg. 136 in technical section.

► **MINIMUM PACKAGE SIZE:** Consult factory for minimum package size (minimum size may vary based on conveyor width).

BF	"A"	"B"	"C"	WT. (lbs.)
15"	6'-0"	40-7/8"	38-3/8"	290
19"	8'-0"	47-3/4"	45-7/8"	310
21"	8'-0"	51-1/4"	49-5/8"	325
25"	8'-0"	58-1/8"	57-1/8"	380
27"	8'-0"	61-5/8"	60-3/4"	526
33"	10'-0"	72"	72"	586
39"	10'-0"	82-3/8"	83-1/4"	678

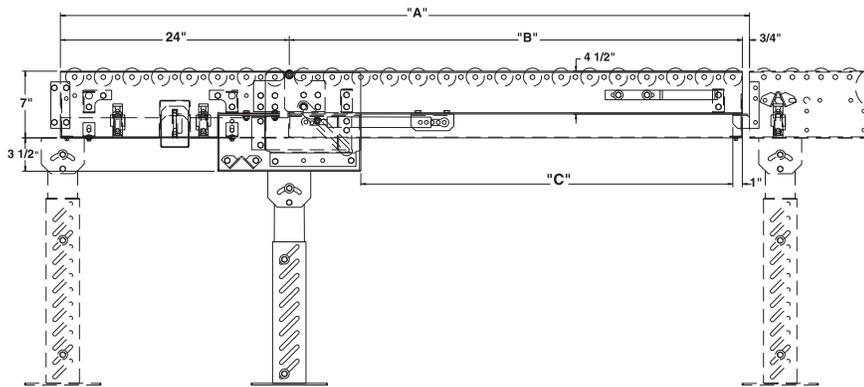
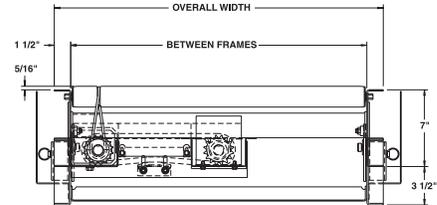
■ 4 week shipment

NOTE: This unit is not designed for high-rate sortation. Consult factory for high-rate applications.

# 796LSG | LINE SHAFT GATE MODULE



Model 796LSG offers the ultimate versatility--it is driven by 796LS so no drive is required and it offers operator accessibility eliminating dangerous walk-overs.



### OPTIONAL EQUIPMENT

**FLOOR SUPPORTS:** Conveyor shown with optional supports. Supports, knee braces, casters, polytyer supports & ceiling hangers available. See Conveyor Accessories.

**GUARD RAILS:** Consult factory for guard rails to be used with line shaft gate module.

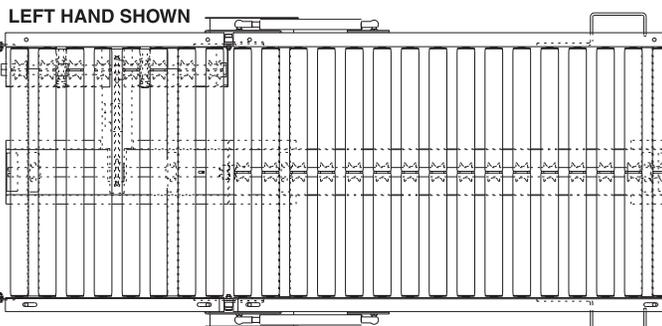
### SPECIFICATIONS

- ▶ **TREAD ROLLERS:** 1.9" dia. x 16 ga. galv. steel, model 196G grooved.
- ▶ **DRIVE BELT:** 3/16" dia., polyurethane belts. Nominal 15 lbs. per roller drive.
- ▶ **DRIVE SHAFT:** 1" dia. C1018 cold rolled steel shaft, located on long side of spur.
- ▶ **COUPLINGS:** Couplings located on horizontal sections only.
- ▶ **LIFT:** Gas cylinder provides assist for raising/lowering.
- ▶ **BEARINGS:** Precision, lubricated, ball bearing units with composite housings.

- ▶ **BED:** 4-1/2" x 1-1/2" x 10 ga. formed steel channel frame on actual lift gate; 7" x 1-1/2" x 12 ga. on 2' horizontal section.
- ▶ **MOTOR DRIVE:** Unit is designed to be driven by 796LS.
- ▶ **SPECIFY HAND:** Specify if gate is left hand or right hand.

GATE LENGTHS/OPENINGS			
GATE	"A"	"B"	"C"
5'	60-1/4"	35-1/2"	26-7/8"
6'	72-1/4"	47-1/2"	38-7/8"
7'	84-1/4"	59-1/2"	50-7/8"

■ 4 week shipment

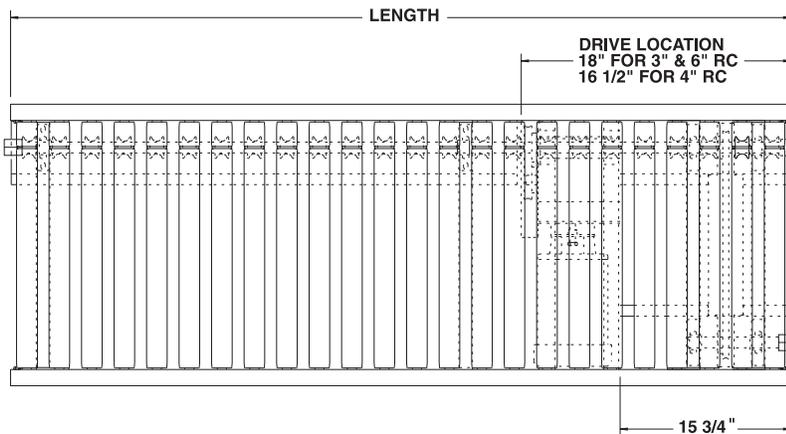
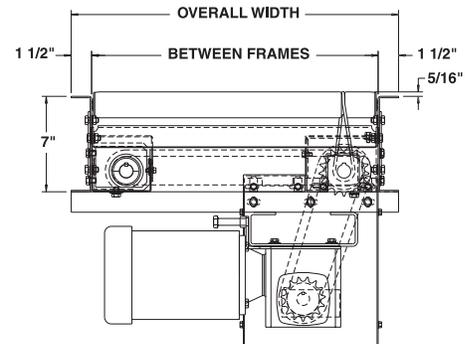


# 796LSX | LINE SHAFT CROSS-OVER MODULE



Roach cross-over module 796LSX was designed to offer a standard component to eliminate confusion over cross-overs. Available in 2'-10' lengths. Roach model 796LSX is the only component required to cross over drive shaft.

**SPECIFY MODEL NUMBER PER EXAMPLE 796LSX-21-3-10-R**  
 796LSX-(between frames)-(roller centers)-(length)-(left or right)



RC	3"	4"	6"	3"	4"	6"
BF	10' UNIT WEIGHTS			UNIT WEIGHTS / FT.		
15"	455	427	389	26	23	20
19"	487	453	419	29	25	22
21"	507	470	433	31	27	24
25"	536	494	451	35	31	27
27"	558	513	468	37	33	28
33"	601	548	495	43	39	32
39"	657	595	533	49	43	37

## SPECIFICATIONS

- ▶ **TREAD ROLLERS:** 1.9" dia. x 16 ga. galv. steel, model 196G grooved.
- ▶ **DRIVE BELT:** 3/16" dia., polyurethane belts. Nominal 15 lbs. per roller drive.
- ▶ **DRIVE SHAFT:** 1" dia. C1018 cold rolled steel shaft.
- ▶ **COUPLINGS:** Couplings located both ends or one end only. Specify where couplings required.
- ▶ **BEARINGS:** Precision, lubricated, ball bearing units with composite housings.
- ▶ **SPEED:** 60 FPM constant.
- ▶ **BED:** 7" x 1-1/2" x 12 ga. formed steel channel frame.
- ▶ **MOTOR DRIVE:** 1/2 HP, 230/460/3, 60 cycle, Super "E" right angle gear motor.
- ▶ **CROSS OVER DIRECTION:** Specify "cross over to right hand" or "cross over to left hand".
- ▶ **ELECTRICAL CONTROLS:** Optional.

## OPTIONAL EQUIPMENT

**FLOOR SUPPORTS:** Conveyor shown with optional supports. Supports, knee braces, casters, polytier supports & ceiling hangers available. See Conveyor Accessories.

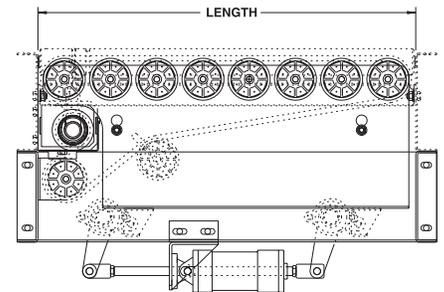
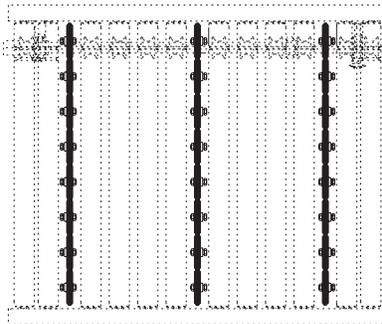
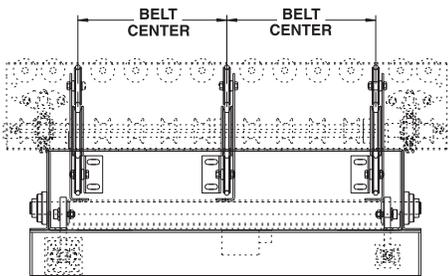
**GUARD RAILS:** 1-3/4" x 1" formed channel (model GC), adjusts horizontally to 8" wider than roller and vertically to 6" above roller; formed steel fixed (model FSG in 2", 4" and 6" heights; fixed channel (model FC); 1-1/2" angle (model GA1-1/2). See Conveyor Accessories.

■ 3 week shipment

# RBT3 | 3-STRAND 90° ROUND BELT TRANSFER



Model RBT3 provides an excellent method of transferring up to 100# product at 90° intervals. And, no drive is necessary when mounted into Roach line shaft driven conveyor. Each unit shown mounted in optional line shaft driven conveyor. Model at right includes optional frame cut-outs and blue paint.



## SPECIFICATIONS

- ▶ **TRANSFER ARM:** 10 ga. formed channel.
- ▶ **TRANSFER BELT:** 3/8" dia. round polyurethane belt.
- ▶ **LENGTHS:** Transfer designed to mount in 796LS line shaft conveyors 15"-39" BF.
- ▶ **BELT CENTERS:** 12"
- ▶ **ONE DIRECTION FLOW:** Transfers product in one direction.
- ▶ **TAKE-UP:** Adjustable sheaves provides take-up of transfer belt.
- ▶ **BEARINGS:** Heavy duty, lubricated, ball bearing units with cast iron housings.
- ▶ **BELT SPEED:** Driven at 150% of speed as powered section transfer is mounted in.

- ▶ **LIFT:** 3/4" positive lift.
  - ▶ **MOTOR DRIVE:** Optional.
  - ▶ **CAPACITY:** 100 lbs.
  - ▶ **AIR CONTROLS:** Air cylinder with single solenoid valve. (60-80 PSI required)
  - ▶ **FLOOR SUPPORTS:** Transfer is designed to attach to 796LS/738LS conveyors w/ mounting hardware integral feature of transfer.
- NOTE:** Specify twist (clockwise or counter clockwise) for drive bands on line shaft conveyor (model LS or LSA) that transfer mounts in. Consult factory.

BF	WT. (lbs.)	BF	WT. (lbs.)
15"	149	33"	186
21"	165	39"	204

## OPTIONAL EQUIPMENT

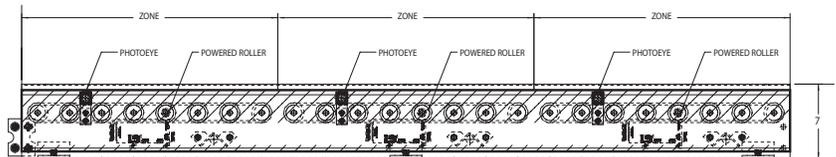
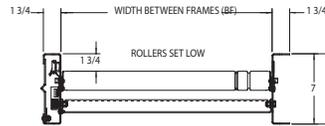
- STRANDS:** 2 and 4
- BELT CENTER:** 18" and 24" with 4" centerline minimum.
- MOTOR DRIVE:** 1/2 HP, 230/460/3, 60 cycle, Super "E" right angle gear motor. Other HP and characteristics available such as TEFC, explosion proof, dirty duty, brake motor, 115/230/1, 575/3.
- DIRECTION OF FLOW:** Reversible.
- BELT SPEED:** For some speed changes an optional drive may be required. Consult factory.

■ 3 week shipment

# 796PRA | PHOTOEYE CONTROLLED POWERED ROLLER ZERO PRESSURE ACCUMULATOR ROLLERS SET LOW



The Powered Roller Accumulator conveyor has revolutionized the automated conveyor industry. Motorized rollers drive the conveyors eliminating the need for drive belts, chains or line shafts.



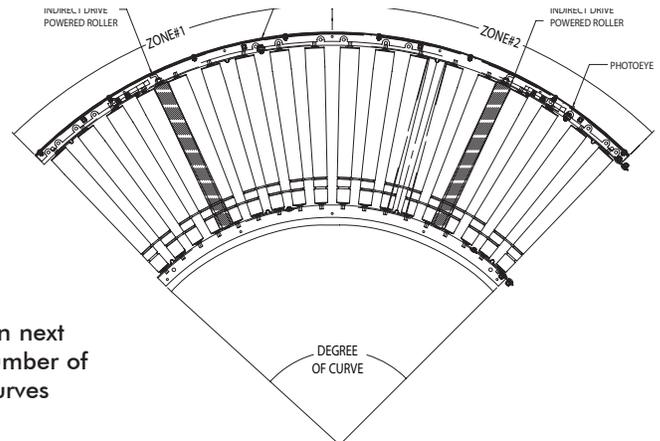
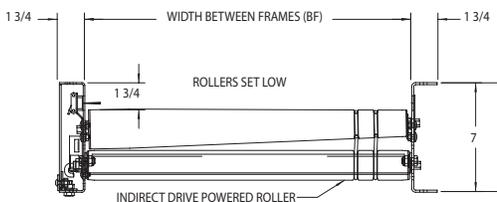
## SPECIFICATIONS

- ▶ **TREAD ROLLERS:** 796 PRA -1.9" dia. x 16 ga. galv. model 196G grooved. 796 PRAC -2-1/2" dia. to 1-11/16" dia. x 14 ga. steel tapered rollers, model 254T.
- ▶ **DRIVE BELT:** 3/16" dia., polyurethane belts. Nominal 15 lbs. per roller drive.
- ▶ **CAPACITY:** 15 lbs. per roller or up to 70 lbs. per zone
- ▶ **SPEED:** 60 FPM, constant.
- ▶ **ROLLER CENTERS:** 3"
- ▶ **BED:** 796 PRA - 7" x 1-3/4" x 12 ga. formed steel channel frame. Rollers set low in frame.

- ▶ **ACCUMULATION:** Zone singulation operation; 24" zone length; zones are actuated using a photoeye
- ▶ **MOTOR DRIVE:** 796 PRA - Driven by 24V DC Powered Roller. 796 PRAC - Indirect driven by 24 VDC Powered Roller. (See end view drawing below)
- ▶ **BEARINGS:** Precision ABEC bearings.
- ▶ **DC POWER SUPPLY:** 24 volt fixed output required

ZONES	AMP
1 - 2 ZONES	6 AMP
3 - 8 ZONES	10 AMP
9 - 17 ZONES	20 AMP
18 - 26 ZONES	30 AMP
27 - 36 ZONES	40 AMP

# 796PRAC | W/ PHOTOEYE CONTROLLED POWERED ROLLER ACCUMULATOR CURVE 30°, 45°, 60° AND 90° MODULES



See chart on next page for number of zones for curves

SPECIFICATION TABLE

■ 4 week shipment

CONVEYOR LENGTH		10'	20'	30'	40'	50'	60'	70'	80'	90'	100'	Deduct
BF	OAW	UNIT WEIGHTS (lbs.) with 3" Roller Centers (For other centers, deduct weights below)										Per Foot
15"	18"	205	410	615	820	1025	1230	1435	1640	1845	2050	21
19"	21"	230	460	690	920	1150	1380	1610	1840	2070	2300	23
21"	24"	242	484	726	968	1210	1452	1694	1936	2178	2420	24
25"	28"	266	532	798	1064	1330	1596	1862	2128	2394	2660	27
27"	30"	279	558	837	1116	1395	1674	1953	2232	2511	2790	28
33"	36"	323	646	969	1292	1615	1938	2261	2584	2907	3230	32
39"	42"	361	722	1083	1444	1805	2166	2527	2888	3249	3610	36

DEGREE		90°						60°					45°					30°				
BF	OAW	INSIDE RADIUS	WT (LBS.)	IR/RC OR/RC	TAPERED ROLLERS	DRIVE ROLLER QTY	ZONE QTY	WT (LBS.)	IR/RC OR/RC	TAPERED ROLLER	DRIVE ROLLER QTY	ZONE QTY	WT (LBS.)	IR/RC OR/RC	ROLLER QTY.	TAPERED ROLLER	ZONE QTY	WT (LBS.)	IR/RC OR/RC	TAPERED ROLLER	DRIVE ROLLER QTY	ZONE QTY
15"	18-1/2"	32 1/2"	229	2.84" 4.15"	18	2	2	180	2.84" 4.15"	12	2	1	169	2.84" 4.15"	9	1	1	146	2.84" 4.15"	6	1	1
19"	22-1/2"	32 1/2"	280	2.84" 4.49"	18	2	2	206	2.84" 4.49"	12	2	1	200	2.84" 4.49"	9	1	1	169	2.84" 4.49"	6	1	1
21"	24-1/2"	32 1/2"	305	2.84" 4.67"	18	2	2	210	2.84" 4.67"	12	2	1	216	2.84" 4.67"	9	1	1	180	2.84" 4.67"	6	1	1
25"	28-1/2"	32 1/2"	355	2.84" 5.02"	18	2	2	238	2.84" 5.02"	12	2	1	247	2.84" 5.02"	9	1	1	202	2.84" 5.02"	6	1	1
27"	30-1/2"	32 1/2"	381	2.84" 5.19"	18	2	2	250	2.84" 5.19"	12	2	1	262	2.84" 5.19"	9	1	1	214	2.84" 5.19"	6	1	1
33"	36-1/2"	48"	456	2.90" 4.89"	26	3	3	323	3.14" 5.30"	17	2	2	309	2.90" 4.89"	13	2	1	247	3.14" 5.30"	9	1	1
39"	42-1/2"	48"	532	2.90" 5.26"	26	3	3	370	3.14" 5.69"	17	2	2	355	2.90" 5.26"	13	2	1	281	3.14" 5.69"	9	1	1

OPTIONAL EQUIPMENT

► **ACCUMULATION ZONES:** 18" and 30" long zones available, depending on roller centers.

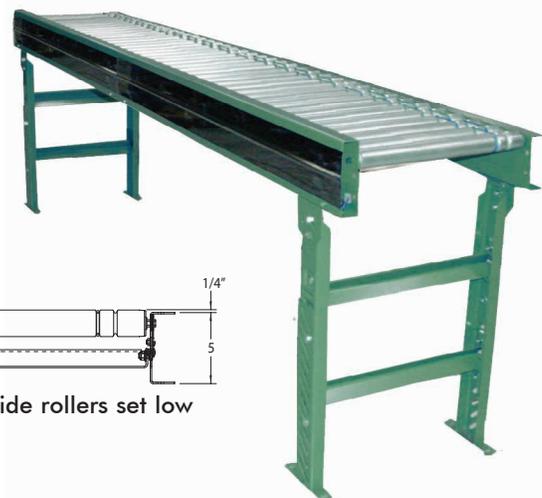
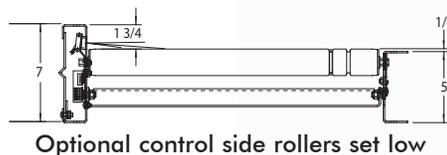
► **FLOOR SUPPORTS:** Conveyor shown with optional supports. Supports, knee braces, casters and polytiter supports available. See Conveyor Accessories.

► **CONVEYOR SPEED:** Constant speed 34-260 FPM

► **CEILING HANGERS:** 5/8" dia. threaded rod with hardware to attach rods to conveyor. Provides 6' clearance between ceiling and TOR (furnished in place of floor supports). See Conveyor Accessories.

► **DIFFUSE PHOTOEYE:** Photoeyes mounted below the tapered rollers.

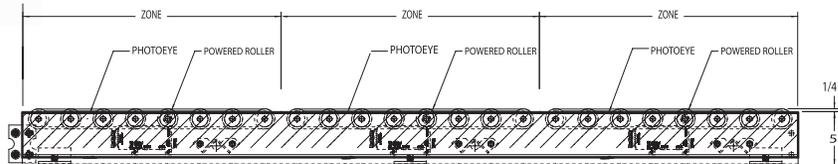
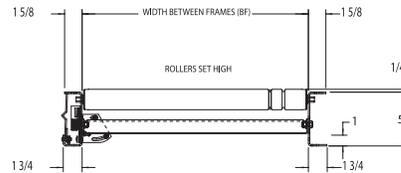
► **BED:** Control side 7" x 1-3/4" x 12 ga. formed steel channel frame. Rollers set low in frame. Outside channel 5" x 1-3/4" x 10 ga. formed steel channel frame. Rollers set high in frame.



# 596PRA | PHOTOEYE CONTROLLED POWERED ROLLER ZERO PRESSURE ACCUMULATOR ROLLERS SET HIGH



The Powered Roller Accumulator conveyor has revolutionized the automated conveyor industry. Motorized rollers drive the conveyors eliminating the need for drive belts, chains or line shafts.



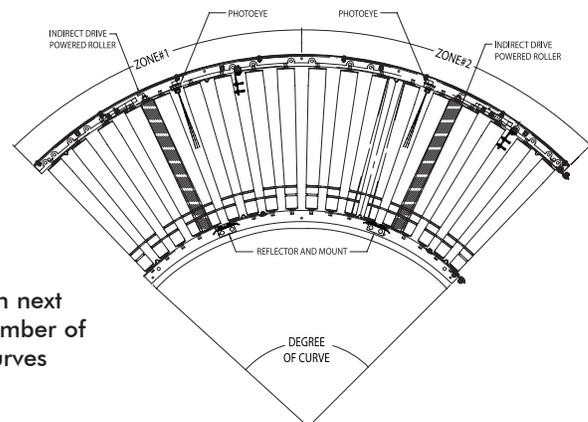
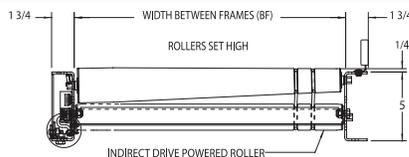
## SPECIFICATIONS

- ▶ **TREAD ROLLERS:** 596 PRA -1.9" dia. x 16 ga. galv., model 196G grooved. 596 PRAC -2-1/2" dia. to 1-11/16" dia. x 14 ga. steel tapered rollers, model 254T.
- ▶ **DRIVE BELT:** 3/16" dia., polyurethane belts. Nominal 15 lbs. per roller drive.
- ▶ **CAPACITY:** 15 lbs. per roller or up to 70 lbs. per zone
- ▶ **SPEED:** 60 FPM, constant.
- ▶ **ROLLER CENTERS:** 3"
- ▶ **BED:** 596 PRA - 5" x 1-3/4" x 10 ga. formed steel channel frame. Rollers set high in frame

- ▶ **ACCUMULATION:** Zone singulation operation; 24" zone length; zones are actuated using a photoeye.
- ▶ **MOTOR DRIVE:** 596 PRA - Driven by 24V DC Powered Roller. 596 PRAC - Indirect driven by 24 VDC Powered Roller. (See end view drawing below)
- ▶ **BEARINGS:** Precision ABEC bearings.
- ▶ **DC POWER SUPPLY:** 24 volt fixed output required

ZONES	AMP
1 - 2 ZONES	6 AMP
3 - 8 ZONES	10 AMP
9 - 17 ZONES	20 AMP
18 - 26 ZONES	30 AMP
27 - 36 ZONES	40 AMP

# 596PRAC | W/ PHOTOEYE CONTROLLED POWERED ROLLER ACCUMULATOR CURVE 30°, 45°, 60° AND 90° MODULES



See chart on next page for number of zones for curves

SPECIFICATION TABLE

■ 4 week shipment

CONVEYOR LENGTH		10'	20'	30'	40'	50'	60'	70'	80'	90'	100'	Deduct
BF	OAW	UNIT WEIGHTS (lbs.) with 3" Roller Centers (For other centers, deduct weights below)										Per Foot
15"	18"	205	410	615	820	1025	1230	1435	1640	1845	2050	21
19"	21"	230	460	690	920	1150	1380	1610	1840	2070	2300	23
21"	24"	242	484	726	968	1210	1452	1694	1936	2178	2420	24
25"	28"	266	532	798	1064	1330	1596	1862	2128	2394	2660	27
27"	30"	279	558	837	1116	1395	1674	1953	2232	2511	2790	28
33"	36"	323	646	969	1292	1615	1938	2261	2584	2907	3230	32
39"	42"	361	722	1083	1444	1805	2166	2527	2888	3249	3610	36

DEGREE			90°					60°					45°					30°				
BF	OAW	INSIDE RADIUS	WT (LBS.)	IR/RC OR/RC	TAPERED ROLLERS	DRIVE ROLLER QTY	ZONE QTY	WT (LBS.)	IR/RC OR/RC	TAPERED ROLLER	DRIVE ROLLER QTY	ZONE QTY	WT (LBS.)	IR/RC OR/RC	ROLLER QTY.	TAPERED ROLLER	ZONE QTY	WT (LBS.)	IR/RC OR/RC	TAPERED ROLLER	DRIVE ROLLER QTY	ZONE QTY
15"	18-1/2"	32 1/2"	229	2.84" 4.15"	18	2	2	180	2.84" 4.15"	12	2	1	169	2.84" 4.15"	9	1	1	146	2.84" 4.15"	6	1	1
19"	22-1/2"	32 1/2"	280	2.84" 4.49"	18	2	2	206	2.84" 4.49"	12	2	1	200	2.84" 4.49"	9	1	1	169	2.84" 4.49"	6	1	1
21"	24-1/2"	32 1/2"	305	2.84" 4.67"	18	2	2	210	2.84" 4.67"	12	2	1	216	2.84" 4.67"	9	1	1	180	2.84" 4.67"	6	1	1
25"	28-1/2"	32 1/2"	355	2.84" 5.02"	18	2	2	238	2.84" 5.02"	12	2	1	247	2.84" 5.02"	9	1	1	202	2.84" 5.02"	6	1	1
27"	30-1/2"	32 1/2"	381	2.84" 5.19"	18	2	2	250	2.84" 5.19"	12	2	1	262	2.84" 5.19"	9	1	1	214	2.84" 5.19"	6	1	1
33"	36-1/2"	48"	456	2.90" 4.89"	26	3	3	323	3.14" 5.30"	17	2	2	309	2.90" 4.89"	13	2	1	247	3.14" 5.30"	9	1	1
39"	42-1/2"	48"	532	2.90" 5.26"	26	3	3	370	3.14" 5.69"	17	2	2	355	2.90" 5.26"	13	2	1	281	3.14" 5.69"	9	1	1

OPTIONAL EQUIPMENT

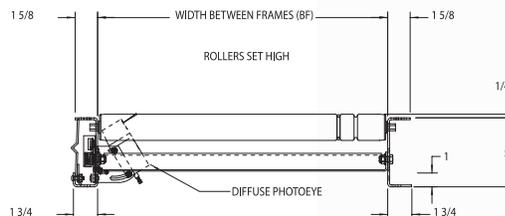
- ▶ **ACCUMULATION ZONES:** 18" and 30" long zones available, depending on roller centers.
- ▶ **FLOOR SUPPORTS:** Conveyor shown with optional supports. Supports, knee braces, casters and polytief supports available. See Conveyor Accessories.

- ▶ **CEILING HANGERS:** 5/8" dia. threaded rod with hardware to attach rods to conveyor. Provides 6' clearance between ceiling and TOR (furnished in place of floor supports). See Conveyor Accessories.

- ▶ **CONVEYOR SPEED:** Constant speed 34 - 260 FPM
- ▶ **DIFFUSE PHOTOEYE:** Photoeye mounted below the tread rollers



OPTIONAL 3-STRAND 90° ROUND BELT TRANSFER

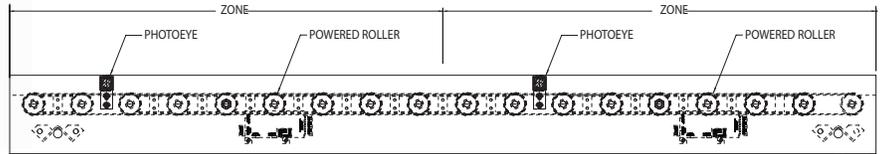


OPTIONAL DIFFUSE PHOTOEYE

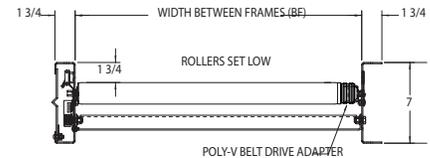
# 796PRA-2PV & 796PRA-3PV | POLY-V PHOTOEYE CONTROLLED ROLLERS SET LOW POWERED ROLLER ZERO PRESSURE ACCUMULATOR



The Powered Roller Accumulator conveyor has revolutionized the automated conveyor industry. Motorized rollers drive the conveyors eliminating the need for drive belts, chains or line shafts.



The Poly-V belt features lengthwise grooves providing a drive by adhesion, and optimizes the contact area, giving increased power transfer.



## SPECIFICATIONS

- ▶ **TREAD ROLLERS:** 1.9" dia. x 16 ga. galvanized, model 196G with Poly-V Belt Drive Adapter
- ▶ **DRIVE BELT:** 796 PRA-2PV -2 Rib Poly-V Belt 796 PRA-3PV -3 Rib Poly-V Belt
- ▶ **CAPACITY:** 2 Rib Poly-V Belt 110 lbs. per zone at 60 fpm (maximum capacity) 3 Rib Poly-V Belt 350 lbs. per zone at 53 fpm (maximum capacity)
- ▶ **ROLLER CENTERS:** 3" or 4"
- ▶ **SIDE CHANNEL:** 7" x 1-3/4" x 12 ga. formed steel channel frame. Rollers set low in frame
- ▶ **SPEED:** 60 FPM, constant.
- ▶ **ACCUMULATION:** Zone singulation operation; 36" zone length; zones are actuated using photoeye
- ▶ **MOTOR DRIVE:** Driven by High Torque 24V DC Powered Roller.
- ▶ **BEARINGS:** Precision ABEC bearings.
- ▶ **DC POWER SUPPLY:** 24 volt fixed output required

ZONES	AMP
1 - 2 ZONES	6 AMP
3 - 8 ZONES	10 AMP
9 - 17 ZONES	20 AMP
18 - 26 ZONES	30 AMP
27 - 36 ZONES	40 AMP

CONVEYOR LENGTH		10'	20'	30'	40'	50'	60'	70'	80'	90'	100'	Deduct
BF	OAW	UNIT WEIGHTS (lbs.) with 3" Roller Centers (For other centers, deduct weights below)										Per Foot
15"	18"	205	410	615	820	1025	1230	1435	1640	1845	2050	21
19"	21"	230	460	690	920	1150	1380	1610	1840	2070	2300	23
21"	24"	242	484	726	968	1210	1452	1694	1936	2178	2420	24
25"	28"	266	532	798	1064	1330	1596	1862	2128	2394	2660	27
27"	30"	279	558	837	1116	1395	1674	1953	2232	2511	2790	28
33"	36"	323	646	969	1292	1615	1938	2261	2584	2907	3230	32
39"	42"	361	722	1083	1444	1805	2166	2527	2888	3249	3610	36

## OPTIONAL EQUIPMENT

**ACCUMULATION ZONES:** 24" and 48" long zones available, depending on roller centers.

**FLOOR SUPPORTS:** Conveyor shown with optional supports. Supports, knee braces, casters and polytier supports available. See Conveyor Accessories.

**CEILING HANGERS:** 5/8" dia. threaded rod with hardware to attach rods to conveyor. Provides 6' clearance between ceiling and TOR (furnished in place of floor supports). See Conveyor Accessories.

**CONVEYOR SPEED:** Constant speeds available 20-150 FPM (optional speeds are dependent upon product weight. Consult Factory)

**BED:** Control side 7" x 1-3/4" x 12 ga. formed steel channel frame. Rollers set low in frame. Outside channel 5" x 1-3/4" x 10 ga. formed steel channel frame. Rollers set high in frame

**DIFFUSE PHOTOEYE:** Photoeyes mounted below tread rollers.

■ 5-6 week shipment

# 596PRA-2PV & 596PRA-3PV | POLY-V PHOTOEYE CONTROLLED ROLLERS SET HIGH POWERED ROLLER ZERO PRESSURE ACCUMULATOR



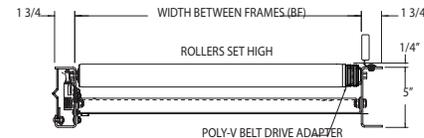
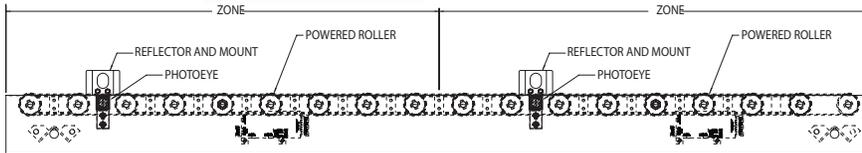
The Powered Roller Accumulator conveyor has revolutionized the automated conveyor industry. Motorized rollers drive the conveyors eliminating the need for drive belts, chains or line shafts.



The Poly-V belt features lengthwise grooves providing a drive by adhesion, and optimizes the contact area, giving increased power transfer.



Roller With Poly-V Belt Drive Adapter



## SPECIFICATIONS

- ▶ **TREAD ROLLERS:** 1.9" dia. x 16 ga. galvanized, model 196G with Poly-V Belt Drive Adapter
- ▶ **DRIVE BELT:** 596 PRA-2PV -2 Rib Poly-V Belt 596 PRA-3PV -3 Rib Poly-V Belt
- ▶ **CAPACITY:** 2 Rib Poly-V Belt 110 lbs. per zone at 60 fpm (maximum capacity) 3 Rib Poly-V Belt 350 lbs. per zone at 53 fpm (maximum capacity)
- ▶ **ROLLER CENTERS:** 3" or 4"
- ▶ **SIDE CHANNEL:** 5" x 1-3/4" x 10 ga. formed steel channel frame. Rollers set high in frame
- ▶ **SPEED:** 60 FPM, constant.
- ▶ **ACCUMULATION:** Zone singulation operation; 36" zone length; zones are actuated using photoeye
- ▶ **MOTOR DRIVE:** Driven by High Torque 24V DC Powered Roller.
- ▶ **BEARINGS:** Precision ABEC bearings.
- ▶ **DC POWER SUPPLY:** 24 volt fixed output required

ZONES	AMP
1 - 2 ZONES	6 AMP
3 - 8 ZONES	10 AMP
9 - 17 ZONES	20 AMP
18 - 26 ZONES	30 AMP
27 - 36 ZONES	40 AMP

CONVEYOR LENGTH		10'	20'	30'	40'	50'	60'	70'	80'	90'	100'	Deduct
BF	OAW	UNIT WEIGHTS (lbs.) with 3" Roller Centers (For other centers, deduct weights below)										Per Foot
15"	18"	205	410	615	820	1025	1230	1435	1640	1845	2050	21
19"	21"	230	460	690	920	1150	1380	1610	1840	2070	2300	23
21"	24"	242	484	726	968	1210	1452	1694	1936	2178	2420	24
25"	28"	266	532	798	1064	1330	1596	1862	2128	2394	2660	27
27"	30"	279	558	837	1116	1395	1674	1953	2232	2511	2790	28
33"	36"	323	646	969	1292	1615	1938	2261	2584	2907	3230	32
39"	42"	361	722	1083	1444	1805	2166	2527	2888	3249	3610	36

■ 5-6 week shipment

## OPTIONAL EQUIPMENT

**ACCUMULATION ZONES:** 24" and 48" long zones available, depending on roller centers.

**FLOOR SUPPORTS:** Conveyor shown with optional supports. Supports, knee braces, casters and polytier supports available. See Conveyor Accessories.

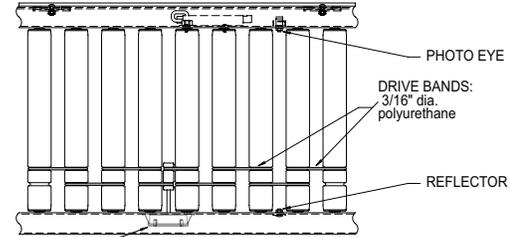
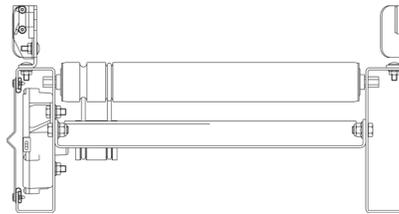
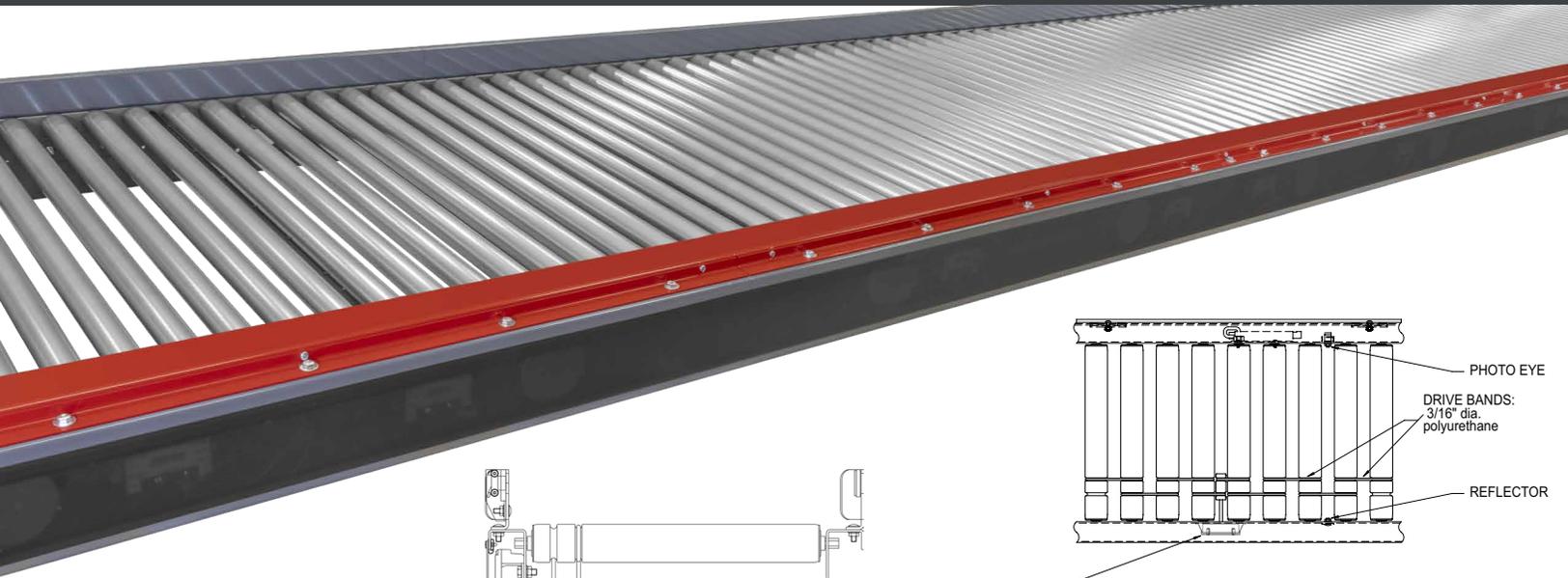
**CEILING HANGERS:** 5/8" dia. threaded rod with hardware to attach rods to conveyor. Provides 6' clearance between ceiling and TOR (furnished in place of floor supports). See Conveyor Accessories.

**CONVEYOR SPEED:** Constant speeds available 20-150 FPM (optional speeds are dependent upon product weight. Consult Factory)

**DIFFUSE PHOTOEYE:** Photoeyes mounted below tread rollers.



# 796MDZ | MOTOR DRIVEN ZONE ACCUMULATOR



UNIDRIVE MOTOR

## SPECIFICATIONS

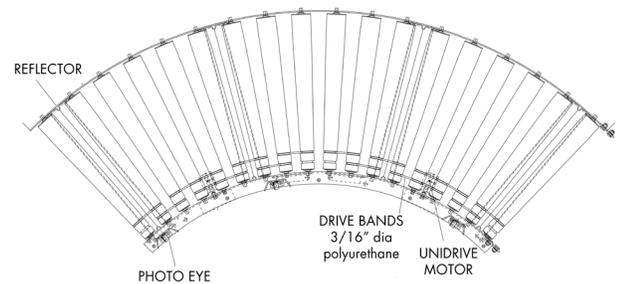
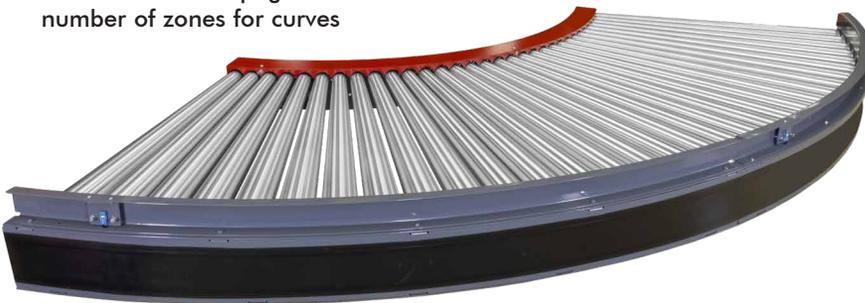
- ▶ **TREAD ROLLERS:** 1.9" dia. x 16 ga. galvanized steel, model 196G grooved.
- ▶ **DRIVE BELT:** 3/16" dia., polyurethane belts. Nominal 15 lbs. per roller drive.
- ▶ **CAPACITY:** 45 lbs. per zone
- ▶ **SPEED:** 35-120 fpm constant
- ▶ **ROLLER CENTERS:** 3"

- ▶ **SIDE CHANNEL:** 7" x 1-7/8" x 12 ga. formed steel channel frame. Rollers set high.
- ▶ **ACCUMULATION:** Zone singulator operation; 24" & 30" zone length
- ▶ **MOTOR DRIVE:** Driven by 24 VDC Unidrive Motor
- ▶ **BEARINGS:** Precision ABEC bearings.
- ▶ **LESS SUPPORTS**

ZONES	AMP
1 - 2 ZONES	6 AMP
3 - 8 ZONES	10 AMP
9 - 17 ZONES	20 AMP
18 - 26 ZONES	30 AMP
27 - 36 ZONES	40 AMP

# 796MDZ | MOTOR DRIVEN ZONE ACCUMULATOR CURVE

See chart on next page for number of zones for curves

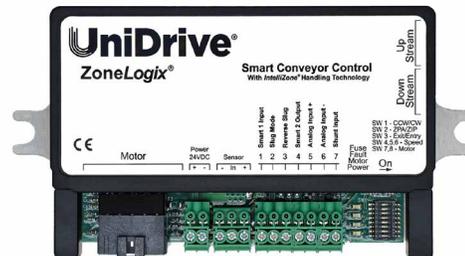


- ▶ **TREAD ROLLERS:** 2-1/2" dia. to 1-11/16" dia. 14ga. galvanized steel tapered rollers model 254T
- ▶ **DRIVE BELT:** 3/16" dia., polyurethane belts.
- ▶ **CAPACITY:** 45 lbs. per zone
- ▶ **SPEED:** 35-120 fpm constant

- ▶ **SIDE CHANNEL:** 7" x 1-5/8" x 12 ga. formed steel channel frame. Rollers set high.
- ▶ **LESS SUPPORTS**
- ▶ **24 VDC, supplied from straight section**

Featuring the new reliable & rugged **UniDrive** motor system.

- ✓ 300,000+ Hour Bearing Life
- ✓ Direct Drive Brushless Motor
- ✓ High Torque at Low Speed
- ✓ Almost Silent Operation
- ✓ Externally Mounted
- ✓ Simple to Service
- ✓ Cost Effective



SPECIFICATION TABLE

■ 3 week shipment

CONVEYOR LENGTH		10'	20'	30'	40'	50'	60'	70'	80'	90'	100'	Deduct
BF	OAW	UNIT WEIGHTS (lbs.) with 3" Roller Centers (For other centers, deduct weights below)										Per Foot
15"	19-1/4"	205	410	615	820	1025	1230	1435	1640	1845	2050	21
19"	23-1/4"	230	460	690	920	1150	1380	1610	1840	2070	2300	23
21"	25-1/4"	242	484	726	968	1210	1452	1694	1936	2178	2420	24
25"	29-1/4"	266	532	798	1064	1330	1596	1862	2128	2394	2660	27
27"	31-1/4"	279	558	837	1116	1395	1674	1953	2232	2511	2790	28
33"	37-1/4"	323	646	969	1292	1615	1938	2261	2584	2907	3230	32
39"	43-1/4"	361	722	1083	1444	1805	2166	2527	2888	3249	3610	36

DEGREE		90°				60°				45°				30°				
BF	OAW	INSIDE RADIUS	WT (LBS.)	Roller QTY	DRIVE QTY	ZONE QTY	WT (LBS.)	Roller QTY	DRIVE QTY	ZONE QTY	WT (LBS.)	Roller QTY	DRIVE QTY	ZONE QTY	WT (LBS.)	Roller QTY	DRIVE QTY	ZONE QTY
15"	18-3/4"	32 1/2"	229	18	2	2	180	12	2	1	169	9	1	1	146	6	1	1
19"	22-3/4"	32 1/2"	280	18	2	2	206	12	2	1	200	9	1	1	169	6	1	1
21"	24-3/4"	32 1/2"	305	18	2	2	210	12	2	1	216	9	1	1	180	6	1	1
25"	28-3/4"	32 1/2"	355	18	2	2	238	12	2	1	247	9	1	1	202	6	1	1
27"	30-3/4"	32 1/2"	381	18	2	2	250	12	2	1	262	9	1	1	214	6	1	1
33"	36-3/4"	48"	456	26	3	3	323	17	2	2	309	13	2	1	247	9	1	1
39"	42-3/4"	48"	532	26	3	3	370	17	2	2	355	13	2	1	281	9	1	1

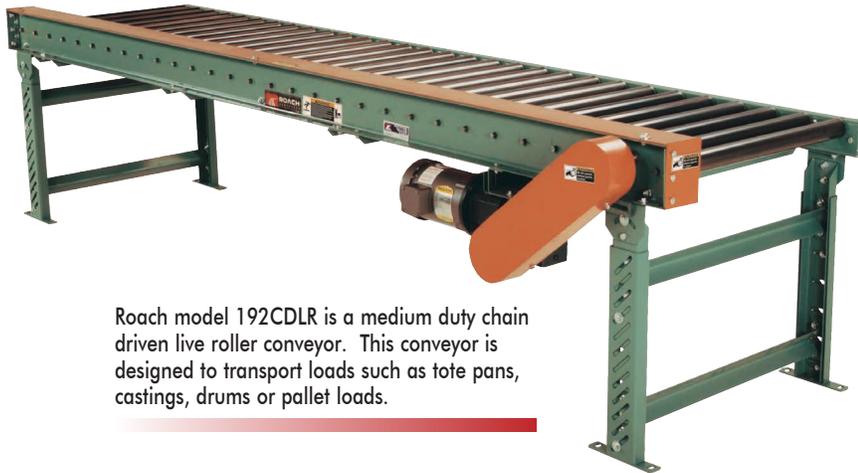
OPTIONAL EQUIPMENT

- ▶ **ACCUMULATION ZONES:** 24" and 30" long zones available, depending on roller centers.
- ▶ **FLOOR SUPPORTS:** Conveyor shown with optional supports. Supports, knee braces, casters and polytiter supports available. See Conveyor Accessories.

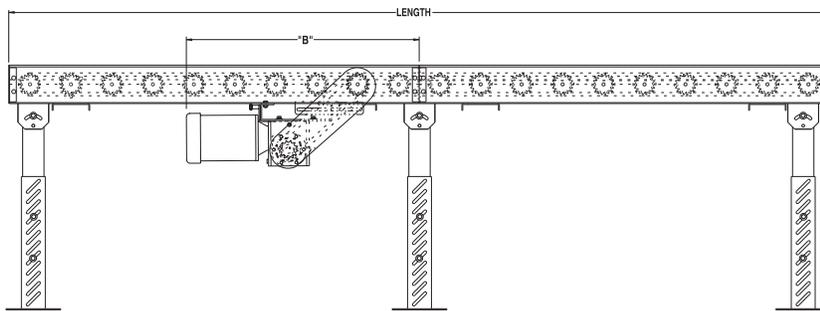
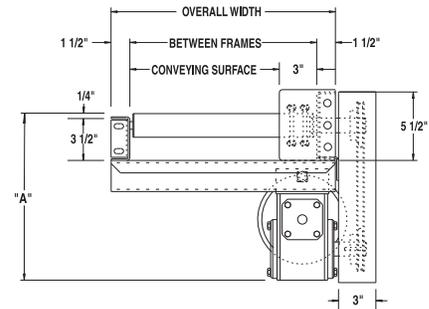
- ▶ **CONVEYOR SPEED:** Constant speed 35-120 FPM
- ▶ **CEILING HANGERS:** 5/8" dia. threaded rod with hardware to attach rods to conveyor. Provides 6' clearance between ceiling and TOR (furnished in place of floor supports). See Conveyor Accessories.

- ▶ **DIFFUSE PHOTOEYE:** Photoeyes mounted below the tread rollers.
- ▶ **BED:** Control side 7" x 1-3/4" x 12 ga. formed steel channel frame. Rollers set low in frame.

## 192CDLR | MEDIUM DUTY ROLL-TO-ROLL CHAIN DRIVEN LIVE ROLLER



Roach model 192CDLR is a medium duty chain driven live roller conveyor. This conveyor is designed to transport loads such as tote pans, castings, drums or pallet loads.



HP @ 45FPM	"A"	"B" MAX
1/2	13-1/8"	49-1/2"
3/4	13-1/2"	49-1/2"
1	13-3/4"	50-1/16"
1-1/2	14-5/8"	50-3/8"
2	15-1/2"	52-1/16"

### SPECIFICATIONS

► **TREAD ROLLERS:** 1.9" dia. x 12 ga. steel, model 192S with sprockets.

► **CHAIN DRIVE:** Roll-to-roll no. 40 roller chain.

► **CENTER DRIVE:** Reversible drive either side mounted or underside mounted (specify). Main drive roller is supported by precision, heavy duty, lubricated, ball bearing units.

► **CHAIN GUARD:** The chain drive is completely enclosed along the entire length of the conveyor.

► **ROLLER CENTERS:** 4", 6", 8" or 12" centers available.

► **SPEED:** 35 FPM, constant.

► **BEARINGS:** Removable type, zinc-plated, grease packed, labyrinth sealed.

► **BED:** 5-1/2" x 1-1/2" x 10 ga. and 3-1/2" x 1-1/2" x 10 ga. formed steel channel frame.

► **MOTOR DRIVE:** 1/2 HP, 230/460/3, 60 cycle, Super "E" right angle gear motor.

► **ELECTRICAL CONTROLS:** Optional.

## SPECIFICATION TABLE

■ 3 week shipment

UNIT WEIGHTS (FOR 4" AND 8" ROLLER CENTERS ONLY)																				
CONVEYOR LENGTH		5'		10'		20'		30'		40'		50'		60'		70'		80'		
CONV. SUR-FACE	BF	4" RC	8" RC RC																	
12"	15"	334	291	509	431	859	703	1209	948	1659	1247	1909	1519	1790	2065	2340				
18"	21"	372	319	572	474	969	773	1367	1073	1764	1372	2161	1671	1971	2276	2581				
24"	27"	409	351	634	516	1079	843	1524	1170	1969	1497	2414	1824	2251	2476	2801				
30"	33"	452	379	697	559	1190	914	1683	1269	2175	1623	2668	1978	2333	2688	3043				
36"	39"	469	406	739	600	1278	950	1817	1340	2356	1720	2895	2100	2480	2865	3250				
42"	45"	524	430	819	640	1407	1049	1994	1457	2581	1865	3169	2274	2684	3099	3514				
48"	51"	562	463	882	683	1517	1119	2152	1555	2788	1992	3423	2428	2864	3299	3734				

UNIT WEIGHTS (FOR 6" AND 12" ROLLER CENTERS ONLY)																			
CONVEYOR LENGTH		5'		10'		20'		30'		40'		50'		60'		70'		80'	
CONV. SUR-FACE	BF	6" RC	12" RC																
12"	15"	307	285	457	405	755	651	1053	897	1351	1143	1647	1389	1946	1634	2246	1884	2546	2134
18"	21"	341	301	506	441	837	707	1169	974	1500	1240	1831	1506	2163	1773	2493	2043	2823	2313
24"	27"	370	331	555	476	921	763	1287	1050	1653	1337	2019	1624	2385	1911	2755	2201	3125	2491
30"	33"	405	358	605	513	1006	822	1407	1131	1807	1439	2208	1748	2609	2057	3009	2367	3409	2677
36"	39"	418	363	633	528	1066	856	1499	1184	1932	1512	2365	1840	2798	2168	3228	2498	3658	2828
42"	45"	465	406	700	581	1169	931	1637	1280	2105	1629	2574	1979	3044	2330	3514	2680	3984	3030
48"	51"	499	432	749	617	1251	987	1753	1357	2256	1728	2753	2090	3260	2468	3760	2838	4260	3208

## OPTIONAL EQUIPMENT

► **SPEED:** Constant speed 1.5-100 FPM; DC variable speed; AC inverter variable speed. Other constant or variable speeds available.  
**NOTE:** CAPACITY CHANGES WITH SPEED. 100 FPM MAX. WITH ROLL-TO-ROLL CHAIN DRIVE.

► **MOTORS:** Available through 3 HP in Super "E", explosion proof, dirty duty, brake motor, 115/230/1, 575/3, etc.

► **FLOOR SUPPORTS:** Conveyor shown with optional supports. Supports, knee braces, casters and polytier supports available. See Conveyor

Accessories.

► **UNDERTRUSSED BED:** Available to provide clearance underneath unit at bed joint locations. Specify location for undertrussing and desired clearance underneath unit. Consult factory.

► **GUARD RAILS:** 1-3/4" x 1" formed channel (model GC), adjusts horizontally to 8" wider than roller and vertically to 6" above roller; formed steel fixed (model FSG in 2", 4" and 6" heights; fixed channel (model FC); 1-1/2" angle (model GA1-1/2). See Conveyor Accessories.

► **CEILING HANGERS:** 5/8" dia. threaded rod with hardware to attach rods to conveyor. Provides 6' clearance between ceiling and TOR (furnished in place of floor supports). See Conveyor Accessories.

► **ELECTRICAL CONTROLS:** Magnetic starter; one direction manual starter; momentary start/stop push button station; limit switch, photo relay; others available.



ROLLER TO ROLLER CHAIN DRIVE  
(guard removed for clarity)



OPTIONAL TOP ROLLER GUARD MOUNTED DRIVE

## 192CDLRC | MEDIUM DUTY CHAIN DRIVEN LIVE ROLLER CURVE

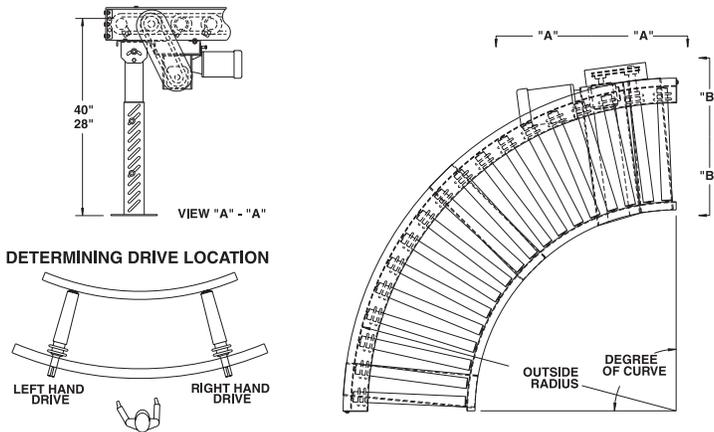
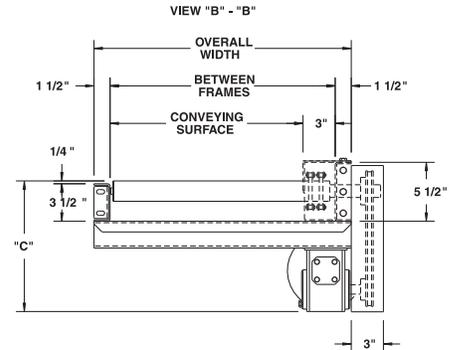


Roach 192CDLRC is a medium duty chain driven live roller curve, designed to transport medium duty loads such as castings or drums. **NOTE:** When conveying medium duty pallet loads, use model 254TCDLRC, opposite page, to maintain product orientation.

**SPECIFY MODEL NUMBER PER EXAMPLE**

**192CDLRC-27-45-L**

192CDLRC-(between frames)-(degree)-(left or right)



■ 4 week shipment

UNIT		90°		45°		
BF	CONV. SURFACE	OUTSIDE RADIUS	QTY. RLRs.	WT (lbs.)	QTY. RLRs.	WT. (lbs.)
15"	12"	4'-10-3/4"	18	339	9	265
21"	18"	4'-10-3/4"	18	374	9	277
27"	24"	4'-10-3/4"	18	409	9	292
33"	30"	8'-15/16"	30	543	15	313
39"	36"	8'-15/16"	30	586	15	337
45"	42"	8'-15/16"	30	633	15	364
51"	48"	8'-15/16"	30	681	15	391

### SPECIFICATIONS

► **TREAD ROLLERS:** 1.9" dia. x 12 ga. steel, model 192S with sprockets.\*

► **CHAIN DRIVE:** Roller to roller with No. 40 circular roller chain.

► **END DRIVE:** Reversible drive either side mounted or underside (specify). Main drive roller is supported by precision, heavy duty, lubricated, ball bearing units.

► **CHAIN GUARD:** Chain drive is enclosed, top and bottom, along entire length of conveyor.

► **BED:** 5-1/2" x 1-1/2" x 10 ga. and 3-1/2" x 1-1/2" x 10 ga. formed steel channel frame.

► **BEARINGS:** Removable type, heavy duty bearings, zinc plated, grease packed, labyrinth sealed.

► **MOTOR DRIVE:** 1/2 HP, 230/460/3, 60 cycle, Super "E" right angle gear motor.

► **SPEED:** 35 FPM, constant.

► **DRIVE LOCATION:** Drive located on outside of curve. Specify right hand drive or left hand drive (drive hand determined with reference point located at outside of curve).

► **ROLLER CENTERS:** 5" RC measured at outside radius of curve.

► **ELECTRICAL CONTROLS:** Optional.

HP @ 45FPM	"C"
1/2	13-1/8"
3/4	13-1/2"
1	13-3/4"
1-1/2	14-5/8"
2	15-1/2"

### OPTIONAL EQUIPMENT

**SPEED:** Constant speed 1.5-60 FPM; DC variable speed; AC inverter variable speed. Other constant or variable speeds available. **NOTE: CAPACITY CHANGES WITH SPEED. 100 FPM MAX. WITH ROLLER-TO-ROLLER CHAIN DRIVE.**

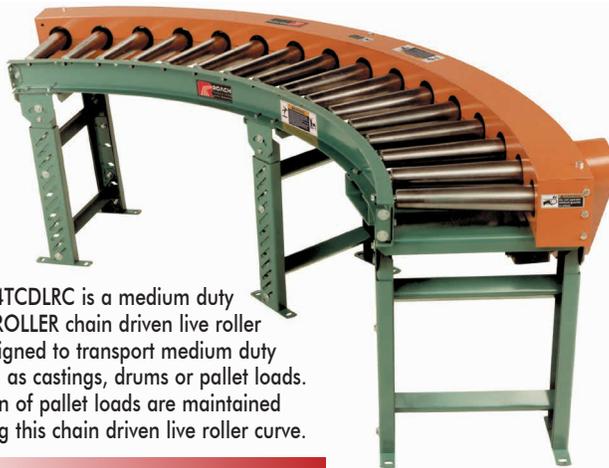
**MOTORS:** Available through 3 HP in TEFC, explosion proof, dirty duty, 115/230/1, 575/3, etc.

**FLOOR SUPPORTS:** Conveyor shown with optional supports. Supports, knee braces, casters, ceiling hangers and polytier supports available. See Conveyor Accessories.

**ELECTRICAL CONTROLS:** Magnetic or manual starter; limit switch; others available.

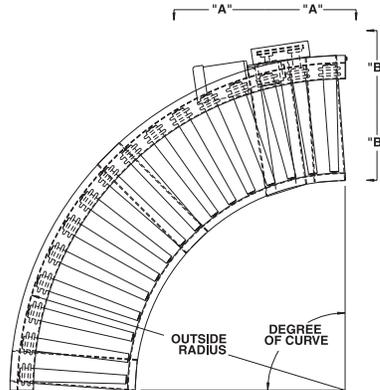
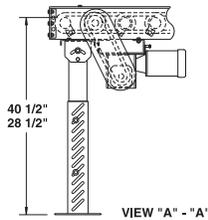
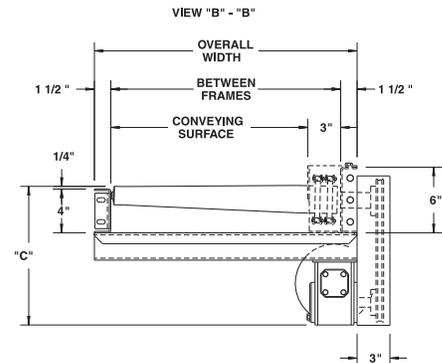
\*NOTE: Orientation of product may be affected because of straight rollers in curve. To maintain orientation, use tapered roller curve.

# 254TCDLRC | MEDIUM DUTY TAPERED ROLLER CHAIN DRIVEN LIVE ROLLER CURVE

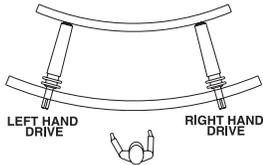


Model 254TCDLRC is a medium duty TAPERED ROLLER chain driven live roller curve, designed to transport medium duty loads such as castings, drums or pallet loads. Orientation of pallet loads are maintained when using this chain driven live roller curve.

**SPECIFY MODEL NUMBER PER EXAMPLE**  
**254TCDLRC-39-90-R**  
 254TCDLRC-(between frames)-(degree)-(left or right)



**DETERMINING DRIVE LOCATION**



■ 4 week shipment

BF	UNIT		90°		45°	
	CONV. SURFACE	OUTSIDE RADIUS	QTY. RLRs.	WT (lbs.)	QTY. RLRs.	WT. (lbs.)
15"	12"	5'-2-1/2"	16	344	8	208
21"	18"	5'-2-1/2"	16	372	8	225
27"	24"	5'-2-1/2"	16	403	8	243
33"	30"	7'-9-1/4"	24	447	12	263
39"	36"	7'-9-1/4"	24	486	12	310
45"	42"	7'-9-1/4"	24	528	12	334
51"	48"	7'-9-1/4"	24	559	12	359

**SPECIFICATIONS**

- ▶ **TREAD ROLLERS:** 2-1/2" dia. to 1-11/16" dia. x 14 ga. steel tapered rollers, model 254T with sprockets.
- ▶ **CHAIN DRIVE:** Roller to roller with No. 60 circular roller chain.
- ▶ **END DRIVE:** Reversible drive, side mounted or underside (specify). Main drive roller is supported by precision, heavy duty, lubricated, ball bearing units.
- ▶ **ROLLER CENTERS:** 6" RC measured at outside radius of curve.
- ▶ **CHAIN GUARD:** Chain drive is enclosed, top and bottom, along entire length of conveyor.
- ▶ **BEARINGS:** Removable type, heavy duty bearings, zinc plated, grease packed, labyrinth sealed.
- ▶ **MOTOR DRIVE:** 3/4 HP, 230/460/3, 60 cycle, Super "E" right angle gear motor.
- ▶ **BED:** 6" x 1-1/2" x 10 ga. and 4" x 1-1/2" x 10 ga. formed steel channel frame.
- ▶ **SPEED:** 35 FPM, constant.
- ▶ **DRIVE LOCATION:** Drive located on outside of curve. Specify right hand drive or left hand drive (drive hand determined with reference point located at outside of curve).
- ▶ **ELECTRICAL CONTROLS:** Optional.

HP @ 45FPM	"C"
1/2	13-5/8"
3/4	14"
1	14-1/4"
1-1/2	15-1/8"
2	16"

**OPTIONAL EQUIPMENT**

**SPEED:** Constant speed 1.5-60 FPM; DC variable speed; AC inverter variable speed. Other constant or variable speeds available. **NOTE: CAPACITY CHANGES WITH SPEED. 100 FPM MAX. WITH ROLLER-TO-ROLLER CHAIN DRIVE.**

**MOTORS:** Available through 3 HP in TEFC, explosion proof, dirty duty, 115/230/1, 575/3, etc.

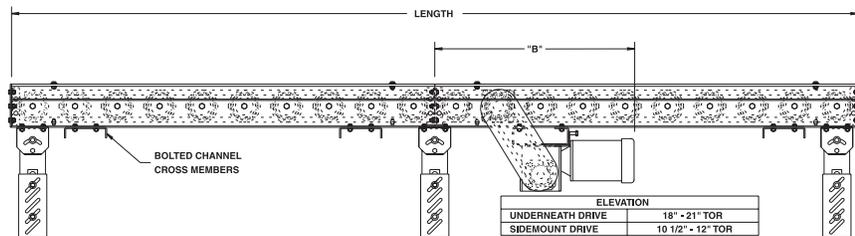
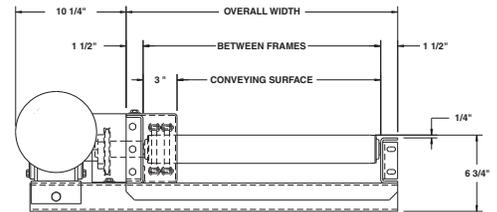
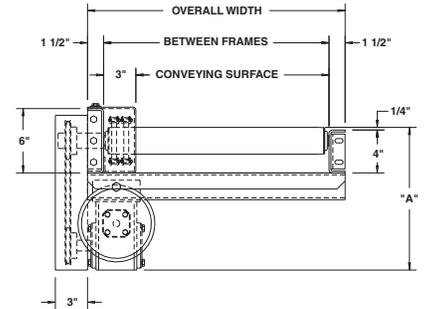
**FLOOR SUPPORTS:** Conveyor shown with optional supports. Supports, knee braces, casters, ceiling hangers and polytier supports available. See Conveyor Accessories.

**ELECTRICAL CONTROLS:** Magnetic or manual starter; limit switch; others available.

## 251CDLR | HEAVY DUTY CHAIN DRIVEN LIVE ROLLER



Model 251CDLR is a heavy duty chain driven live roller conveyor, specifically designed to transport heavy loads such as tote pans, castings, drums, pallet loads, etc. It is especially suited for carrying loads in the presence of oil and other such contaminants.



HP @ 35FPM	"A" MAX	"B" MAX
3/4	13"	38-13/16"
1	13-1/4"	39-1/8"
1-1/2	14-1/8"	39-1/8"
2	15"	40-13/16"

### SPECIFICATIONS

► **TREAD ROLLERS:** 2-1/2" dia. x 11 ga. steel rollers, model 251S with sprockets.

► **CHAIN DRIVE:** Roller to roller with No. 60 roller chain.

► **ROLLER CENTERS:** 3", 4-1/2", 6", 9" or 12". (SEE NOTE FOR 3" RC)

► **CENTER DRIVE:** Reversible drive either side mounted or underside mounted (specify). Main drive roller is supported by precision, heavy duty, lubricated, ball bearing units.

► **BED:** 6" x 1-1/2" x 7 ga. and 4" x 1-1/2" x 7 ga. formed steel channel frame. Bed sections attached with couplings and floor supports.

► **MOTOR DRIVE:** 3/4 HP, 230/460/3, 60 cycle, Super "E" right angle gear motor.

► **BEARINGS:** Precision ABEC bearings.

► **CHAIN GUARD:** The chain drive is completely enclosed along the entire length of the conveyor.

► **BED LENGTHS (4-1/2" or 9" RC):** Intermediate bed section lengths 3'-0", 3'-9", 4'-6", 5'-3", 6'-0", 6'-9", 7'-6", 8'-3", 9'-0" and 9'-9" increments. Minimum overall conveyor length with drive 5'-3". Maximum overall conveyor length: 58'-6" with 4-1/2" RC; 78'-0" with 9" RC.

► **BED LENGTHS (6" or 12" RC):**

Intermediate bed section lengths are available in 1'-0" increments. Minimum overall conveyor length with drive 5'-0". Maximum overall conveyor length 80'-0".

► **ELECTRICAL CONTROLS:** Optional.

► **SPEED:** 35 FPM, constant.

\*NOTE 3" RC: 3" RC are available with #40 chain on 40-14 double single sprocket sleeves.



OPTIONAL 3" RC NOW AVAILABLE (guard removed for clarity)

## SPECIFICATION TABLE

■ 3 week shipment

UNIT WEIGHTS (FOR 4-1/2" AND 9" ROLLER CENTERS ONLY)																	
CONVEYOR LENGTH		5'-3"		9'-9"		19'-6"		29'-3"		39'		48'-9"		58'-6"		68'-3"	78'
CONV. SURFACE	BF	4-1/2" RC	9" RC	9" RC	9" RC												
12"	15"	317	282	522	452	928	788	1304	1099	1699	1427	2105	1763	2511	2099	2503	2844
18"	21"	347	307	577	497	1033	873	1455	1221	1899	1588	2355	1964	2811	2340	2753	3129
24"	27"	377	330	632	537	1138	948	1606	1328	2099	1729	2605	2140	3110	2551	3003	3414
30"	33"	407	352	687	577	1243	1023	1757	1435	2299	1870	2855	2316	3412	2762	3253	3699
36"	39"	443	373	753	613	1368	1088	1938	1528	2538	1993	3104	2419	3770	2945	3468	3944
42"	45"	472	395	807	652	1473	1163	2090	1636	2738	2134	3404	2645	4070	3156	3718	4229
48"	51"	500	415	862	692	1578	1238	2240	1743	2938	2275	3654	2821	4370	3367	3968	4514
51"	54"	516	428	890	713	1631	1277	2317	1799	3039	2348	3780	2913	4521	3477	4094	4657
54"	57"	532	440	917	732	1683	1313	2391	1850	3139	2418	3904	2998	4670	3579	4218	4799
60"	63"	567	460	982	767	1808	1378	2571	1943	3377	2539	4203	3150	5029	3761	4433	5044

UNIT WEIGHTS (FOR 6" AND 12" ROLLER CENTERS ONLY)																			
CONVEYOR LENGTH		5'		10'		20'		30'		40'		50'		60'		70'		80'	
CONV. SURFACE	BF	6" RC	12" RC																
12"	15"	299	287	482	432	848	728	1214	1064	1580	1380	1946	1699	2312	2012	2678	2328	3044	2644
18"	21"	324	297	527	467	933	813	1339	1159	1745	1505	2151	1851	2557	2197	2963	2543	3369	2889
24"	27"	349	312	572	502	1018	878	1464	1254	1910	1630	2356	2006	2802	2382	3248	2758	3694	3134
30"	33"	374	332	617	537	1103	943	1589	1349	2075	1755	2561	2161	3047	2567	3533	2973	4019	3379
36"	39"	399	348	662	563	1188	988	1714	1429	2240	1840	2766	2266	3292	2692	3818	3118	4344	3544
42"	45"	424	367	707	597	1273	1053	1839	1509	2405	1965	2971	2421	3537	2877	4103	3333	4669	3789
48"	51"	449	387	752	632	1358	1118	1964	1604	2570	2090	3176	2576	3782	3062	4388	3548	4994	4034
51"	54"	462	400	775	650	1401	1151	2027	1652	2653	2153	3279	2654	3905	3155	4531	3656	5157	4157
54"	57"	474	407	797	667	1443	1183	2089	1699	2736	2216	3381	2731	4027	3247	4673	3763	5319	4279
60"	63"	499	422	842	692	1528	1228	2214	1764	2900	2300	3586	2836	4272	3372	4958	3908	5644	4444

### OPTIONAL EQUIPMENT

► **SPEED:** Constant speed 1.5-100 FPM; DC variable speed; AC inverter variable speed. Other constant or variable speeds available.

**NOTE:** CAPACITY CHANGES WITH SPEED. 100 FPM MAX. WITH ROLL-TO-ROLL CHAIN DRIVE.

► **FLOOR SUPPORTS:** Conveyor shown with optional supports. Supports,

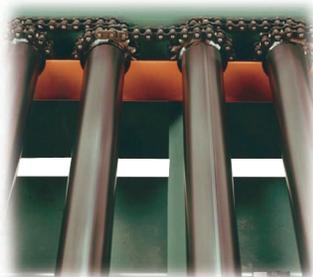
knee braces, casters and polytyr supports available. See Conveyor Accessories.

► **ELECTRICAL CONTROLS:** Magnetic starter (one direction or reversible); one direction manual starter; momentary start/stop push button station; forward/reversing/stop push button station; mounting and pre-wiring

for units 12'-0" long and under; limit switch, photo relay; others available.

► **BED:** 4" at 5.4 lb. and 6" at 8.2 lb. structural steel channel frame.

► **MOTORS:** Available through 3 HP in Super "E", explosion proof, dirty duty, brake motor, 115/230/1, 575/3, etc.

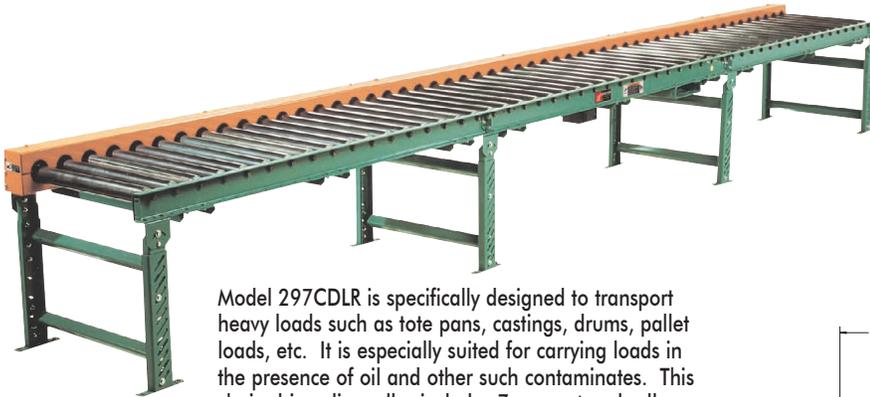


ROLLER TO ROLLER CHAIN DRIVE  
(guard removed for clarity)

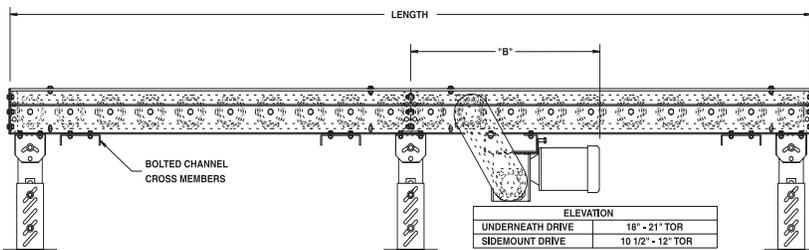
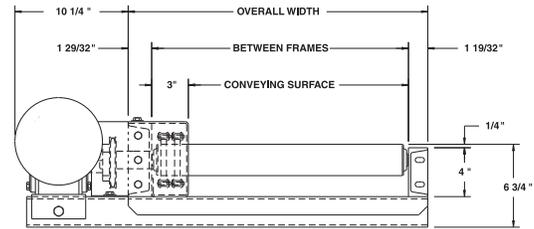
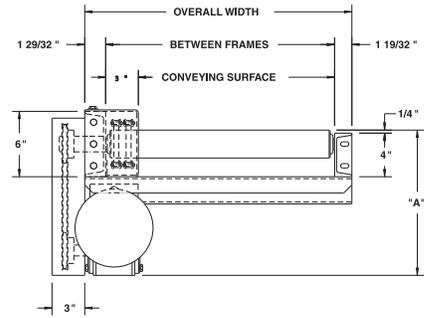


OPTIONAL TOP ROLLER GUARD MOUNTED DRIVE

## 297CDLR | HEAVY DUTY CHAIN DRIVEN LIVE ROLLER



Model 297CDLR is specifically designed to transport heavy loads such as tote pans, castings, drums, pallet loads, etc. It is especially suited for carrying loads in the presence of oil and other such contaminants. This chain driven live roller includes 7 gauge tread rollers and structural steel frame as standard unit features.



HP @ 35FPM	"A" MAX	"B" MAX
3/4	13"	38-13/16"
1	13-1/4"	39-1/8"
1-1/2	14-1/8"	39-1/8"
2	15"	40-13/16"

### SPECIFICATIONS

- ▶ **TREAD ROLLERS:** 2-9/16" dia. x 7 ga. steel rollers, model 297S with sprockets.
- ▶ **CHAIN DRIVE:** Roller to roller with No. 60 roller chain.
- ▶ **CENTER DRIVE:** Reversible drive either side mounted or underside mounted (specify). Main drive roller is supported by precision, heavy duty, lubricated, ball bearing units.
- ▶ **ROLLER CENTERS:** 3", 4-1/2", 6", 9" and 12".
- ▶ **BED:** 4" at 5.4 lbs. and 6" at 8.2 lbs. structural steel channel frame. Bed sections attached with couplings and floor supports.
- ▶ **SPEED:** 35 FPM, constant.

- ▶ **BEARINGS:** Precision ABEC bearings.
- ▶ **CHAIN GUARD:** The chain drive is completely enclosed along the entire length of the conveyor.
- ▶ **BED LENGTHS (4-1/2" or 9" RC):** Intermediate bed section lengths 3'-0", 3'-9", 4'-6", 5'-3", 6'-0", 6'-9", 7'-6", 8'-3", 9'-0" and 9'-9" increments. Minimum overall conveyor length with drive 5'-3". Maximum overall conveyor length: 58'-6" with 4-1/2" RC; 78'-0" with 9" RC.
- ▶ **BED LENGTHS (6" or 12" RC):** Intermediate bed section lengths are available in 1'-0" increments. Minimum overall conveyor length with drive 5'-0".

- ▶ **MOTOR DRIVE:** 3/4 HP, 230/460/3, 60 cycle, Super "E" right angle gear motor.
  - ▶ **ELECTRICAL CONTROLS:** Optional.
- \*NOTE 3" RC: 3" RC are available with #40 chain on 40-14 double single sprocket sleeves.



OPTIONAL 3" RC NOW AVAILABLE (guard removed for clarity)

## SPECIFICATION TABLE

■ 4 week shipment

UNIT WEIGHTS (FOR 4-1/2" AND 9" ROLLER CENTERS ONLY)																		
CONVEYOR LENGTH		5'-3"		9'-9"		19'-6"		29'-3"		39'		48'-9"		58'-6"		68'-3"		78'
CONV. SUR-FACE	BF	4-1/2" RC	9" RC	9" RC	9" RC													
12"	15"	389	299	629	494	1142	876	1635	1257	2093	1639	2603	2020	3102	2402	2783	3300	
18"	21"	414	333	709	553	1297	987	1872	1420	2401	1854	2989	2287	3564	2721	3154	3588	
24"	27"	454	354	789	609	1452	1093	2100	1577	2696	2061	3359	3287	4007	3029	3513	3997	
30"	33"	492	388	857	653	1583	1177	2292	1700	2945	2224	3671	2747	4380	3271	3794	4318	
36"	39"	536	418	936	708	1736	1282	2517	1855	3237	2430	4037	3002	4818	3576	4149	4723	
42"	45"	573	446	1013	761	1885	1384	2736	2006	3520	2630	4392	3251	5243	3874	4496	5119	
48"	51"	620	479	1090	814	2034	1481	2955	2147	3805	2814	4749	3480	5670	4147	4813	5480	
51"	54"	640	491	1130	841	2109	1532	3065	2223	3948	2914	4927	3605	5883	4296	4987	5678	
54"	57"	662	507	1167	867	2183	1583	3174	2298	4090	3014	5105	3729	6096	4445	5160	5876	
60"	63"	701	537	1246	922	2336	1688	3399	2453	4380	3219	5470	3984	6532	4750	5530	6281	

UNIT WEIGHTS (FOR 6" AND 12" ROLLER CENTERS ONLY)																			
CONVEYOR LENGTH		5'		10'		20'		30'		40'		50'		60'		70'		80'	
CONV. SUR-FACE	BF	6" RC	12" RC																
12"	15"	333	278	549	439	982	769	1415	1099	1848	1429	2281	1759	2714	2039	3147	2419	3850	2749
18"	21"	370	315	618	488	1115	859	1612	1228	2109	1598	2606	1968	3103	2338	3600	2708	4097	3078
24"	27"	405	350	684	534	1242	944	1800	1354	2358	1764	2916	2174	3474	2584	4032	2994	4590	3404
30"	33"	435	380	738	568	1345	1008	1952	1448	2559	1888	3166	2328	3773	2768	4380	3208	4987	3648
36"	39"	470	415	803	613	1470	1093	2137	1573	2804	2053	3471	2533	4138	3013	4805	3493	5472	3973
42"	45"	504	449	866	656	1591	1176	2316	1696	3041	2216	3766	2736	4491	3256	5216	3776	5941	4296
48"	51"	538	483	929	699	1712	1249	2495	1799	3278	2349	4061	2899	4844	3449	5627	3999	6410	4549
51"	54"	554	499	961	721	1773	1291	2585	1861	3397	2431	4209	3001	5021	3571	5833	4141	6645	4711
54"	57"	572	517	992	742	1833	1332	2674	1922	3516	2512	4356	3102	5197	3692	6038	4282	6879	4872
60"	63"	607	552	1057	787	1958	1417	2859	2047	3760	2677	4661	3307	5562	3937	6463	4567	7364	5197

### OPTIONAL EQUIPMENT

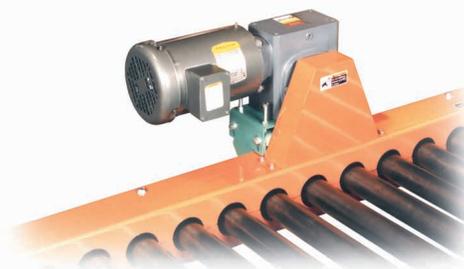
► **SPEED:** Constant speed 1.5-100 FPM; DC variable speed; AC inverter variable speed. Other constant or variable speeds available.  
**NOTE:** CAPACITY CHANGES WITH SPEED. 100 FPM MAX. WITH ROLL-TO-ROLL CHAIN DRIVE.



ROLLER TO ROLLER CHAIN DRIVE  
(guard removed for clarity)

► **MOTORS:** Available through 3 HP in Super "E", explosion proof, dirty duty, brake motor, 115/230/1, 575/3, etc.  
 ► **FLOOR SUPPORTS:** Conveyor shown with optional supports. Supports, knee braces, casters and polytier supports available. See Conveyor Accessories.

► **ELECTRICAL CONTROLS:** Magnetic starter (one direction or reversible); one direction manual starter; momentary start/stop push button station; forward/reversing/stop push button station; mounting and pre-wiring for units 12'-0" long and under; limit switch, photo relay; others available.

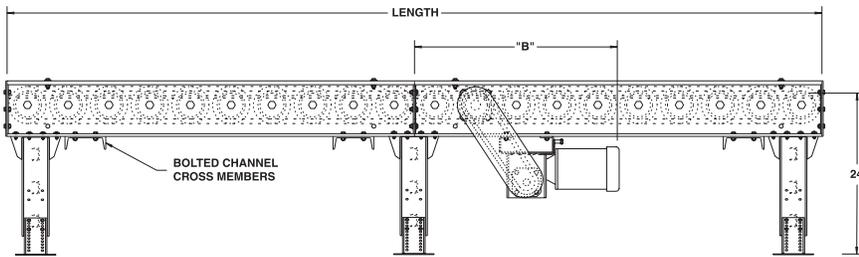
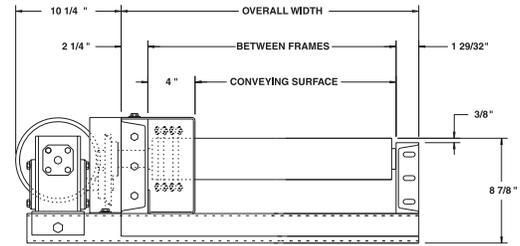
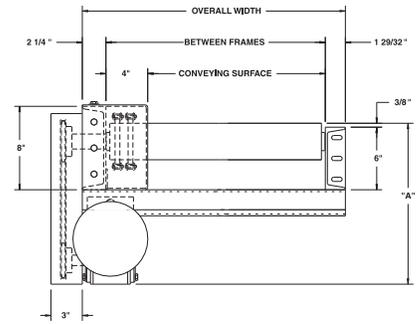


OPTIONAL TOP ROLLER GUARD MOUNTED DRIVE

## 3530CDLR | HEAVY DUTY CHAIN DRIVEN LIVE ROLLER



Roach model 3530CDLR is ideal for transporting very heavy unit loads. This heavy duty chain driven live roller is designed with heavy .300 wall steel rollers, larger size roller chain and heavy duty structural frame and supports for applications demanding ultra-durable construction for longevity and durability.



HP @ 35FPM	"A"	"B" MAX
3/4	16"	38-13/16"
1	16-1/4"	39-1/8"
1-1/2	17-1/8"	39-1/8"
2, 3	18-1/2"	40-13/16"
2	18-1/2"	41-13/16"

### SPECIFICATIONS

- ▶ **TREAD ROLLERS:** 3-1/2" dia. x .300 wall steel, model 3530S with sprockets.
- ▶ **CHAIN GUARD:** The chain drive is completely enclosed along the entire length of the conveyor.
- ▶ **CENTER DRIVE:** Reversible drive either side mounted or underneath mounted (specify). Main drive roller is supported by precision, heavy duty, lubricated, ball bearing units.
- ▶ **BEARINGS:** Precision ABEC bearings.

- ▶ **BED LENGTHS (6" RC, #60 CHAIN AND 12" RC, #80 CHAIN):** Intermediate bed section lengths 3'-0", 4'-0", 5'-0", 6'-0", 7'-0", 8'-0", 9'-0" and 10'-0" increments. Minimum overall conveyor length with drive 5'-0". Maximum overall conveyor length 80'-0".
- ▶ **BED LENGTHS (7-1/2" RC, #80 CHAIN):** Intermediate bed section lengths 3'-1-1/2", 3'-9", 4'-4-1/2", 5'-0", 5'-7-1/2", 6'-3", 6'-10-1/2", 7'-6", 8'-1-1/2", 8'-9", 9'-4-1/2" and 10'-0". Minimum overall conveyor length with drive 5'-0". Maximum overall conveyor length 80'-0".
- ▶ **ROLLER CENTERS:** 6" with No. 60 chain; 7-1/2" and 12" with No. 80 chain.

- ▶ **CHAIN DRIVE:** Roller to roller with No. 60 or No. 80 roller chain.
- ▶ **SPEED:** 35 FPM constant.
- ▶ **BED:** 6" at 8.2 lbs. and 8" at 11.5 lbs. structural steel frame. Bed sections attached with couplings and floor supports.
- ▶ **MOTOR DRIVE:** 3/4 HP, 230/460/3, 60 cycle, Super "E" right angle gear motor.
- ▶ **ROLLER CAPACITY:** 2500 lbs. per roller.
- ▶ **ELECTRICAL CONTROLS:** Optional.

## SPECIFICATION TABLE

■ 4 week shipment

CONVEYOR LENGTH				10'	20'	30'	40'	50'	60'	70'	80'
CONV. SURFACE	BF	RC	CHAIN SIZE	UNIT WEIGHTS (lbs.)							
35"	39"	6"	60	1453	2873	4293	5713	7133	8553	9973	11393
		7-1/2"	80	1337	2950	4563	6176	7789	9402	11015	12628
		12"	80	990	1950	2910	3870	4830	5790	6750	7710
41"	45"	6"	60	1605	3179	4753	6327	7901	9475	11049	12623
		7-1/2"	80	1472	3165	4858	6551	8244	9937	11630	13323
		12"	80	1074	2104	3134	4164	5194	6224	7254	8284
47"	51"	6"	60	1757	3485	5213	6941	8669	10397	12125	13853
		7-1/2"	80	1607	3380	5153	6926	8699	10472	12245	14018
		12"	80	1159	2269	3379	4489	5599	6709	7819	8929
53"	57"	6"	60	1909	3791	5673	7555	9437	11319	13201	15083
		7-1/2"	80	1743	3596	5449	7302	9155	11008	12861	14714
		12"	80	1243	2423	3603	4783	5963	7143	8323	9503

## OPTIONAL EQUIPMENT

**SPEED:** Constant speed 1.5-100 FPM; DC variable speed; AC inverter variable speed. Other constant or variable speeds available. **NOTE: CAPACITY CHANGES WITH SPEED. 100 FPM MAX. WITH ROLL-TO-ROLL CHAIN DRIVE.**

**FLOOR SUPPORTS:** Conveyor shown with optional supports. Supports and knee braces available. See Conveyor Accessories.

**ELECTRICAL CONTROLS:** Magnetic starter (one direction or reversible); one direction manual starter; momentary start/stop push button station; forward/reversing/stop push button station; mounting and pre-wiring for units 12'-0" long and under; limit switch, photo relay; others available.

**MOTORS:** Available through 5 HP in Super "E", explosion proof, dirty duty, brake motor, 115/230/1, 575/3, etc.



ROLLER TO ROLLER CHAIN DRIVE  
(guard removed for clarity)



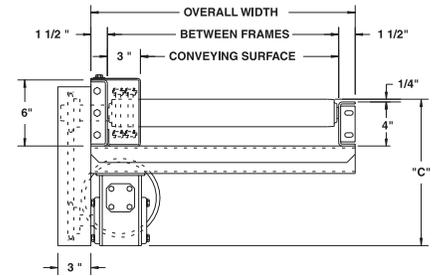
OPTIONAL TOP ROLLER GUARD MOUNTED DRIVE

## 251CDLRC | HEAVY DUTY CHAIN DRIVEN LIVE ROLLER CURVE

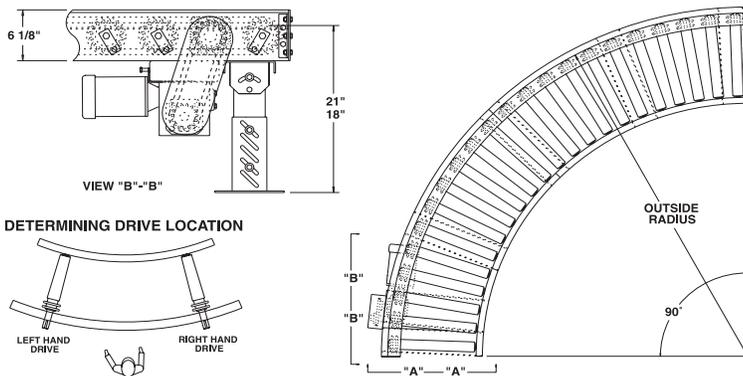


251CDLRC, heavy duty chain driven live roller curve, transports heavy unit loads. Heavy castings, drums and other loads not requiring product orientation may be effectively conveyed on this conveyor.

**SPECIFY MODEL NUMBER PER EXAMPLE**  
**251CDLRC-39-90-L**  
 251CDLRC-(between frames)-(degree)-(left or right)



■ 4 week shipment



UNIT		90°	45°
BF	CONV. SURFACE	QTY. RLLRS.	WT (lbs.)
15"	12"	22	624
21"	18"	22	672
27"	24"	22	721
33"	30"	22	769
39"	36"	22	815
45"	42"	32	1244
51"	48"	32	1383
57"	54"	32	1531
63"	60"	32	1680

### SPECIFICATIONS

- ▶ **TREAD ROLLERS:** 2-1/2" dia. x 11 ga. steel, model 251S with sprockets.
- ▶ **CHAIN DRIVE:** Roller to roller with No. 60 circular roller chain.
- ▶ **END DRIVE:** Reversible drive either side mounted or underside (specify). Main drive roller is supported by precision, heavy duty, lubricated, ball bearing units.
- ▶ **BEARINGS:** Precision ABEC bearings.
- ▶ **ROLLER CENTERS:** 6" RC measured at outside radius of curve.
- ▶ **MOTOR DRIVE:** 3/4 HP, 230/460/3, 60 cycle, Super "E" right angle gear motor.
- ▶ **SPEED:** 35 FPM, constant.
- ▶ **BED:** 6" x 1-1/2" x 7 ga. and 4" x 1-1/2" x 7 ga. formed steel channel frame.

- ▶ **CHAIN GUARD:** The chain drive is enclosed, top and bottom, along the entire length of the conveyor.
- ▶ **DRIVE LOCATION:** Drive located on outside of curve. Specify right hand drive or left hand drive (drive hand determined with reference point located at outside of curve).
- ▶ **ELECTRICAL CONTROLS:** Optional.

HP @ 35FPM	"C"
3/4	13"
1	13-1/4"
1-1/2	14-1/8"
2	15"

\*NOTE: Orientation of product may be affected because of straight rollers in curve. To maintain orientation, use tapered roller curve.

### OPTIONAL EQUIPMENT

**BED:** Rollers on 4-1/2" centers on outside radius.

**SPEED:** Constant speed 1.5-60 FPM; DC variable speed; AC inverter variable speed. Other constant or variable speeds available. **NOTE: CAPACITY CHANGES WITH SPEED. 100 FPM MAX. WITH ROLLER-TO-ROLLER CHAIN DRIVE.**

**MOTORS:** Available through 3 HP in TEFC, explosion proof, dirty duty, 115/230/1, 575/3, etc.

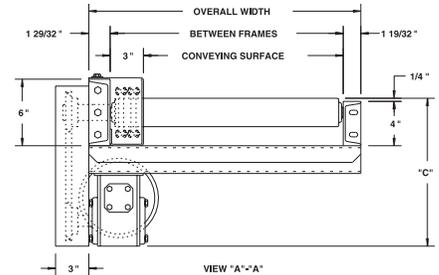
**FLOOR SUPPORTS:** Conveyor shown with optional supports. Supports, knee braces, casters, and polytier supports available. See Conveyor Accessories.

# 297CDLRC | HEAVY DUTY CHAIN DRIVEN LIVE ROLLER CURVE



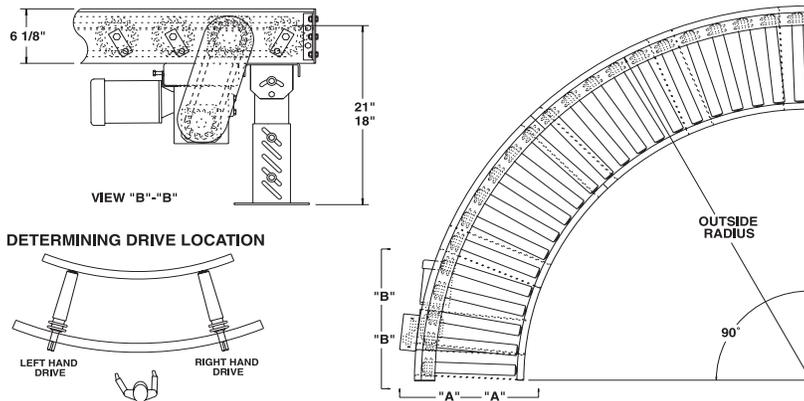
Model 297CDLRC features structural steel channel frames for conveying heavy unit loads. Heavy castings, drums and numerous other loads not requiring product orientation may be transported on this heavy duty chain driven live roller curve.

**SPECIFY MODEL NUMBER PER EXAMPLE**  
**297CDLRC-57-45-R**  
 297CDLRC-(between frames)-(degree)-(left or right)



■ 4 week shipment

UNIT		90°		45°		
BF	CONV. SURFACE	OUTSIDE RADIUS	QTY. RLRs.	WT (lbs.)	QTY. RLRs.	WT (lbs.)
15"	12"	7'-1-1/2"	22	736	11	421
21"	18"	7'-1-1/2"	22	846	11	495
27"	24"	7'-1-1/2"	22	956	11	540
33"	30"	7'-1-1/2"	22	1066	11	750
39"	36"	7'-1-1/2"	22	1176	11	811
45"	42"	10'-3-3/4"	32	1625	16	872
51"	48"	10'-3-3/4"	32	1735	16	965
57"	54"	10'-3-3/4"	32	1845	16	1026



## SPECIFICATIONS

- ▶ **TREAD ROLLERS:** 2-9/16" dia. x 7 ga. steel, model 297S with sprockets.\*
- ▶ **CHAIN DRIVE:** Roller to roller with No. 60 circular roller chain.
- ▶ **END DRIVE:** Reversible drive, either side mounted or underside (specify). Main drive roller is supported by precision, heavy duty, lubricated, ball bearing units.
- ▶ **CHAIN GUARD:** Chain drive is enclosed, top and bottom, along entire length of conveyor.
- ▶ **ROLLER CENTERS:** 6" RC measured at outside radius of curve.
- ▶ **BED:** 4" at 5.4 lbs. and 6" at 8.2 lbs. structural steel channel frame.
- ▶ **BEARINGS:** Precision ABEC bearings.
- ▶ **MOTOR DRIVE:** 3/4 HP, 230/460/3, 60 cycle, Super "E" right angle gear motor.
- ▶ **SPEED:** 35 FPM, constant.
- ▶ **DRIVE LOCATION:** Drive located on outside of curve. Specify right hand drive or left hand drive (drive hand determined with reference point located at outside of curve).
- ▶ **ELECTRICAL CONTROLS:** Optional.

HP @ 35FPM	"C"
3/4	13"
1	13-1/4"
1-1/2	14-1/8"
2	15

## OPTIONAL EQUIPMENT

**BED:** Rollers on 4-1/2" centers on outside radius.

**SPEED:** Constant speed 1.5-60 FPM; DC variable speed; AC inverter variable speed. Other constant or variable speeds available. **NOTE: CAPACITY CHANGES WITH SPEED. 100 FPM MAX. WITH ROLLER-TO-ROLLER CHAIN DRIVE.**

**MOTORS:** Available through 3 HP in TEFC, explosion proof, dirty duty, 115/230/1, 575/3, etc.

**FLOOR SUPPORTS:** Conveyor shown with optional supports. Supports, knee braces, casters, and polytier supports available. See Conveyor Accessories.

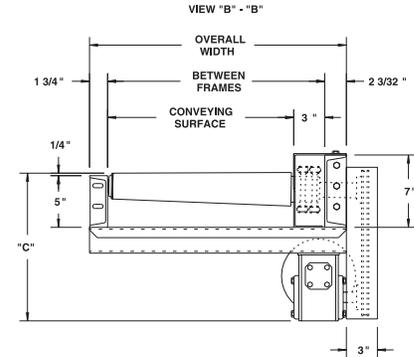
\*NOTE: Orientation of product may be affected because of straight rollers in curve. To maintain orientation, use tapered roller curve.

## 351TCDLRC | HEAVY DUTY TAPERED ROLLER CHAIN DRIVEN LIVE ROLLER CURVE

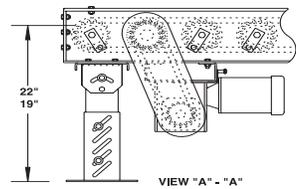


351TCDLRC is a true taper heavy duty chain driven live roller curve. Ideal for conveying pallets or other heavy unit loads, this conveyor features "true taper" to maintain product orientation throughout the curve.

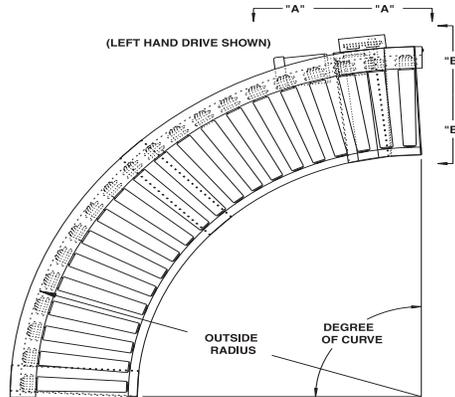
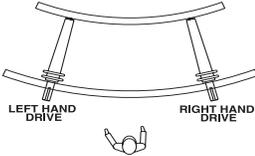
**SPECIFY MODEL NUMBER PER EXAMPLE**  
**351TCDLRC-51-90-R**  
 351TCDLRC-(between frames)-(degree)-(left or right)



■ 6 week shipment



**DETERMINING DRIVE LOCATION**



BF	UNIT		90°		45°		
	LARGE O.D.	SMALL O.D.	OUTSIDE RADIUS	QTY. RLRS.	WT (lbs.)	QTY. RLRS.	WT (lbs.)
21"	3-1/4"	2-1/2"	6-6"	20	778	10	423
27"	3-1/2"	2-1/2"	7'-1-1/2"	22	966	11	524
33"	3-3/4"	2-1/2"	7'-9-1/4"	24	1192	12	644
39"	4"	2-1/2"	8'-4-3/4"	26	1460	13	787
45"	4-1/4"	2-1/2"	8'-4-3/4"	26	1523	13	801
51"	4-1/2"	2-1/2"	9-1/2"	28	1889	14	990
57"	4-3/4"	2-1/2"	9'8"	30	2307	15	1210
63"	5"	2-1/2"	10-3-3/4"	32	2789	16	1464

### SPECIFICATIONS

- ▶ **TREAD ROLLERS:** Heavy duty 11 ga. tapered rollers, model 351T with sprockets, for true taper effect. See chart, upper right corner for roller dia.
- ▶ **CHAIN DRIVE:** Roller to roller with No. 60 circular roller chain.
- ▶ **END DRIVE:** Reversible drive either side mounted (shown above) or underside (specify). Main drive roller is supported by precision, heavy duty, lubricated, ball bearing units.
- ▶ **ROLLER CENTERS:** 6" RC measured at outside radius of curve.
- ▶ **SPEED:** 35 FPM, constant.
- ▶ **BED:** 5" at 6.7 lbs. and 7" at 9.8 lbs. structural steel channel frame.
- ▶ **BEARINGS:** Precision ABEC bearings.

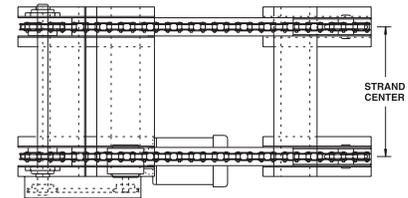
- ▶ **CHAIN GUARD:** The chain drive is enclosed, top and bottom, along the entire length of the conveyor.
- ▶ **MOTOR DRIVE:** 3/4 HP, 230/460/3, 60 cycle, Super "E" right angle gear motor.
- ▶ **DRIVE LOCATION:** Drive located on outside of curve. Specify right hand drive or left hand drive (drive hand determined with reference point located at outside of curve).
- ▶ **ELECTRICAL CONTROLS:** Optional.

HP @ 35FPM	"C"
3/4	15"
1	15-1/4"
1-1/2	16-1/8"
2	17

### OPTIONAL EQUIPMENT

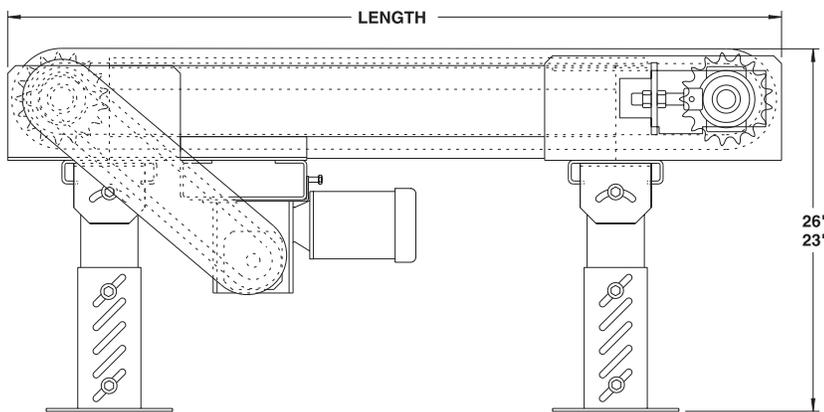
- BED:** Rollers on 4-1/2" centers on outside radius for 21"-39" BF.
- FLOOR SUPPORTS:** Conveyor shown with optional supports. Supports available. See Conveyor Accessories.
- SPEED:** Constant speed 1.5-60 FPM; DC variable speed; AC inverter variable speed. Other constant or variable speeds available. **NOTE: CAPACITY CHANGES WITH SPEED. 100 FPM MAX. WITH ROLLER-TO-ROLLER CHAIN DRIVE.**
- MOTORS:** Available through 3 HP in TEFC, explosion proof, dirty duty, 115/230/1, 575/3, etc.

# CD280 | 2-STRAND CHAIN DRAG CONVEYOR



Chain drag conveyors convey heavy duty unit loads and often are suited for products with unusual conveying characteristics such as pallets or specialty tote pans. Unit shown features OPTIONAL structural construction.

■ 4 week shipment



Length	WT. (lbs.)	Length	WT. (lbs.)
3'	377	7'	484
4'	409	8'	516
5'	420	9'	548
6'	452	10'	580

## SPECIFICATIONS

- ▶ **FRAME:** 7 ga. formed boxed channel.
- ▶ **CARRIER CHAIN:** No. 80 (model CD280) or no. 60 (model CD260) riveted roller chain.
- ▶ **WEAR STRIP:** UHMW long lasting wear strip, upper and lower.
- ▶ **CHAIN CENTERS:** 18"
- ▶ **CHAIN TAKE-UP:** Screw type located at tail end.
- ▶ **END DRIVE:** Allows one-direction (unit) operation; add optional center drive for reversible application.
- ▶ **CHAIN SPEED:** 35 FPM constant.
- ▶ **BEARINGS:** Heavy duty, lubricated, ball bearing unit with cast iron housings.
- ▶ **CAPACITY:** Unit load not to exceed 3000 lbs.
- ▶ **MOTOR DRIVE:** 1/2 HP, 230/460/3, 60 cycle, Super "E" right angle gear motor.
- ▶ **ELECTRICAL CONTROLS:** Optional.

## OPTIONAL EQUIPMENT

**STRANDS:** 3, 4 or more.

**CONSTRUCTION:** Durable structural frame.

**CHAIN CENTER:** 12", 24" or as required by application.

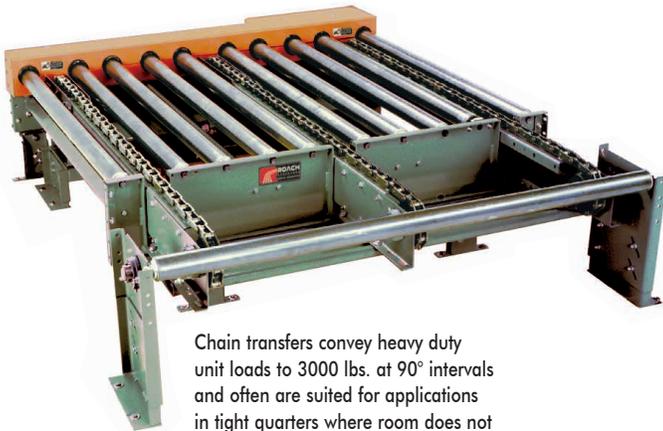
**FLOOR SUPPORTS:** Conveyor shown with optional supports. Supports available. See Conveyor Accessories.

**CHAIN SPEED:** 35-120 FPM, constant speed (specify). Other constant or variable speed available. **NOTE: CAPACITY CHANGES WITH SPEED.**

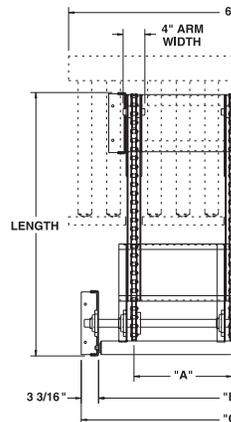
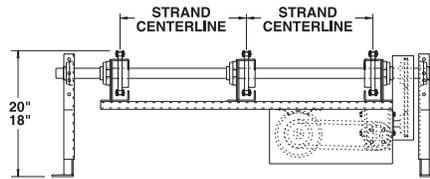
**MOTORS:** Available through 3 HP in TEFC, explosion proof, dirty duty, 115/230/1, 575/3, etc.

**ELECTRICAL CONTROLS:** Manual start/stop push button switch; magnetic starter; photo eye; limit switch; photo relay; others available.

# CT380/CT360 | 90° 3-STRAND CHAIN TRANSFER



Chain transfers convey heavy duty unit loads to 3000 lbs. at 90° intervals and often are suited for applications in tight quarters where room does not exist for large radius curves. Pivot type transfer above; positive type lift chain transfer shown at right, both mounted in optional 251CDLR (model at right includes optional blue paint).



## SPECIFICATIONS

- ▶ **TRANSFER ARM:** 7 ga. formed channel.
- ▶ **TRANSFER CHAIN:** No. 80 flat side bar (model CT380) or No. 60 flat side bar (model CT360) chain.
- ▶ **STANDARD LENGTHS:** 3', 4', 5', 6', 7' and 8' unit lengths.
- ▶ **CHAIN CENTERS:** 18"
- ▶ **CHAIN TAKE-UP:** Screw Type.
- ▶ **END DRIVE:** Allows one-direction (unit) operation; add optional center drive for reversible application.
- ▶ **LIFT:** Pivot type.
- ▶ **BEARINGS:** Heavy duty, lubricated, ball bearing unit with cast iron housings.
- ▶ **CHAIN SPEED:** 35 FPM constant.
- ▶ **MOTOR DRIVE:** 1/2 HP, 230/460/3, 60 cycle, Super "E" right angle gear motor.

- ▶ **CAPACITY:** 3000 lbs.
- ▶ **AIR CONTROLS:** Air bag(s) with single solenoid valve. (60-80) psi required.
- ▶ **CUTOUTS:** Required through conveyor frame transfer mounts in when using end drive; may be required by application for center drive transfers also.
- ▶ **ELECTRICAL CONTROLS:** Optional.

MODEL CT360/CT380 WTS. (lbs.)				
LENGTH	END DRIVE-PIVOT LIFT		CENTER DRIVE-PIVOT LIFT	
	CT360	CT380	CT360	CT380
3'	398	410	433	451
4'	444	460	479	501
5'	490	510	525	551
6'	536	560	571	601
7'	584	612	619	653
8'	631	663	665	704

■ 4 week shipment

## OPTIONAL EQUIPMENT

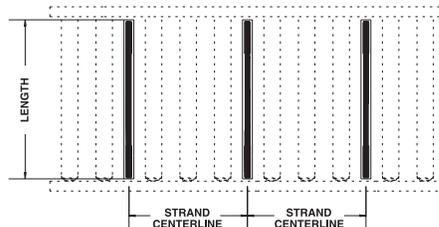
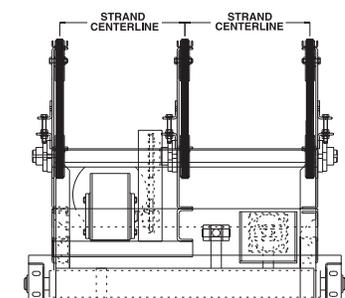
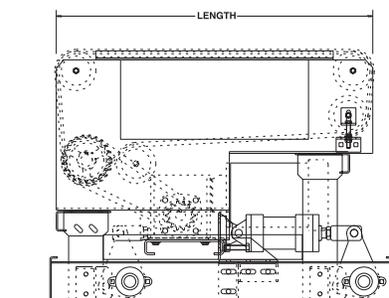
- STRANDS:** 2, 4 or more.
- POSITIVE LIFT:** Allows reversible drive and decreased overall length.
- FRL:** Filter, regulator, lubricator with 3/8" ports.
- FLOOR SUPPORTS:** Conveyor shown with optional supports. See Conveyor Accessories for various elevations and types.
- CHAIN CENTER:** 12", 24" or as required by application.
- CHAIN SPEED:** 35-120 FPM, constant speed (specify). Other constant or variable speed available. **NOTE: CAPACITY CHANGES WITH SPEED.**
- MOTORS:** Available through 2 HP in TEFC, explosion proof, dirty duty, 115/230/1, 575/3, etc.
- ELECTRICAL CONTROLS:** Optional.

"A"	"B"	"C"
12"	37"	43-3/8"
18"	49"	55-3/8"
24"	61"	67-3/8"

# VBT | 90° V-BELT TRANSFER



V-belt transfers are ideal for medium duty applications and are often used where product could be damaged by strands of chain on heavier duty chain transfers. Unit at left shown with frame cutout for use in belt driven live roller conveyor with 6" wide belting.



LENGTH	WT. (lbs.)	LENGTH	WT. (lbs.)
3'	395	6'	530
4'	440	7'	575
5'	485	8'	620

■ 4 week shipment

## SPECIFICATIONS

- ▶ **TRANSFER ARM:** 10 ga. formed channel.
- ▶ **TRANSFER BELT:** "B" section V-belt.
- ▶ **STANDARD LENGTHS:** 3', 4', 5', 6', 7' and 8' unit lengths.
- ▶ **V-BELT CENTERS:** As required.
- ▶ **CENTER DRIVE:** Allows reversible operation.

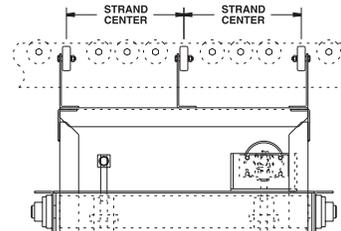
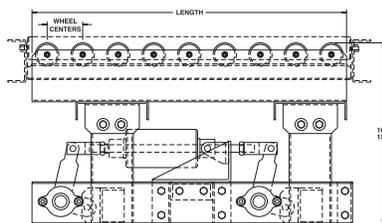
- ▶ **STRANDS:** 2,3,4 or more.
- ▶ **BEARINGS:** Heavy duty, lubricated, ball bearing unit with cast iron housings.
- ▶ **BELT SPEED:** As required.
- ▶ **MOTOR DRIVE:** 1/2 HP, 230/460/3, 60 cycle, Super "E" right angle gear motor.
- ▶ **FLOOR SUPPORTS:** Integral part of unit, with adjustment of 18" to 20" top of

- V-belt (down position).
- ▶ **LIFT:** Positive type
- ▶ **CAPACITY:** Unit load not to exceed 500 lbs.
- ▶ **ELECTRICAL CONTROLS:** Optional.
- AIR CONTROL:** 60-80 PSI required on air cylinders

# WT | 90° SKATE WHEEL TRANSFER



Shown mounted in optional conveyor



## SPECIFICATIONS

- ▶ **TRANSFER ARM:** 7 ga. formed channel.
- ▶ **TRANSFER WHEELS:** Frantz model 35Z on 3" wheel centers. Wheels are rated at 50 lbs. capacity each.
- ▶ **STRANDS:** 2,3,4 or more.
- ▶ **STANDARD LENGTHS:** 2', 3', 4', and 5'.

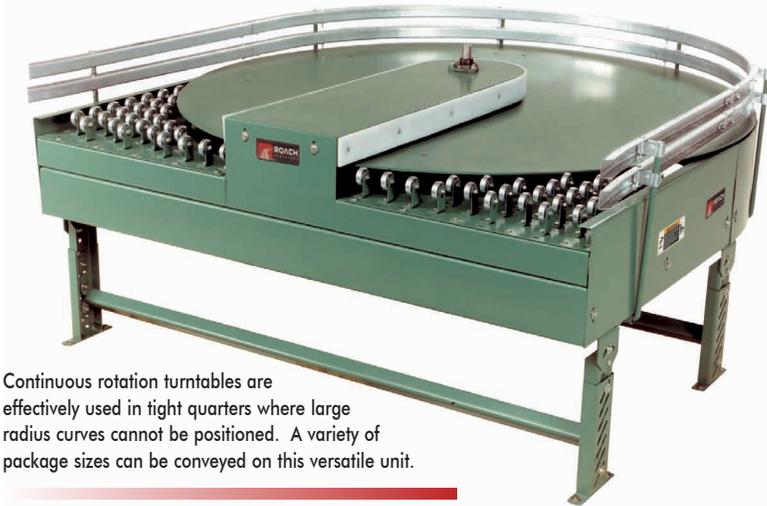
- ▶ **STRAND CENTERS:** As required.
- ▶ **LIFT:** Positive type lift with 1" of net lift.
- ▶ **BEARINGS:** Heavy duty, lubricated, ball bearing unit with cast iron housings.
- ▶ **MOUNTING:** Integral part of unit, with 15" top of wheel elevation (down position). Unit designed to mount between conveyor frames.

- ▶ **ELECTRICAL CONTROLS:** Optional.
- ▶ **CAPACITY:** Unit load not to exceed 500 lbs.
- ▶ **AIR CONTROLS:** Air cylinder (dou-

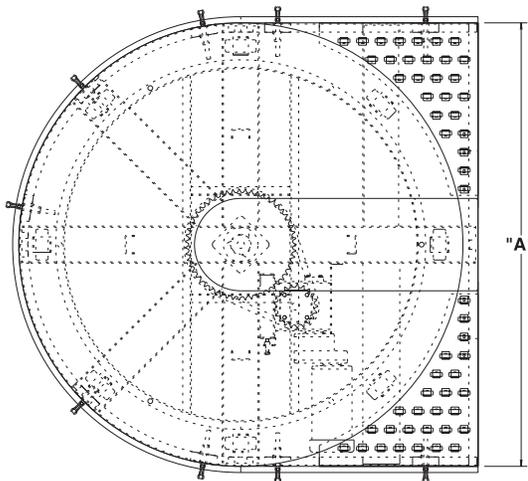
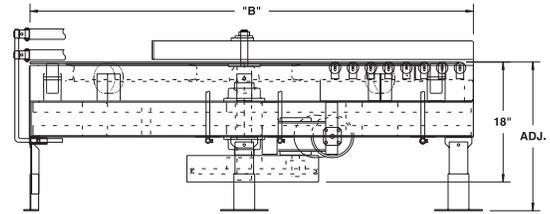
LENGTH	WT. (lbs.)	LENGTH	WT. (lbs.)
2'	375	4'	440
3'	395	5'	485

■ 4 week shipment

# CRT | MEDIUM DUTY CONTINUOUS ROTATION POWERED TURNTABLE



Continuous rotation turntables are effectively used in tight quarters where large radius curves cannot be positioned. A variety of package sizes can be conveyed on this versatile unit.



"A"	"B"	WEIGHT (lbs.)
3'	38-1/2"	523
4'	50-1/2"	741
6'	74-1/2"	959
8'	98-1/2"	1117

## SPECIFICATIONS

- ▶ **ROTATION:** 360° continuous.
  - ▶ **SPEED:** 60 FPM at outside diameter.
  - ▶ **CHAIN DRIVE:** No. 80 roller chain.
  - ▶ **CHAIN GUARD:** The chain drive is completely enclosed.
  - ▶ **CASTERS:** (8) 5" dia. heavy duty rubber-covered casters support rotation of turntable carrier platform.
  - ▶ **SKATE WHEELS:** 1-15/16" dia. zinc-plated skate wheels located at infeed and discharge ends to provide access onto and off of turntable.
  - ▶ **BEARINGS:** Removable type, heavy duty ball bearing 4-hole flange.
  - ▶ **ELEVATION:** Minimum 18" to top of plate.
  - ▶ **CARRIER PLATFORM:** 1/4" thick steel plate rotates on heavy duty casters to carry unit loads.
  - ▶ **MOTOR DRIVE:** 3/4 HP, 230/460/3, 60 cycle, Super "E" right angle gear motor.
  - ▶ **CAPACITY:** 500 lbs. maximum load; 150 lbs. maximum unit load.
- ELECTRICAL CONTROLS:** Optional.

## OPTIONAL EQUIPMENT

**ELEVATION:** Other height elevations to top of plate available; consult factory.

**MOTORS:** Available through 2 HP in TEFC, explosion proof, dirty duty, 115/230/1, 575/3, etc.

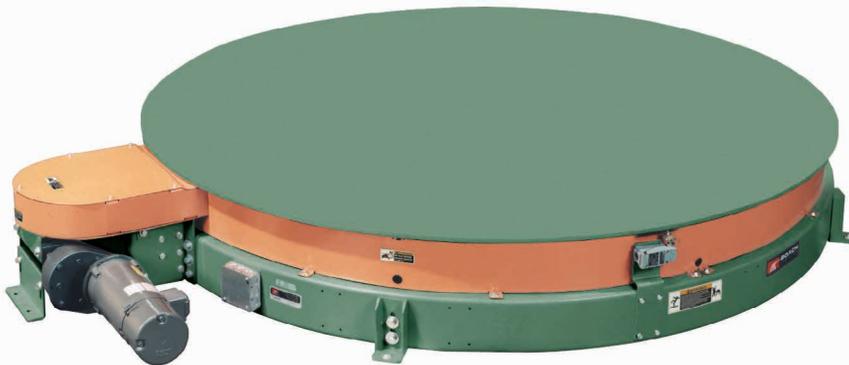
**ELECTRICAL CONTROLS:** Manual start/stop push button switch; magnetic starter; limit switch; photo relay; others available.

**FLOOR SUPPORTS:** Conveyor shown with optional supports. See Conveyor Accessories for various elevations and types.

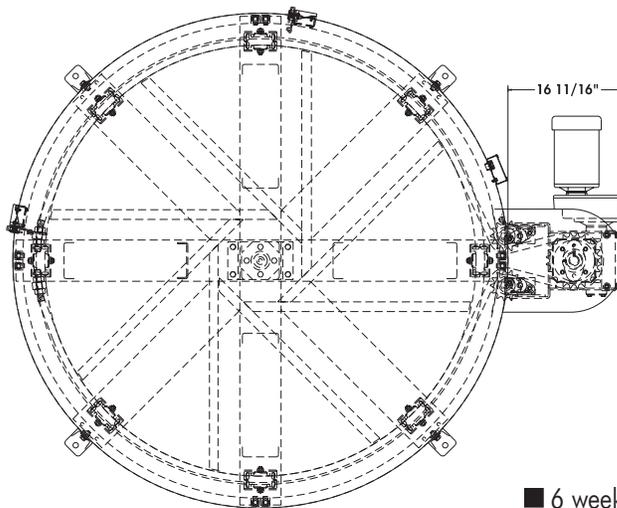
**NOTE:** Orientation of product may be affected using continuous rotation powered turntable. If orientation of product must be maintained, consult factory for other options.

■ 6 week shipment

# IPT | HEAVY DUTY INDEXING POWERED TURNTABLE



Indexing powered turntables convey heavy unit loads in numerous applications. A heavy duty chain driven live roller may be mounted on turntable platform and rotated to orient product at specified intervals allowing operator to perform a variety of tasks.



■ 6 week shipment

## SPECIFICATIONS

- ▶ **ROTATION:** 2 position, 3 position or 4 position.
- ▶ **SPEED:** 35 FPM at outside diameter.
- ▶ **CHAIN DRIVE:** No. 80 roller chain.
- ▶ **CHAIN GUARD:** The chain drive is completely enclosed.
- ▶ **CASTERS:** (8) 4" dia. heavy duty rubber-covered casters support rotation of turntable carrier platform.
- ▶ **DIAMETER:** 3'-0", 3'-6", 4'-0", 4'-6", 5'-0", 5'-6", 6'-0", 6'-6", 7'-0", 7'-6" and 8'-0" dia.
- ▶ **CARRIER PLATFORM:** 3" structural platform with 1/2" thick steel plate

supported by heavy duty casters.

- ▶ **BEARINGS:** Heavy duty ball bearing 4-hole flange.
- ▶ **CAPACITY:** 4000 lbs. max. product load.
- ▶ **MOTOR DRIVE:** 3/4 HP, 230/460/3, 60 cycle, Super "E" right angle gear motor with brake.
- ▶ **ELEVATION:** Minimum 12-1/2" to top of plate with (4) structural leveling supports.
- ▶ **ELECTRICAL CONTROLS:** Limit switches supplied as follows: 2 position = 2 limit switches; 3 position = 3 limit switches; 4 position = 4 limit switches.

## SPECIFY MODEL NUMBER PER

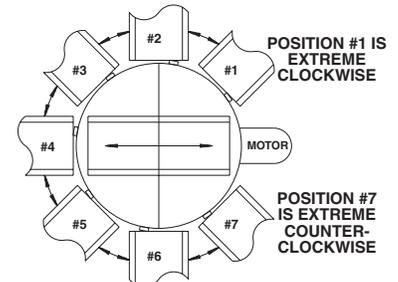
**EXAMPLE**  
IPT-72-2

IPT-(diameter)-(stop positions)

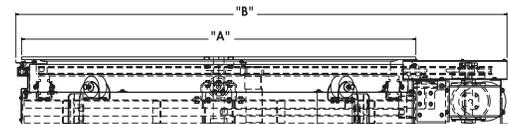
Diameter available in 36", 42", 48", 54", 60", 66", 72", 78", 84", 90" and 96".

Number of stop positions is 2, 3 or 4.

**MINIMUM CONVEYOR DISTANCE IS 45° ON EITHER SIDE OF TURNTABLE DRIVE; TURNTABLE IS CAPABLE OF 45° INTERVALS**



## GENERIC REFERENCE FOR STANDARD



12-1/2" Minimum Height

"A"	"B"	WEIGHT (lbs.)
3'	53-3/4"	718
3'-6"	59-3/4"	814
4'	65-3/4"	926
4'-6"	71-3/4"	1037
5'	77-3/4"	1158
5'-6"	83-3/4"	1285
6'	89-3/4"	1421
6'-6"	95-3/4"	1564
7'	101-3/4"	1718
7'-6"	107-3/4"	1877
8'	113-3/4"	2045

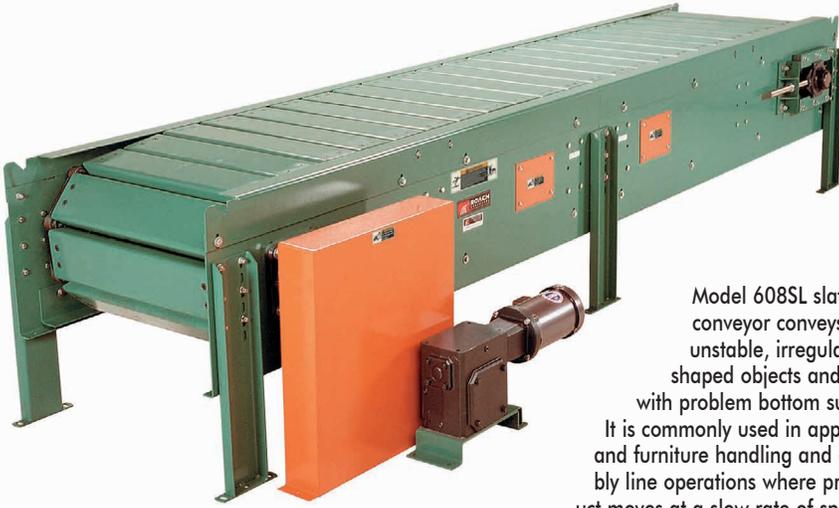
## OPTIONAL EQUIPMENT

**ELEVATION:** Other height elevations to top of plate available; consult factory.

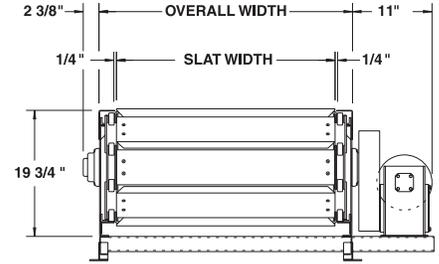
**MOTORS:** Available through 2 HP in TEFC, explosion proof, dirty duty, 115/230/1, 575/3, etc.

**ELECTRICAL CONTROLS:** Manual start/stop push button switch; magnetic starter; photo relay; others available.

## 608SL | HEAVY DUTY SLAT CONVEYOR

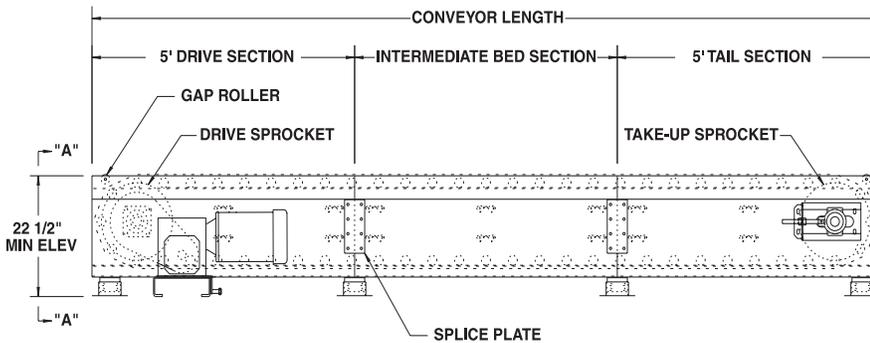


Model 608SL slat conveyor conveys unstable, irregular shaped objects and those with problem bottom surfaces. It is commonly used in appliance and furniture handling and assembly line operations where product moves at a slow rate of speed through several operator work stations.



■ 6 week shipment

SLAT	25"	31"	37"	43"	49"
OAW	31"	37"	43"	49"	55"
OAL	UNIT WEIGHT (lbs.)				
10'	1801	1933	2065	2197	2329
20'	2993	3233	3472	3711	3951
30'	4186	4532	4879	5226	5572
40'	5378	5832	6286	6740	7194
50'	6570	7132	7693	8254	8815
60'	7763	8431	9100	9768	10437
70'	8955	9731	10507	11283	12058
80'	10147	11030	11914	12797	13680
90'	11340	12330	13321	14311	15301
100'	12532	13630	14728	15825	16923
#/FT.	119	130	141	151	162



### SPECIFICATIONS

- ▶ **SLAT:** 5-3/4" wide formed 7 ga. steel channel. Slat chain, 6" pitch @ 2500 lb. pull each
- ▶ **DRIVE:** End side mount drive.
- ▶ **SPEED:** 35 FPM, constant (maximum).
- ▶ **TAKE-UP:** Screw type.
- ▶ **BED:** 19-3/4" deep formed steel channel.
- ▶ **MOTOR DRIVE:** 3/4 HP, 230/460/3, 60 cycle, Super "E" right angle gear motor.
- ▶ **DRIVE CHAIN:** Sizes will vary with length of conveyor and chain pull required.
- ▶ **ELECTRICAL CONTROLS:** Optional.

### OPTIONAL EQUIPMENT

**FLOOR SUPPORTS:** Conveyor shown with optional supports. See Conveyor Accessories for various elevations and types. Minimum 17" top of slat with floor mounted drive and 6" tooth sprocket.

**CONVEYOR SPEED:** Other constant or variable speed drives available.

**MOTORS:** Available through 5 HP in TEFC, explosion proof, dirty duty, 115/230/1, 575/3, etc.

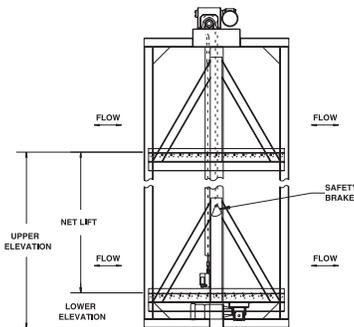
**ELECTRICAL CONTROLS:** Manual start/stop push button switch; magnetic starter; photo eye; others available.

# RVC / CVC | VERTICAL CONVEYORS



Model RVC above shown with optional blue powder paint.

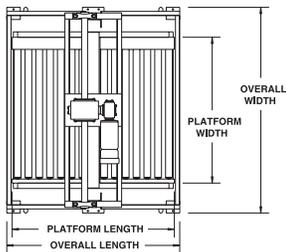
RVC SIDE VIEW



MODEL RVC Z-FLOW

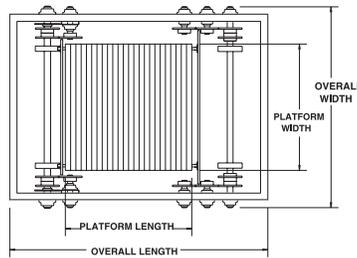


RVC TOP VIEW

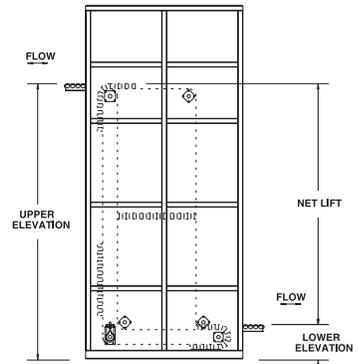


MODEL CVC Z-FLOW

CVC TOP VIEW



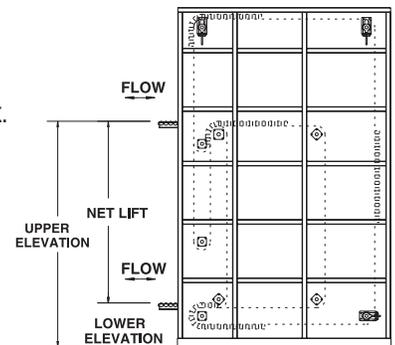
CVC-Z SIDE VIEW



MODEL CVC C-FLOW



CVC-C SIDE VIEW



## RVC SPECIFICATIONS

- ▶ **CAPACITY:** Up to 3000 lbs.
- ▶ **FRAME:** Heavy duty tubular construction.
- ▶ **DRIVE:** (2) heavy strands of chain to raise and lower carrier platform.
- ▶ **RATE:** Varies with unit height.
- ▶ **SPEED:** 60 FPM (120 FPM maximum).
- ▶ **LOADING:** One or more loading points may be selected at any level.
- ▶ **PLATFORM:** Specify conveyor type.
- ▶ **GUARDS:** Expanded metal guarding.
- ▶ **CONTROLS:** Optional.

## CVC SPECIFICATIONS

- ▶ **CAPACITY:** Up to 3000 lbs.
- ▶ **FRAME:** Heavy duty tubular construction.
- ▶ **DRIVE:** (4) continuous roller chains driven by a suitably sized brake motor.
- ▶ **RATE:** Up to 25 loads per minute.
- ▶ **SPEED:** 60 FPM (100 FPM maximum).
- ▶ **LOADING:** Automatic loading is accomplished by metering belt. Operator attention is not required.
- ▶ **PLATFORM:** Size depends upon product.
- ▶ **GUARDS:** Expanded metal guarding.
- ▶ **CONTROLS:** Supplied as required.

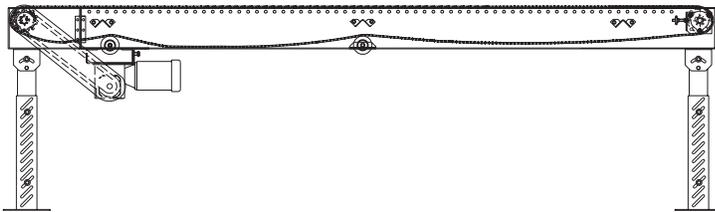
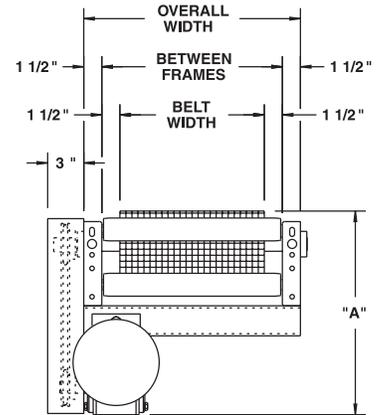
■ 8 week shipment

CV. NO.	CARRIER PLATFORM DIMENSIONS		PLATFORM CAPACITY
	LENGTH	WIDTH	
60	3" INCR. UP TO 49-1/2"	18"-60"	200
80	4" INCR. UP TO 78"	24"-84"	600
100	5" INCR. UP TO 90-1/2"	30"-96"	1000
122	6" INCR. UP TO 105"	36"-96"	2000
143	8" INCR. UP TO 108"	36"-96"	3000

## 700SBW | WIRE MESH BELT CONVEYOR



Roach wire mesh belt conveyors can be used in a variety of conditions to convey hot, cold or oily products in oven, cooling or other special conditions.



### SPECIFICATIONS

- ▶ **BELTING:** 1/2" x 1" x 11 ga. clinched edge, galvanized wire mesh belt.
- ▶ **DRIVE SPROCKETS:** 4" dia. sprocket with 1-3/16" dia. shaft or 8" dia. sprocket with 1-7/16" dia. shaft.
- ▶ **TAIL SPROCKETS:** 4" dia. sprocket with 1-3/16" dia. shaft.
- ▶ **END DRIVE:** One-direction unit operation.
- ▶ **TAKE-UP:** Screw type unit at tail end provides 12" belt take-up.
- ▶ **RETURN ROLLERS:** 1.9" dia. x 16ga. galv. steel, model 196G, adjustable.
- ▶ **BED:** 7" x 1-1/2" x 12 ga. formed channel frame with UHMW wear strips.
- ▶ **BEARINGS:** Drive and tail shaft bearings are precision, heavy duty, lubricated, ball bearing units with cast iron housings.
- ▶ **BELT SPEED:** 60 FPM, constant.

- ▶ **MOTOR DRIVE:** 1/2 HP, 230/460/3, 60 cycle, Super "E" right angle gear motor.
- ▶ **ROLLER CHAIN:** Drive shaft is driven by No. 50 roller chain for 1-1/2 HP or less and No. 60 chain on larger drives. Chain take-up provided on motor base.

HP @ 60FPM	"A" MAX		"B" MAX	
	4" DRV.	8" DRV.	4" DRV.	8" DRV.
1/2	16-5/8"	16-5/8"	27-3/32"	33-3/32"
3/4	17"	17"	27-23/32"	33-23/32"
1	17-1/4"	17-1/4"	28-15/32"	34-15/32"
1-1/2	18-1/8"	18-1/8"	31-3/32"	37-3/32"
2	19"	19"	32-3/32"	38-3/32"

■ 4 week shipment

### OPTIONAL EQUIPMENT

**BELTING:** High carbon, stainless steel, others available. Consult factory.

**SPEED:** Constant speed 1.5-60 FPM; DC variable speed; AC inverter variable speed. Other constant or variable speeds available. **NOTE: CAPACITY CHANGES WITH SPEED.**

**MOTORS:** Available through 2 HP in TEFC, explosion proof, dirty duty, 115/230/1, 575/3, etc.

**FLOOR SUPPORTS:** Conveyor shown with optional supports. Supports, knee braces, casters, and polytier supports available. See Conveyor Accessories.

**ELECTRICAL CONTROLS:** Magnetic or manual starter; limit switch; others available.

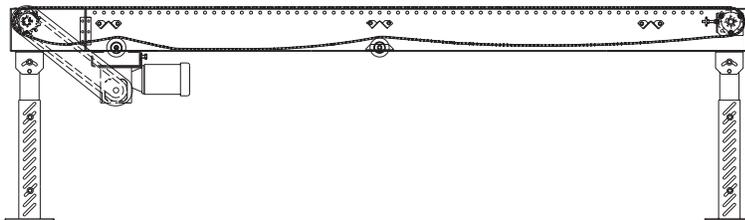
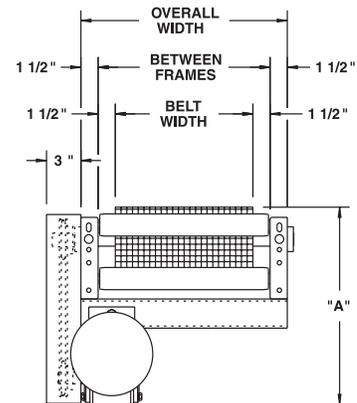
### WARNING

Prevent pinch points that exist when belt conveyors are permanently attached to other conveyors or equipment!

# 700SBO | OPEN BED STYLE WIRE MESH BELT CONVEYOR



Roach open type wire mesh belt conveyors offer opening in bed to allow air or various sprays to pass through belt and conveyors to accommodate numerous spraying or drying applications.



## SPECIFICATIONS

- ▶ **BELTING:** 1/2" x 1" x 11 ga. clinched edge, galvanized wire mesh belt.
- ▶ **DRIVE SPROCKETS:** 4" dia. with 1-3/16" dia. shaft; 8" dia. with 1-7/16" dia. shaft.
- ▶ **TAIL SPROCKETS:** 4" dia. sprocket with 1-3/16" dia. shaft.
- ▶ **END DRIVE:** One-direction unit operation.
- ▶ **TAKE-UP:** Screw type unit at tail end provides 12" belt take-up.
- ▶ **BED:** 7" x 1-1/2" x 12 ga. open type formed channel frame w/ UHMW wear strips.
- ▶ **RETURN ROLLERS:** 1.9" dia. x 16ga. galv. steel, model 196G, adjustable.
- ▶ **BELT SPEED:** 60 FPM, constant.

- ▶ **BEARINGS:** Drive and tail shaft bearings are precision, heavy duty, lubricated, ball bearing units with cast iron housings.
- ▶ **MOTOR DRIVE:** 1/2 HP, 230/460/3, 60 cycle, Super "E" right angle gear motor.
- ▶ **ROLLER CHAIN:** Drive shaft is driven by No. 50 roller chain for 1-1/2 HP or less and No. 60 chain on larger drives. Chain take-up provided on motor base.

HP @ 60FPM	"A" MAX		"B" MAX	
	4" DRV.	8" DRV.	4" DRV.	8" DRV.
1/2	16-5/8"	16-5/8"	27-3/32"	33-3/32"
3/4	17"	17"	27-23/32"	33-23/32"
1	17-1/4"	17-1/4"	28-15/32"	34-15/32"
1-1/2	18-1/8"	18-1/8"	31-3/32"	37-3/32"
2	19"	19"	32-3/32"	38-3/32"

■ 4 week shipment

## OPTIONAL EQUIPMENT

**BELTING:** High carbon, stainless steel, others available. Consult factory.

**SPEED:** Constant speed 1.5-60 FPM; DC variable speed; AC inverter variable speed. Other constant or variable speeds available. **NOTE: CAPACITY CHANGES WITH SPEED.**

**MOTORS:** Available through 2 HP in TEFC, explosion proof, dirty duty, 115/230/1, 575/3, etc.

**FLOOR SUPPORTS:** Conveyor shown with optional supports. Supports, knee braces, casters, and polytier supports available. See Conveyor Accessories.

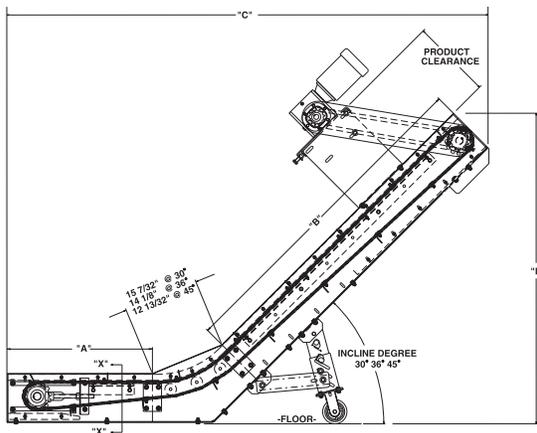
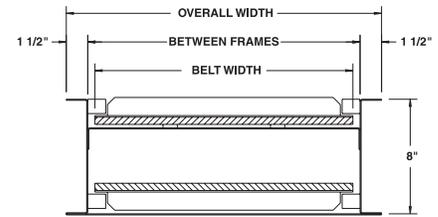
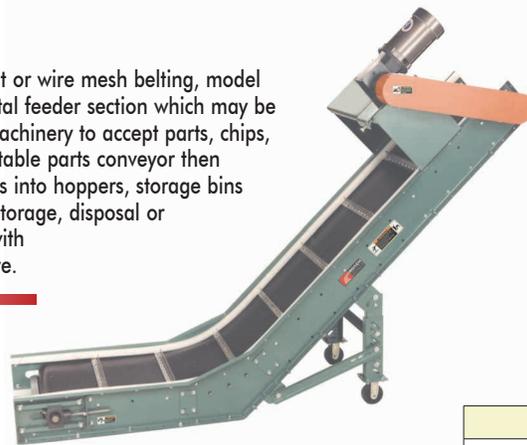
**ELECTRICAL CONTROLS:** Magnetic or manual starter; limit switch; others available.

## WARNING

Prevent pinch points that exist when belt conveyors are permanently attached to other conveyors or equipment!

# PC-F | PARTS CONVEYOR WITH FEEDER

Available with nitrile belt or wire mesh belting, model PC-F includes a horizontal feeder section which may be stationed underneath machinery to accept parts, chips, slugs or scrap. This portable parts conveyor then transports such materials into hoppers, storage bins or other containers for storage, disposal or recycling. Unit shown with standard right hand drive.



		"A"		24"	30"	42"
BELT	BF	OAW	"B"	UNIT WEIGHTS (lbs.)		
12"	13"	16"	45"	210	218	234
12"	13"	16"	54"	219	228	243
12"	13"	16"	66"	233	250	256
18"	19"	22"	45"	233	243	261
18"	19"	22"	54"	244	254	272
18"	19"	22"	66"	260	270	288
24"	25"	28"	45"	256	268	290
24"	25"	28"	54"	269	281	303
24"	25"	28"	66"	287	299	321

**NOTE:** "A" or "B" dimensions not to exceed 10'. Combined lengths of "A" and "B" not to exceed 15'. Cleat centers must not exceed 12". Cleats available in rigid construction ONLY. Consult factory for optional cleats. Minimum parts size of 1/2" cube for neoprene belt, 1" cube for flat wire mesh belt.

## SPECIFICATIONS

- ▶ **BELTING:** Black PVC-120 (CXFS) or 1/2" x 1" flat wire mesh belt with 1-1/2" high galvanized cleats on 12" centers.
- ▶ **DRIVE PULLEY:** 4" dia., with 1-3/16" dia. shaft, fully lagged with nitrile belt; 4" dia. sprockets supplied with flat wire mesh belt.
- ▶ **TAIL PULLEY:** 4" dia. with 1-3/16" dia. shaft.
- ▶ **TAKE-UP:** Screw type unit at tail pulley provides 12" belt take-up.
- ▶ **BED:** 8" deep x 12 ga. enclosed box type construction with 14 ga. steel belt return pan.
- ▶ **BEARINGS:** All pulley bearings are precision, heavy duty, lubricated, ball bearing units with cast iron housings.
- ▶ **BELT SPEED:** 35 FPM, constant.

- ▶ **MINIMUM PARTS SIZE:** 1/2" cube for nitrile belt, 1" cube for flat wire mesh belt.
- ▶ **INCLINE:** 30, 36 and 45° (specify).
- ▶ **PORTABLE SUPPORT:** Adjustable floor support with 4" dia. casters and bracing.
- ▶ **MOTOR DRIVE:** 1/2 HP, 230/460/3, 60 cycle, Super "E" right angle gear motor.
- ▶ **CAPACITY:** 350 lbs. total distributed load.
- ▶ **ROLLER CHAIN:** No. 50 chain provided at drive pulley. Chain take-up provided on motor base.
- ▶ **ELECTRICAL CONTROLS:** Optional.

## SPECIFICATION TABLE

■ 3 week shipment

45°				36°				30°			
"A"	"B"	"C"	"D"	"A"	"B"	"C"	"D"	"A"	"B"	"C"	"D"
24"	45"	72-7/8"	44-1/2"	24"	45"	78-1/2"	39-1/32"	24"	45"	81-3/4"	34-3/8"
24"	54"	79-1/4"	50-7/8"	24"	54"	85-3/4"	44-1/8"	24"	54"	89-1/2"	39"
24"	66"	87-3/4"	59-1/2"	24"	66"	95-1/2"	51-1/8"	24"	66"	99-7/8"	45"
30"	45"	78-7/8"	44-1/2"	30"	45"	84-1/2"	39-1/32"	30"	45"	87-3/4"	34-3/8"
30"	54"	85-1/4"	50-7/8"	30"	54"	91-3/4"	44-1/8"	30"	54"	95-1/2"	39"
30"	66"	93-3/4"	59-1/2"	30"	66"	101-1/2"	51-1/8"	30"	66"	105-7/8"	45"
42"	45"	90-7/8"	44-1/2"	42"	45"	96-1/2"	39-1/32"	42"	45"	99-3/4"	34-3/8"
42"	54"	97-1/4"	50-7/8"	42"	54"	103-3/4"	44-1/8"	42"	54"	107-1/2"	39"
42"	66"	105-3/4"	59-1/2"	42"	66"	113-1/2"	51-1/8"	42"	66"	117-7/8"	45"

## OPTIONAL EQUIPMENT

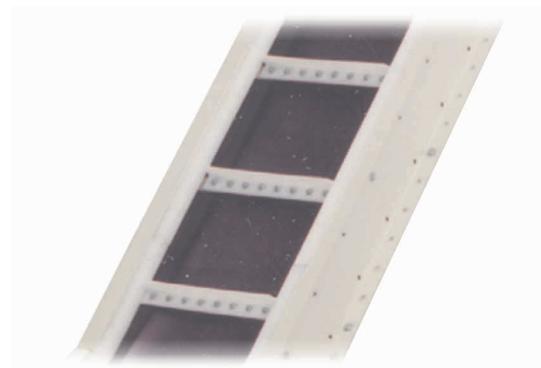
► **SPEED:** Constant speed 1.5-60 FPM; DC variable speed; AC inverter variable speed. Other constant or variable speeds available.

**NOTE:** CAPACITY CHANGES WITH SPEED. 100 FPM MAX. WITH ROLL-TO-ROLL CHAIN DRIVE.

► **MOTORS:** Available through 1 HP in Super "E", explosion proof, dirty duty, brake motor, 115/230/1, 575/3, etc.

► **FLOOR SUPPORTS:** Supports and knee braces available. See Conveyor Accessories.

► **ELECTRICAL CONTROLS:** Magnetic starter (one direction or reversible); one direction manual starter; momentary start/stop push button station; forward/reversing/stop push button station; mounting and pre-wiring for units 12'-0" long and under; limit switch, photo relay; others available.

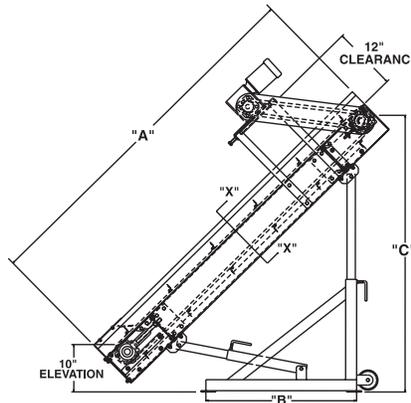
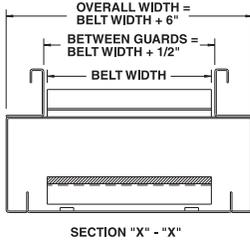


OPTIONAL UHMW CLEATS

# PC | PARTS CONVEYOR



Parts conveyors are widely used to convey chips, slugs or scrap materials to hoppers or other containers for disposal or recycling. Model PC, at left is shown with nitrile belt. PC at right includes wire mesh belting. Each PC is supplied with flapper gate at infeed end and right hand drive.



## SPECIFICATIONS

- ▶ **BELTING:** Black PVC-120 (CXFS) with 1-1/2" high molded cleats on 12" centers; 1/2" x 1" flat wire mesh belt with 1-1/2" high galv. cleats on 12" centers. **NOTE:** Units with 6" wide belt not available with wire mesh belt.
- ▶ **DRIVE PULLEY:** 4" dia. with 1-3/16" dia. shaft, crowned and fully lagged.
- ▶ **TAIL PULLEY:** 4" dia., crowned, with 1-3/16" dia. shaft.
- ▶ **BELT RETURN:** Formed steel slide retains belt and cleats inside bed.
- ▶ **BEARINGS:** All pulley bearings are precision, heavy duty, lubricated, ball bearing units with cast iron housings.
- ▶ **BELT SPEED:** 60 FPM, constant.
- ▶ **BED:** 7" deep x 12 ga. one piece formed box-type construction.

- ▶ **TAKE-UP:** Screw type unit at tail pulley provides 12" belt take-up.
- ▶ **PORTABLE SUPPORT:** 4" dia. casters, tubular construction, adjustable both ends.
- ▶ **GUARD RAILS:** 3-1/2" high x 12 ga. formed steel with gate at infeed.
- ▶ **MOTOR DRIVE:** 1/2 HP, 230/460/3, 60 cycle, Super "E" right angle gear motor.
- ▶ **CAPACITY:** 330 lbs. total distributed live load at 60 FPM.
- ▶ **ELECTRICAL CONTROLS:** Optional.

## OPTIONAL EQUIPMENT

**DRIVE CLEARANCE:** Motor drive may be mounted higher above bed or underneath bed for additional clearance.

**FLOOR SUPPORTS:** Permanent, adjustable supports available. Consult factory.

**BELT SPEED:** Constant speed 10 to 60 FPM; DC variable speed; AC inverter variable speed. Other constant or variable speeds available. **NOTE: CAPACITY CHANGES WITH SPEED.**

**MOTORS:** Available through 1 HP in TEFC, explosion proof, dirty duty, 115/230/1, 575/3, etc.

**ELECTRICAL CONTROLS:** Magnetic starter; manual starter; momentary start/stop push button station; mounting and pre-wiring for units 12'-0" long and under; limit switch; photo relay; others available.

**NOTE:** Minimum parts size of 1/2" cube for nitrile belt, 1" cube for flat wire mesh belt.

BELT		*6"	8"	12"	18"	24"
BED		12"	12"	18"	24"	30"
"A"	"B"	"C" MAX	UNIT WEIGHTS (lbs.)			
4'	18"	36"	413	417	480	618
6'	30"	56"	447	451	515	659
7'	36"	61"	465	469	575	688
9'	48"	78"	502	506	595	723
11'	60"	95"	539	543	615	764

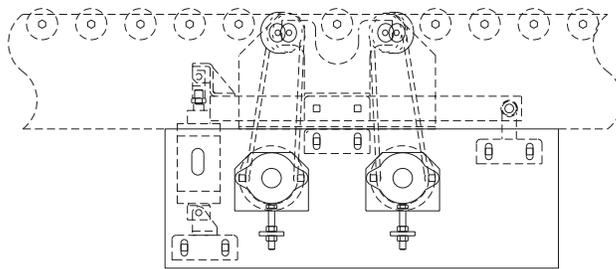
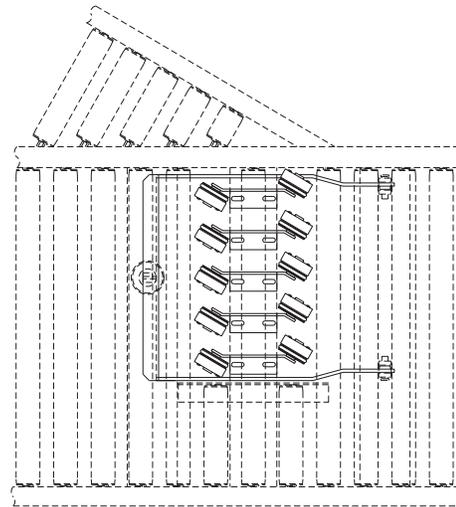
\*NOTE: Units with 6" wide belt not available with wire mesh belt.

■ 3 week shipment

# SD60 | SKEWED WHEEL DIVERTER



Shown mounted in optional conveyor



## SPECIFICATIONS

- ▶ **BELTS:** 1/4" dia. round polyurethane.
- ▶ **DRIVE WHEELS:** 2-1/2" O.D. x 3/4" face polyurethane, quantity as required, driven by 1/4" dia. polyurethane belts.
- ▶ **DRIVE SHAFT:** 1-3/16" dia.
- ▶ **AIR CYLINDER:** Double action.
- ▶ **AIR CONTROLS:** Single solenoid valve. (60-80) PSI required
- ▶ **FRAME ASSEMBLY:** Designed to mount into 196LR, 796CALR and 196LS line shaft driven conveyor.
- ▶ **DIVERSION ANGLE:** 30°, 45° and 90°. Guard rails on take-away spur conveyor may be required at various angles.
- ▶ **RATE:** Up to 60 sorts per minute.
- ▶ **BEARINGS:** Heavy duty, lubricated, ball bearing units with cast iron housings.
- ▶ **SPEED:** 60-180 FPM, constant. Other speeds available. Consult factory.
- ▶ **MOTOR DRIVE:** 1/2 HP, 230/460/3, 60 cycle, Super "E" right angle gear motor.
- ▶ **CAPACITY:** 50 lbs. per ft.; maximum unit load not to exceed 150 lbs.

## OPTIONAL EQUIPMENT

**SPEED:** Unit speed may be increased from 120 to 250 FPM, constant speed (specify).

**MOTORS:** Available in TEFC, explosion proof, dirty duty, 115/230/1, 575/3, etc.

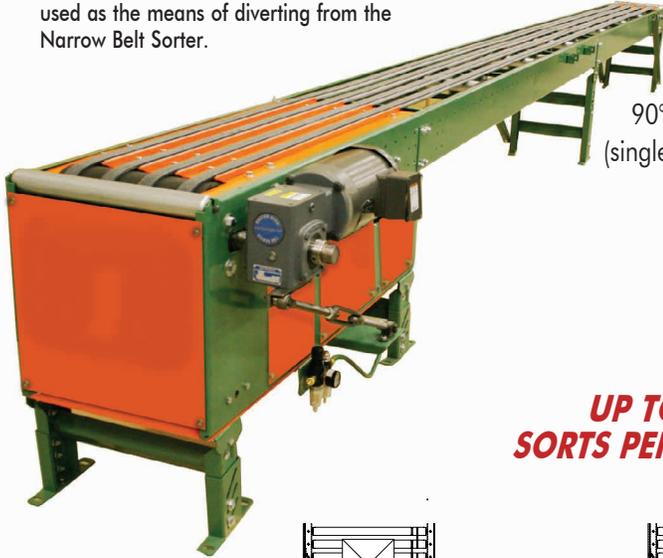
**SLAVE DRIVEN:** Driven by drive shaft on 196LS line shaft conveyor or by return direction of belt on belt driven live roller conveyor. Consult factory.

**ELECTRICAL CONTROLS:** Designed per application. Consult factory.

■ 4 week shipment

# NBS | NARROW BELT SORTER

The Narrow Belt Sorter utilizes multiple belts to transport product to diverters that have been strategically located along the sorter. Both the Skewed Wheel Diverter and the Roller Diverter can be used as the means of diverting from the Narrow Belt Sorter.



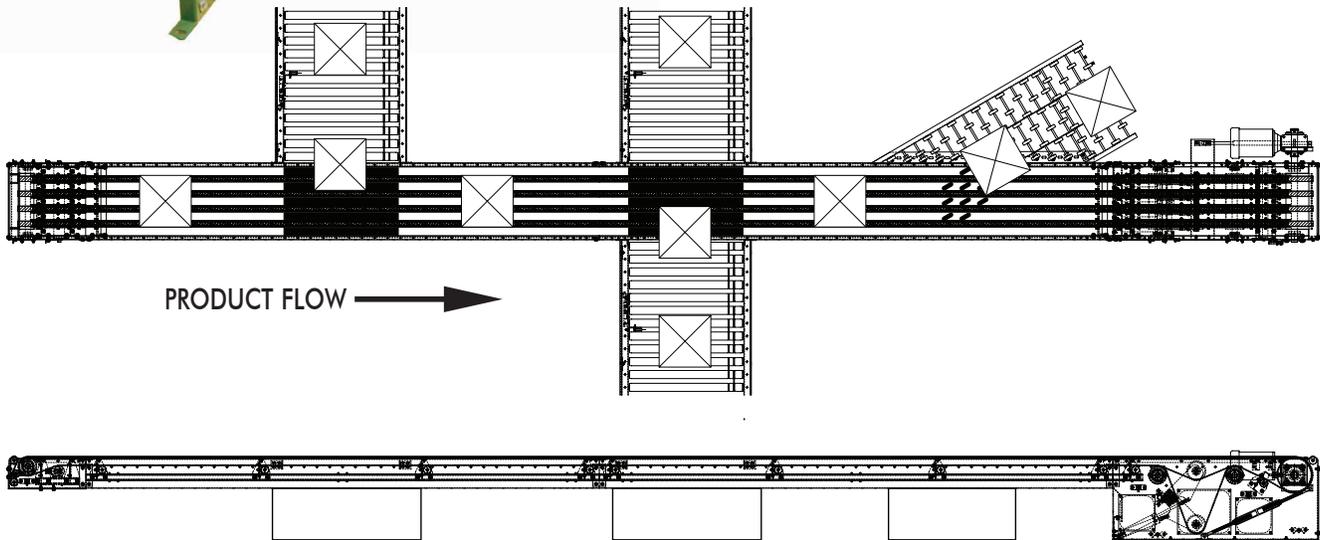
90° Roller Transfer  
(single or bi-directional)



30° Skewed Wheel Diverter  
(single direction)



**UP TO 75  
SORTS PER MINUTE**



## SPECIFICATIONS

► **BELTING:** Ultimate 240, 1-1/4" wide running on UHMW guide tracks on 3-1/2" centers.

► **DRIVE PULLEY:** 8" dia. with 1-7/16" dia. shaft, both machine crowned and fully lagged.

► **TAIL PULLEY:** 4" dia., machine crowned, with 1-3/16" dia. shaft.

► **SAFETY POP-OUT ROLLER:** Standard on both ends, 1.9" dia. x 16 ga. galv. steel roller, model 196G.

► **TAKE-UP:** Pneumatic belt tension mechanism

► **BELT SPEED:** 300 FPM, maximum (speeds are dependent up upon product size and weight)

► **AIR CONTROLS:** Single solenoid 60 PSI required

► **CAPACITY:** Product not to exceed 60 lbs.

► **90° ROLLER TRANSFER:** Model 156 high speed 1-1/2" x 16 ga. rollers

with urethane covering. Single or bi-directional.

► **30° SKEWED WHEEL DIVERTER:** Urethane covered drive wheels. Single direction only. Guard rails on take-away spur conveyor may be required.

► **DIVERTER DRIVE:** Independantly driven

► **RATE:** Up to 60 sorts per minute.

■ 8-10 week shipment

# 796 SORT BELT | PIVOTING BELT SORTER

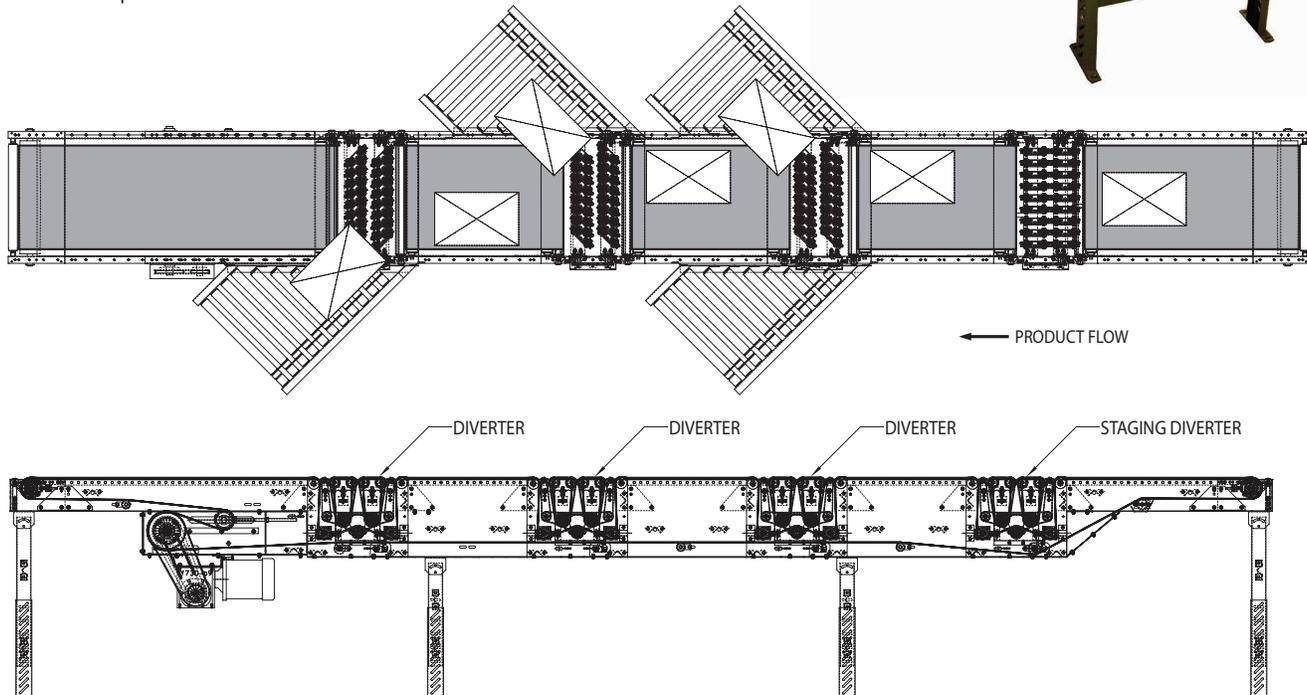


The Pivoting Belt Diverter has a high rate package sortation. As many as 75 cartons may be accurately sorted per minute with belt speeds as high as 300 fpm.



**UP TO 75  
SORTS PER MINUTE**

■ 6-8 week shipment



## SPECIFICATIONS

- ▶ **BELTING:** Trackmate
- ▶ **DRIVE PULLEY:** 8" dia. with 1-7/16" dia. shaft, both machine crowned and fully lagged.
- ▶ **TAIL PULLEY:** 4" dia., machine crowned, with 1-3/16" dia. shaft.
- ▶ **SAFETY POP-OUT ROLLER:** Standard on both ends, 1.9" dia. x 16 ga. galv. steel roller, model 196G.
- ▶ **NOSE-BAR PULLEY:** 2-1/2" dia. machine crowned pulley.
- ▶ **TAKE-UP:** Screw type unit at tail pulley provides 12" belt take-up.
- ▶ **BELT SPEED:** 300 FPM, maximum (speeds are dependent up upon product size and weight)
- ▶ **AIR CYLINDER:** Dual, 1-1/16" bore x 1" stroke double action cylinders.
- ▶ **AIR CONTROLS:** Single solenoid 40 PSI required
- ▶ **DIVERTER:** Dual pivoting wheels with urethane drive bands
- ▶ **DIVERTER DRIVE:** Diverter is slave driven from the conveyor belt
- ▶ **DIVERSION ANGLE:** 30° and 45°. Guard rails on take-away spur conveyor may be required.
- ▶ **RATE:** Up to 75 sorts per minute.
- ▶ **STAGING DIVERTER:** Stages package for diverting.

# PRIMO SORT | HIGH SPEED SORTER



SPECIFY MODEL NUMBER PER  
EXAMPLE  
**PRIMO224-21**  
Primo(stroke)-(between frames)  
Stroke available up to 36"

Conveyor sold separately

The Primo Sort High Speed Sorter was designed in response to an increasing demand for high speed distribution equipment. Up to 75 sorts per minute (based on size of product) can be economically and accurately sorted with the Primo.

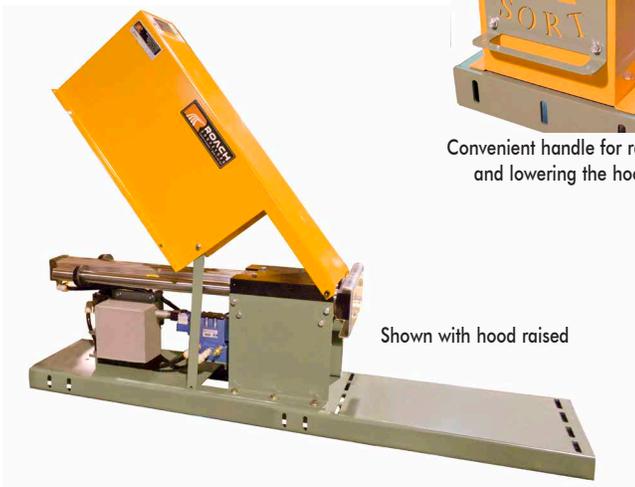
## SPECIFICATIONS

- ▶ **AIR CYLINDER:** 2" dia. bore.
- ▶ **LENGTH OF STROKE:** Up to 36" available.
- ▶ **PUSHER PLATE:** 1/8" aluminum channel.
- ▶ **MAXIMUM CYCLE RATE:** Up to 75 cycles/min (cycle rate is dependent upon product size and weight).
- ▶ **FRL:** Included, w/ 3/8" ports.
- ▶ **COMPRESSED AIR:** 0.5 cu. ft./min. at 80 to 100 PSI per cycle.
- ▶ **PNEUMATIC CONTROLS:** Pneumatics slow down cushion at rest position
- ▶ **CAPACITY:** Maximum product weight is 100 lbs (rates are affected by product weight.)
- ▶ **ENCLOSURE:** NEMA 1 houses terminal strip for all wiring connections.
- ▶ **WIRING DIAGRAM:** Housed inside of terminal box.
- ▶ **ELECTRICAL CONTROLS:** 24 VDC single solenoid valve. 2 hall-effect sensors.
- ▶ **OPTIONAL:** 120 volt, single or double solenoid valve

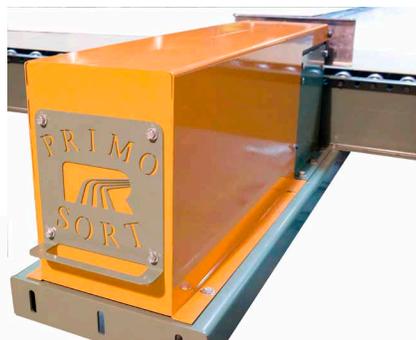
**UP TO 75  
SORTS PER MINUTE**



Specify BF dimensions and TOR elevation  
Support may be required



Shown with hood raised



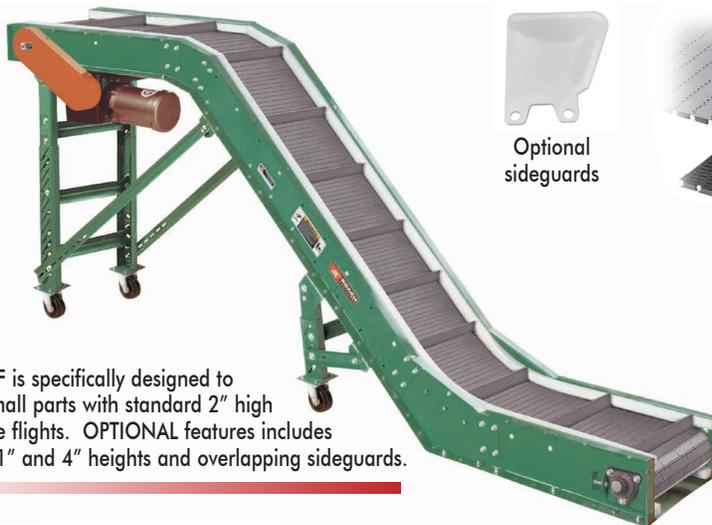
Convenient handle for raising and lowering the hood



Up to 75 sorts per minute

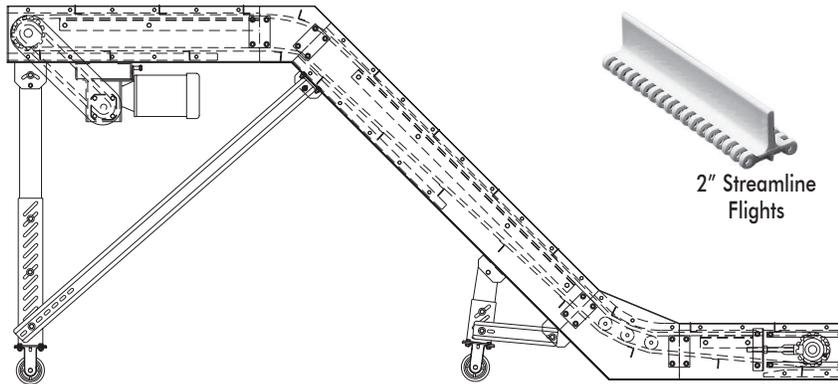
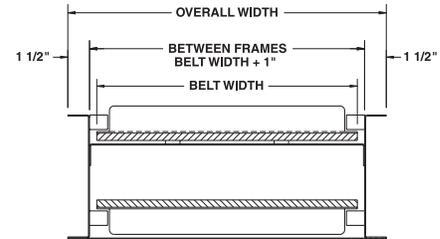
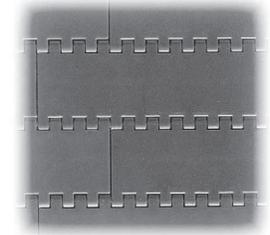
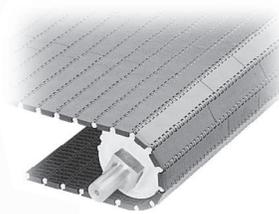
■ 6 week shipment

# PPF | SERIES 900 FLAT TOP PLASTIC BELT PARTS CONV. W/ FLIGHTS



Optional sideguards

Model PPF is specifically designed to convey small parts with standard 2" high streamline flights. OPTIONAL features includes flights in 1" and 4" heights and overlapping sideguards.



2" Streamline Flights

## SPECIFICATIONS

- ▶ **BELTING:** Series 900 flat top gray polypropylene belt with 2" high streamline flights on 11.9" centers, FDA approved belting.
- ▶ **DRIVE SPROCKETS:** 4.1" pitch dia. with 1.5" square bore.
- ▶ **TAIL SPROCKETS:** 4.1" pitch dia. with 1.5" square bore.
- ▶ **END DRIVE:** Allows one-direction (unit) operation.
- ▶ **TAKE-UP:** Catenary type, underneath mounted.
- ▶ **BELT SPEED:** 35 FPM, constant.
- ▶ **BEARINGS:** Drive shaft bearings are precision, heavy duty, lubricated, ball bearing units with cast iron housings.
- ▶ **BED:** 9" deep x 10 ga. enclosed box type construction with UHMW wearstrips

mounted to 14 ga. steel belt return pan.

- ▶ **INCLINE:** 30, 36 and 45° (specify).
- ▶ **PORTABLE SUPPORT:** Adjustable floor supports with 4" dia. casters & bracing.
- ▶ **ROLLER CHAIN:** No. 50 chain provided at drive shaft. Chain take-up provided on motor base.
- ▶ **MOTOR DRIVE:** 1/2 HP, 230/460/3, 60 cycle, Super "E" right angle gear motor.
- ▶ **ELECTRICAL CONTROLS:** Optional.

### PPF AVAILABLE WIDTHS

BELT WIDTH	BF	OAW
6"	7"	10"
12"	13"	16"
18"	19"	22"
24"	25"	28"

## OPTIONAL EQUIPMENT

**BELTING:** Available with 1" and 4" high streamline flights and sideguards for integral guard rail.

**DRIVE/TAIL SPROCKETS:** 5.8" pitch dia. sprockets with 1.5" square bore; 6.1" & 6.8" pitch dia. sprockets w/ 1.5" or 2.5" square bore.

**BELT SPEED:** Constant speed 10 to 60 FPM; DC variable speed; AC inverter variable speed. Other constant or variable speeds available. **NOTE: CAPACITY CHANGES WITH SPEED.**

**MOTORS:** Available through 1 HP in TEFC, explosion proof, dirty duty, 115/230/1, 575/3, etc.

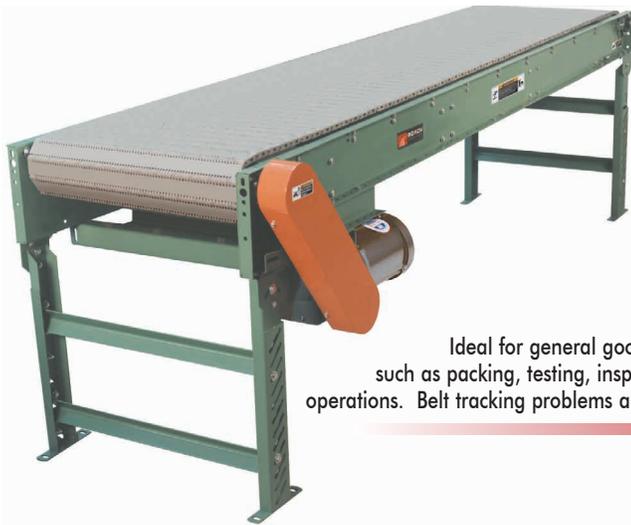
**ELECTRICAL CONTROLS:** Magnetic starter; manual starter; momentary start/stop push button station; mounting and pre-wiring for units 12'-0" long and under; limit switch; photo relay; others available.

### ⚠ WARNING

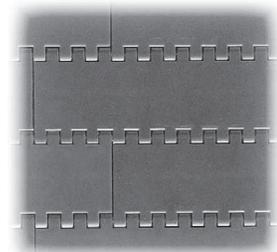
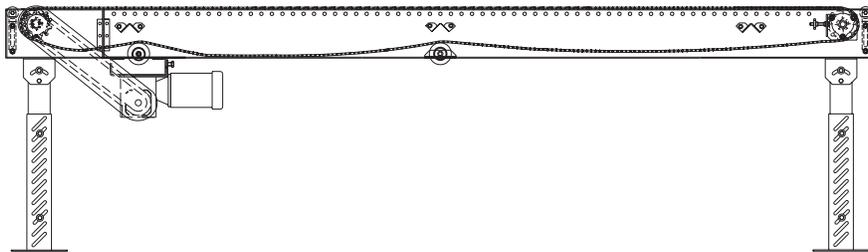
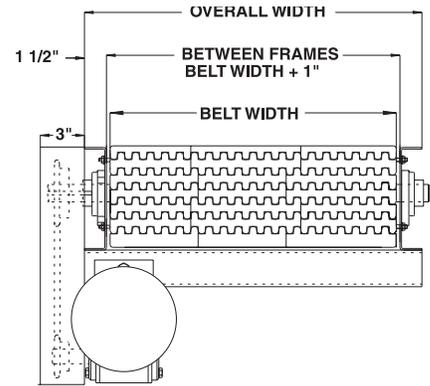
Prevent pinch points that exist when belt conveyors are permanently attached to other conveyors or equipment!

■ 3 week shipment

# 700PB | SERIES 900 FLAT FRICTION TOP PLASTIC BELT CONVEYOR



Ideal for general goods transportation in applications such as packing, testing, inspecting and various assembly line operations. Belt tracking problems are eliminated with model 700PB.



## SPECIFICATIONS

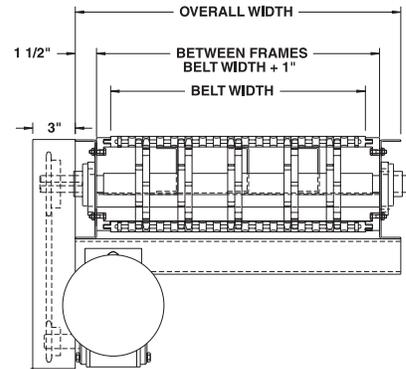
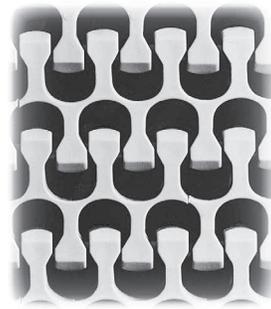
- ▶ **BELTING:** Series 900 flat top gray polypropylene belt, FDA approved belt.
- ▶ **DRIVE SPROCKETS:** 4.1" pitch dia. with 1.5" square bore. Available with OPTIONAL 6.1" or 6.8" pitch dia. sprockets with 1.5" or 2.5" square bore.
- ▶ **TAIL SPROCKETS:** 4.1" pitch dia. with 1.5" square bore. Available with OPTIONAL 6.1" or 6.8" pitch dia. sprockets with 1.5" or 2.5" square bore.
- ▶ **BEARINGS:** Drive and tail shaft bearings are precision, heavy duty, lubricated, ball bearing units with cast iron housings.
- ▶ **END DRIVE:** Allows one-direction (unit) operation.
- ▶ **BED:** 7" x 1-1/2" x 10 ga. channel frame with open style bed construction and UHMW wearstrips mounted to longitudinal channels.
- ▶ **TAKE-UP:** Catenary type located at discharge end.
- ▶ **RETURN ROLLERS:** 1.9" dia. x 16 ga. galv. steel, model 196G, adjustable with rubber sleeves.
- ▶ **BELT SPEED:** 60 FPM, constant.
- ▶ **FLOOR SUPPORTS:** Conveyor shown with optional supports. See Conveyor Accessories.
- ▶ **MOTOR DRIVE:** 1/2 HP, 230/460/3, 60 cycle, Super "E" right angle gear motor.
- ▶ **ROLLER CHAIN:** Drive shaft is driven by No. 50 roller chain for 1-1/2 HP or less and No. 60 chain on larger drives. Chain take-up provided on motor base.
- ▶ **ELECTRICAL CONTROLS:** Optional.

**⚠ WARNING**

Prevent pinch points that exist when belt conveyors are permanently attached to other conveyors or equipment!

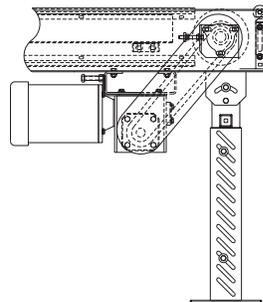
■ 3 week shipment

# 700PBC | SERIES 2200 FLUSH GRID PLASTIC BELT CURVE

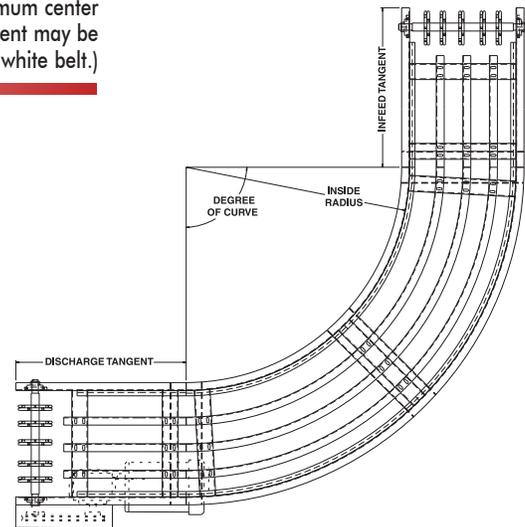


Use model 700PBC for applications requiring 30°, 45°, 60° or 90° curves. S-curve formations also available with minimum center tangent length twice belt width. Additional straight tangent may be added at discharge (drive) end. (Unit shown with optional white belt.)

TECHNICAL SPECIFICATIONS		
BELT WIDTH	MIN. TANGENT LENGTH	MIN. INSIDE RADIUS
6"	9"	24"
12"	18"	26.4"
18"	27"	39.8"
24"	36"	52.8"
30"	45"	66"
36"	54"	79.2"
42"	63"	92.4"
48"	72"	105.6"



Min drive tangent length 5'



## SPECIFICATIONS

- ▶ **BELT:** Series 2200 flush grid gray curved polypropylene belt, FDA & USDA approved belting.
- ▶ **DRIVE SPROCKETS:** 5.3" pitch dia. with 1.5" square bore. Available with OPTIONAL 6.3" or 7.7" pitch dia. sprockets with 1.5" or 2.5" square bore.
- ▶ **TAIL SPROCKETS:** 5.3" pitch dia. with 1.5" square bore. Available with OPTIONAL 6.3" or 7.7" pitch dia. sprockets with 1.5" or 2.5" square bore.
- ▶ **END DRIVE:** Allows one-direction operation ONLY; this conveyor is NOT reversible.
- ▶ **TAKE-UP:** Catenary type located at discharge end.

- ▶ **BED:** 7" x 1-1/2" x 10 ga. formed steel channel frame with UHMW wearstrips attached to bed and belt return pan.
- ▶ **MINIMUM RADIUS:** 2.2 x belt width, measured from inside edge of belt.
- ▶ **SPEED:** 60 FPM, constant.
- ▶ **TANGENTS:** Minimum length is 1.5 x belt width located at each end of conv. Optional additional tangent may be located at dischg.
- ▶ **FLOOR SUPPORTS:** Conveyor shown with optional supports. See Conveyor Accessories.
- ▶ **BEARINGS:** End shafts are supported by precision, heavy duty, lubricated, ball bearing units with cast iron housings.

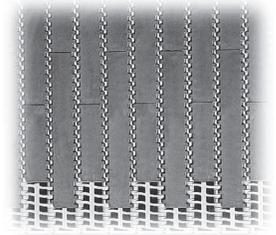
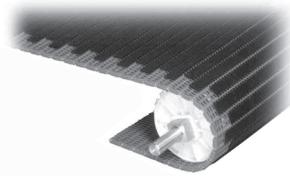
- ▶ **DIRECTION OF FLOW:** Specify right hand or left hand.
- ▶ **MOTOR DRIVE:** 1/2 HP, 230/460/3, 60 cycle, Super "E" right angle gear motor on 45° and 90° curves; 3/4 HP supplied on all 180° curves.
- ▶ **ROLLER CHAIN:** Drive shaft is driven by No. 50 chain.
- ▶ **ELECTRICAL CONTROLS:** Optional.

**⚠ WARNING**

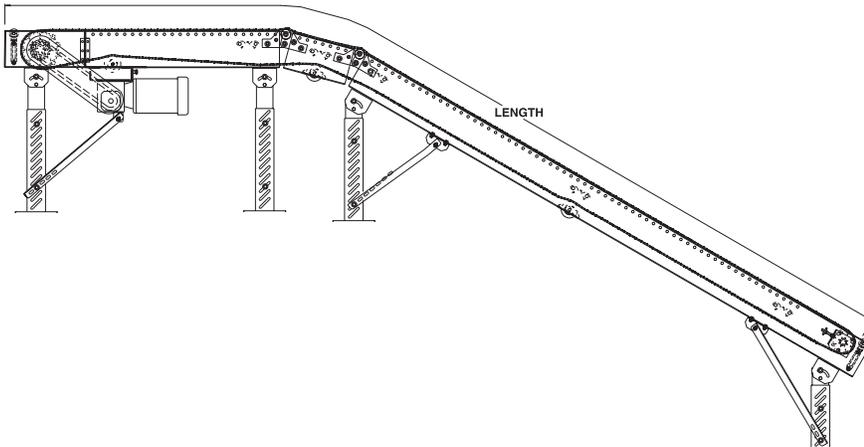
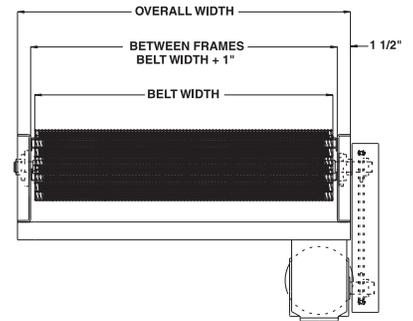
Prevent pinch points that exist when belt conveyors are permanently attached to other conveyors or equipment!

■ 3 week shipment

# 700FFT | SERIES 900 FLAT FRICTION TOP PLASTIC BELT CONVEYOR



Model 700FFT is the choice for floor-to-floor, inclined or declined carton handling applications. Eliminate belt tracking problems with plastic belt on model 700FFT. Unit shown with optional supports and knee braces.



BELT WIDTH	BF	OAW
6"	7"	10"
12"	13"	16"
18"	19"	22"
24"	25"	28"
30"	31"	34"
36"	37"	40"
42"	43"	46"
48"	49"	52"

## SPECIFICATIONS

- ▶ **BELTING:** Series 900 flat friction top gray polypropylene belt with black rubber top modules.
- ▶ **DRIVE SPROCKETS:** 6.1" pitch dia. with 1.5" square bore. Available with OPTIONAL 6.1" pitch dia. with 2.5" square bore and 6.8" pitch dia. sprockets with 1.5" or 2.5" square bore.
- ▶ **TAIL SPROCKETS:** 6.1" pitch dia. with 1.5" square bore. Available with OPTIONAL 6.1" pitch dia. with 2.5" square bore and 6.8" pitch dia. sprockets with 1.5" or 2.5" square bore.
- ▶ **END DRIVE:** Allows one-direction (unit) operation.

- ▶ **BELT SPEED:** 60 FPM, constant.
- ▶ **TAKE-UP:** Catenary type located at discharge end.
- ▶ **RETURN ROLLERS:** 1.9" dia. x 16 ga. galv. steel, model 196G, adjustable with rubber sleeves.
- ▶ **BED:** 7" x 1-1/2" x 10 ga. channel frame with open style bed construction and UHMW wearstrips mounted to longitudinal channels.
- ▶ **BEARINGS:** Drive and tail shaft bearings are precision, heavy duty, lubricated, ball bearing units with cast iron housings.

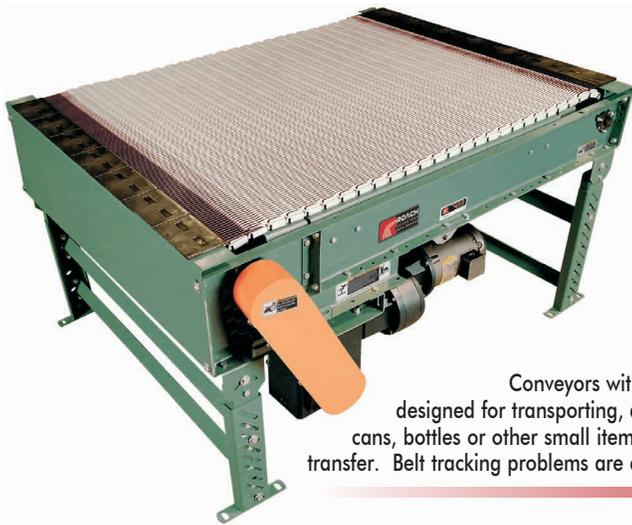
- ▶ **ROLLER CHAIN:** Drive shaft is driven by No. 50 roller chain for 1-1/2 HP or less and No. 60 chain on larger drives. Chain take-up provided on motor base.
- ▶ **MOTOR DRIVE:** 1/2 HP, 230/460/3, 60 cycle, Super "E" right angle gear motor.
- ▶ **FLOOR SUPPORTS:** Conveyor shown with optional supports. See Conveyor Accessories.
- ▶ **ELECTRICAL CONTROLS:** Optional.

**⚠ WARNING**

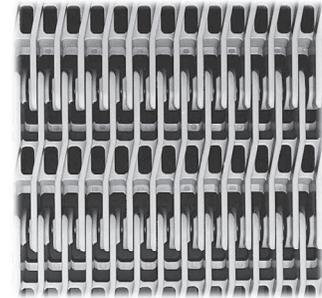
Prevent pinch points that exist when belt conveyors are permanently attached to other conveyors or equipment!

■ 3 week shipment

# 700RR | SERIES 400 RAISED RIB PLASTIC BELT CONVEYOR



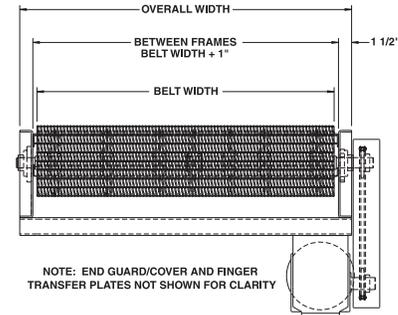
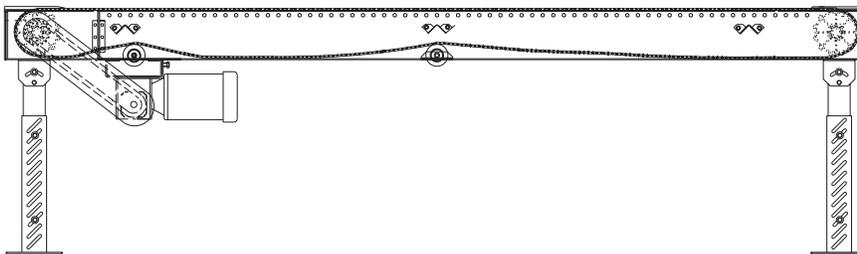
Flush edges with easy length adjustment, furnished standard



Conveyors with raised rib plastic belting are designed for transporting, accumulating and transferring cans, bottles or other small items that are normally difficult to transfer. Belt tracking problems are eliminated with model 700RR.



Finger Transfer Plates



## SPECIFICATIONS

► **BELTING:** Series 400 raised rib gray polypropylene belt, FDA approved belt. Finger transfer plates provided both ends of conveyor to facilitate smooth product transfer.

► **DRIVE SPROCKETS:** 7.8" pitch dia. with 1.5" square bore. Available with OPTIONAL 10.1" pitch dia. sprockets with 1.5" or 2.5" square bore.

► **TAIL SPROCKETS:** 7.8" pitch dia. with 1.5" square bore. Available with OPTIONAL 10.1" pitch dia. sprockets with 1.5" or 2.5" square bore.

► **BED:** 7" x 1-1/2" x 10 ga. channel frame with open style bed construction and UHMW wearstrips mounted to longitudinal channels.

► **END DRIVE:** Allows one-direction (unit) operation.

► **BEARINGS:** Drive and tail shaft bearings are precision, heavy duty, lubricated, ball bearing units with cast iron housings.

► **BELT SPEED:** 60 FPM, constant.

► **TAKE-UP:** Catenary type located at discharge end.

► **RETURN ROLLERS:** 1.9" dia. x 16 ga. galv. steel, model 196G, adjustable with rubber sleeves.

► **FLOOR SUPPORTS:** Conveyor shown with optional supports. See Conveyor Accessories.

► **MOTOR DRIVE:** 1/2 HP, 230/460/3, 60 cycle, Super "E" right angle gear motor.

► **ROLLER CHAIN:** Drive shaft is driven by No. 50 roller chain for 1-1/2 HP or less and No. 60 chain on larger drives. Chain take-up provided on motor base.

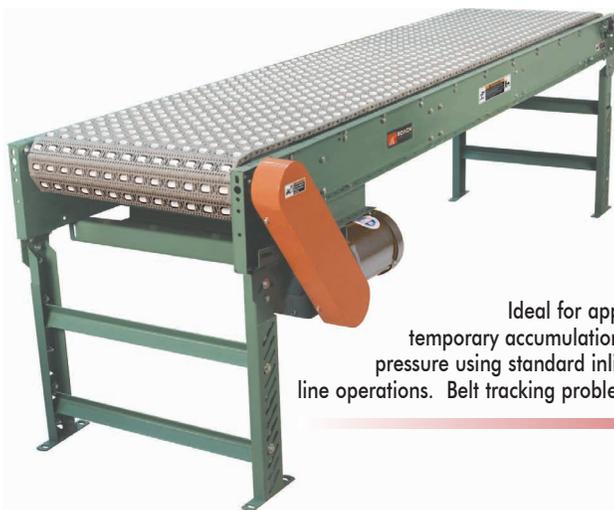
► **ELECTRICAL CONTROLS:** Optional.

■ 3 week shipment

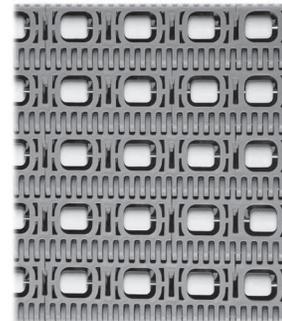
### ⚠ WARNING

Prevent pinch points that exist when belt conveyors are permanently attached to other conveyors or equipment!

# 700RT | SERIES 400 INLINE ROLLER TOP PLASTIC BELT CONVEYOR

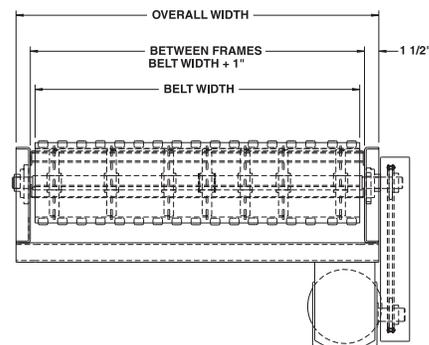
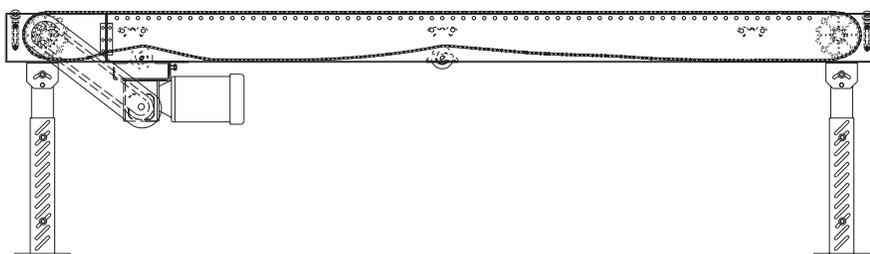


Flush edges with easy length adjustment, furnished standard



BELT FLOW

Ideal for applications requiring transportation and temporary accumulation. Product accumulates with low back pressure using standard inline rollers in belt for various assembly line operations. Belt tracking problems are eliminated with model 700RT.



## SPECIFICATIONS

► **BELTING:** Series 400 roller top gray polypropylene belt, FDA approved belt.

► **DRIVE SPROCKETS:** 7.8" pitch dia. with 1.5" square bore. Available with OPTIONAL 10.1" pitch dia. sprockets with 1.5" or 2.5" square bore.

► **TAIL SPROCKETS:** 7.8" pitch dia. with 1.5" square bore. Available with OPTIONAL 10.1" pitch dia. sprockets with 1.5" or 2.5" square bore.

► **END DRIVE:** Allows one-direction (unit) operation.

► **TAKE-UP:** Catenary type located at discharge end.

► **RETURN ROLLERS:** 1.9" dia. x 16 ga. galv. steel, model 196G, adjustable with rubber sleeves.

► **BELT SPEED:** 60 FPM, constant.

► **BEARINGS:** Drive shaft bearings are precision, heavy duty, lubricated, ball bearing units with cast iron housings.

► **BED:** 7" x 1-1/2" x 10 ga. channel frame with open style bed construction and UHMW wearstrips mounted to longitudinal channels.

► **FLOOR SUPPORTS:** Conveyor shown with optional supports. See Conveyor Accessories.

► **MOTOR DRIVE:** 1/2 HP, 230/460/3, 60 cycle, Super "E" right angle gear motor.

► **ROLLER CHAIN:** Drive shaft is driven by No. 50 roller chain for 1-1/2 HP or less and No. 60 chain on larger drives. Chain take-up provided on motor base.

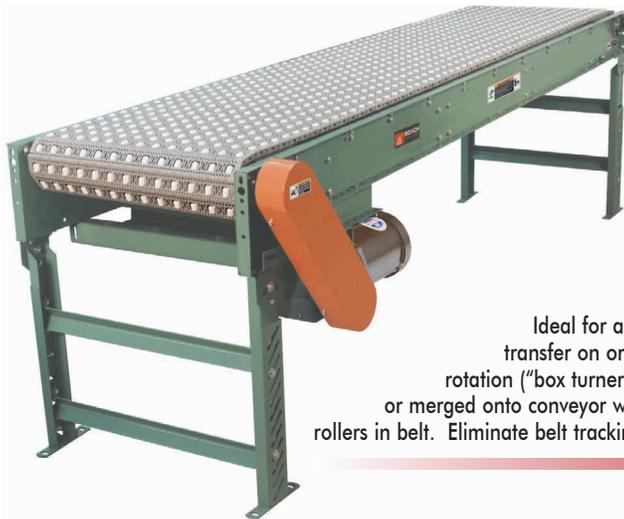
► **ELECTRICAL CONTROLS:** Optional.

### ⚠ WARNING

Prevent pinch points that exist when belt conveyors are permanently attached to other conveyors or equipment!

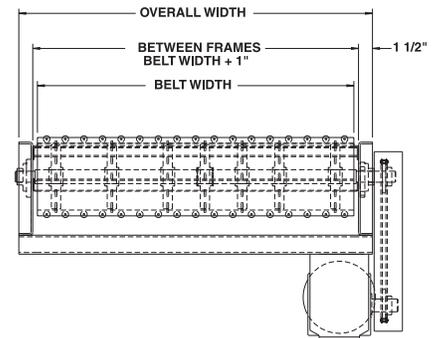
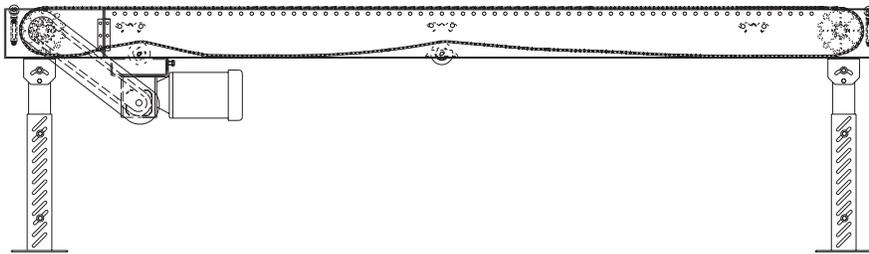
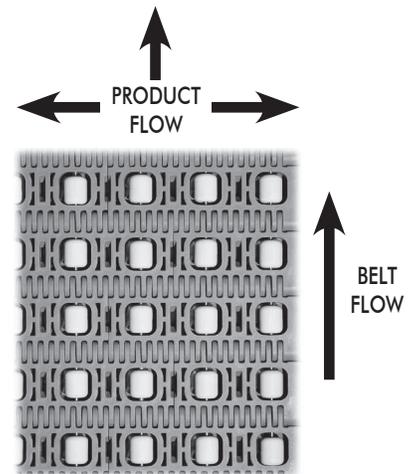
■ 3 week shipment

# 700TRT | SERIES 400 TRANSVERSE ROLLER TOP PLASTIC BELT CONVEYOR



Flush edges with easy length adjustment, furnished standard

Ideal for applications requiring 90° product transfer on or off, product centering or carton rotation ("box turner"). Product can be diverted from or merged onto conveyor with standard transverse mounted rollers in belt. Eliminate belt tracking problems with model 700TRT.



## SPECIFICATIONS

- ▶ **BELTING:** Series 400 transverse roller top gray polypropylene belt with acetal rollers & stainless steel roller axles, FDA approved belting.
- ▶ **DRIVE SPROCKETS:** 7.8" pitch dia. with 1.5" square bore. Available with OPTIONAL 10.1" pitch dia. sprockets with 1.5" or 2.5" square bore.
- ▶ **TAIL SPROCKETS:** 7.8" pitch dia. with 1.5" square bore. Available with OPTIONAL 10.1" pitch dia. sprockets with 1.5" or 2.5" square bore.
- ▶ **END DRIVE:** Allows one-direction (unit) operation.
- ▶ **TAKE-UP:** Catenary type located at discharge end.

- ▶ **RETURN ROLLERS:** 1.9" dia. x 16 ga. galv. steel, model 196G, adjustable with rubber sleeves.
- ▶ **BEARINGS:** Drive and tail shaft bearings are precision, heavy duty, lubricated, ball bearing units with cast iron housings.
- ▶ **BELT SPEED:** 60 FPM, constant.
- ▶ **BED:** 7" x 1-1/2" x 10 ga. channel frame with open style bed construction and UHMW wearstrips mounted to longitudinal channels.
- ▶ **FLOOR SUPPORTS:** Conveyor shown with optional supports. See Conveyor Accessories.

- ▶ **MOTOR DRIVE:** 1/2 HP, 230/460/3, 60 cycle, Super "E" right angle gear motor.
- ▶ **ROLLER CHAIN:** Drive shaft is driven by No. 50 roller chain for 1-1/2 HP or less and No. 60 chain on larger drives. Chain take-up provided on motor base.
- ▶ **ELECTRICAL CONTROLS:** Optional.

### ⚠ WARNING

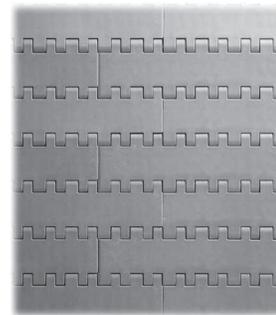
Prevent pinch points that exist when belt conveyors are permanently attached to other conveyors or equipment!

■ 3 week shipment

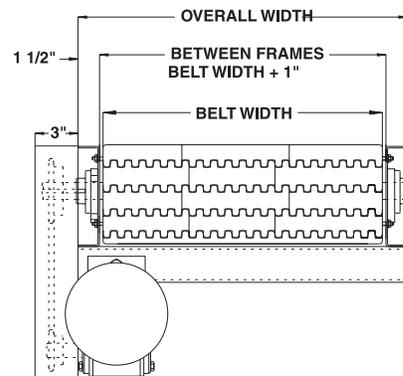
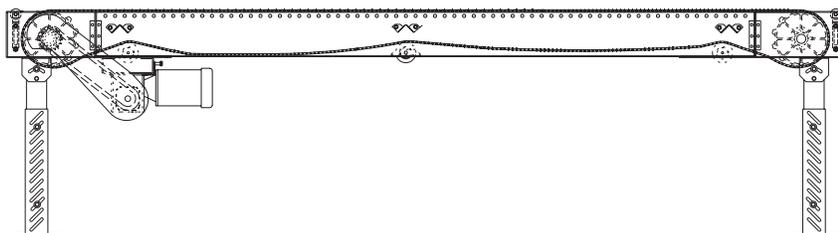
# HD1200PB | SERIES 1200 HEAVY DUTY PLASTIC BELT CONVEYOR



Conveyor shown with optional supports



Series 1200 flat top belting is used on model HD1200PB for heavy unit loads and pallet handling. Belt tracking problems are eliminated using series 1200 flat top belting on model HD1200PB.



## SPECIFICATIONS

- ▶ **BELTING:** Series 1200 flat top gray polypropylene belt.
- ▶ **DRIVE SPROCKETS:** 10.2" pitch dia. with 2.5" square bore.
- ▶ **TAIL SPROCKETS:** 10.2" pitch dia. with 2.5" square bore.
- ▶ **END DRIVE:** Allows one-direction (unit) operation.
- ▶ **BED:** 7" x 1-1/2" x 7 ga. channel frame with open style bed construction and UHMW wearstrips mounted to longitudinal channels.
- ▶ **TAKE-UP:** Catenary type located at discharge end.

- ▶ **RETURN ROLLERS:** 1.9" dia. x 16 ga. galv. steel, model 196G, adjustable with rubber sleeves.
- ▶ **BEARINGS:** Drive and tail shaft bearings are precision, heavy duty, lubricated, ball bearing units with cast iron housings.
- ▶ **FLOOR SUPPORTS:** See Conveyor Accessories.
- ▶ **BELT SPEED:** 35 FPM, constant.
- ▶ **MOTOR DRIVE:** 1/2 HP, 230/460/3, 60 cycle, Super "E" right angle gear motor.

- ▶ **ROLLER CHAIN:** Drive shaft is driven by No. 50 roller chain for 1-1/2 HP or less and No. 60 chain on larger drives. Chain take-up provided on motor base.

- ▶ **ELECTRICAL CONTROLS:** Optional.

**⚠ WARNING**

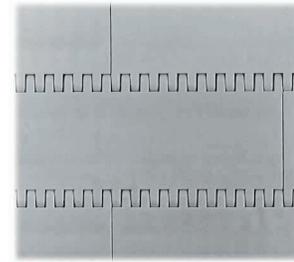
Prevent pinch points that exist when belt conveyors are permanently attached to other conveyors or equipment!

■ 3 week shipment

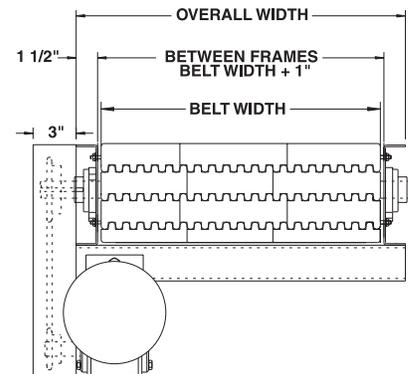
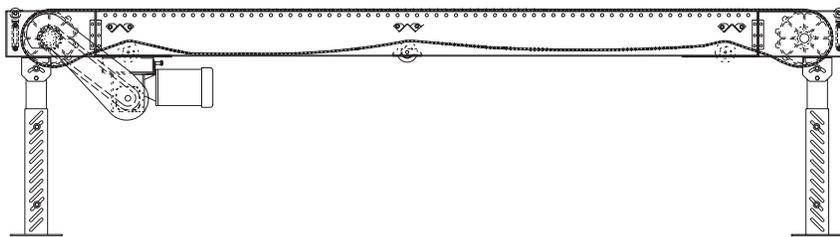
# 400PB | SERIES 400 HEAVY DUTY PLASTIC BELT CONVEYOR



Conveyor shown with optional supports



Series 400 flat top belting is used on model HD400PB for heavy unit loads. Belt tracking problems are eliminated when using series 400 flat top belting on Roach model HD400PB.



## SPECIFICATIONS

- ▶ **BELTING:** Series 400 flat top gray polypropylene belt, FDA approved belt.
- ▶ **DRIVE SPROCKETS:** 10.1" pitch dia. with 2.5" square bore.
- ▶ **TAIL SPROCKETS:** 10.1" pitch dia. with 2.5" square bore.
- ▶ **END DRIVE:** Allows one-direction (unit) operation.
- ▶ **BED:** 7" x 1-1/2" x 7 ga. channel frame with open style bed construction and UHMW wearstrips mounted to longitudinal channels.
- ▶ **TAKE-UP:** Catenary type located at discharge end.

- ▶ **RETURN ROLLERS:** 1.9" dia. x 16 ga. galv. steel, model 196G, adjustable with rubber sleeves.
- ▶ **BEARINGS:** Drive and tail shaft bearings are precision, heavy duty, lubricated, ball bearing units with cast iron housings.
- ▶ **FLOOR SUPPORTS:** See Conveyor Accessories.
- ▶ **BELT SPEED:** 35 FPM, constant.
- ▶ **MOTOR DRIVE:** 1/2 HP, 230/460/3, 60 cycle, Super "E" right angle gear motor.

- ▶ **ROLLER CHAIN:** Drive shaft is driven by No. 50 roller chain for 1-1/2 HP or less and No. 60 chain on larger drives. Chain take-up provided on motor base.
- ▶ **ELECTRICAL CONTROLS:** Optional.

### ⚠ WARNING

Prevent pinch points that exist when belt conveyors are permanently attached to other conveyors or equipment!

■ 3 week shipment

**PRODUCT STOPS**

**PNEUMATIC ROLLER & BLADE STOPS (POWER CONV. ONLY)**



Pneumatic power conveyor stops are used where automatic line control is required such as accumulation, indexing, inspection stations, etc. This stop is normally used on variable pressure accumulators and live roller conveyors.

**SPECIFY MODEL NUMBER PER**

**EXAMPLE**

**PRSL-196VP-33**

(pneumatic)(roller or blade stop\*)(left or right\*\*)-(conveyor type)-(between frames)

\*Specify RS for roller stop; BS for blade stop.

\*\*Specify L for left hand; R for right hand.

**SPECIFICATIONS**

- ▶ **ROLLER STOP:** 1.9" dia. x 16 ga. galv. steel roller, model 196G.
- ▶ **BLADE STOP:** 7 ga. formed angle.
- ▶ **AIR CYLINDER:** Double action. (60-80 PSI) required.
- ▶ **SOLENOID VALVE:** Single.
- ▶ **BEARINGS:** Removable type, heavy duty ball bearing, with cast iron housings.

- ▶ **OPTIONAL:** Double solenoid and electrical controls.
- ▶ **WIDTHS:** 15", 19", 21", 25", 27", 33" and 39" BF. Medium duty models above 39" BF, light duty models in 10", 16" and 22" BF and heavy duty models above 39" BF are 2 week shipment.

■ 2 week shipment

**MANUAL ROLLER & BLADE STOPS (POWER CONV. ONLY)**



Manual operated power conveyor stops are hand operated and used where line control is required such as accumulation, indexing, inspection stations, etc. This stop is normally used on variable pressure accumulators and live roller conveyors.

**SPECIFY MODEL NUMBER PER**

**EXAMPLE**

**MBSR-196LR-21**

(manual)(roller or blade stop\*)(left or right\*\*)-(conveyor type)-(between frames)

\*Specify RS for roller stop; BS for blade stop.

\*\*Specify L for left hand; R for right hand.

**SPECIFICATIONS**

- ▶ **ROLLER STOP:** 1.9" dia. x 16 ga. galv. steel roller, model 196G.
- ▶ **BLADE STOP:** 7 ga. formed angle.
- ▶ **BEARINGS:** Removable type, heavy duty ball bearing, with cast iron housings.
- ▶ **LOCK:** Spring loaded catch.
- ▶ **WIDTHS:** 15", 19", 21", 25", 27", 33" and 39" BF. Medium duty models above 39" BF, light duty models in 10", 16" and 22" BF and heavy duty models above 39" BF are 2 week shipment.

■ 2 week shipment

## PRODUCT DIVERTERS

### PNEUMATIC DIVERTERS



Pneumatic diverters are used to divert packages off main conveyor line onto spurs. This diverter may be utilized in powered or gravity conveyor applications. Conveyors shown are optional.

#### SPECIFY MODEL NUMBER PER EXAMPLE

**PD30-27-7-L**

PD30-(between frames)-(frame size\* -(left or right\*\*))

\*Specify 3.5 or 7 for depth of frame.

\*\*Specify L for left hand; R for right hand.

#### SPECIFICATIONS

- ▶ **DIVERSION ANGLE:** 30°
- ▶ **DIVERTER ARM:** 1/8" aluminum.
- ▶ **AIR CYLINDER:** Double action with 6" stroke and cushioned. (60-80) PSI required.
- ▶ **SOLENOID VALVE:** Single, 110 volt.
- ▶ **BEARINGS:** Removable type, heavy duty

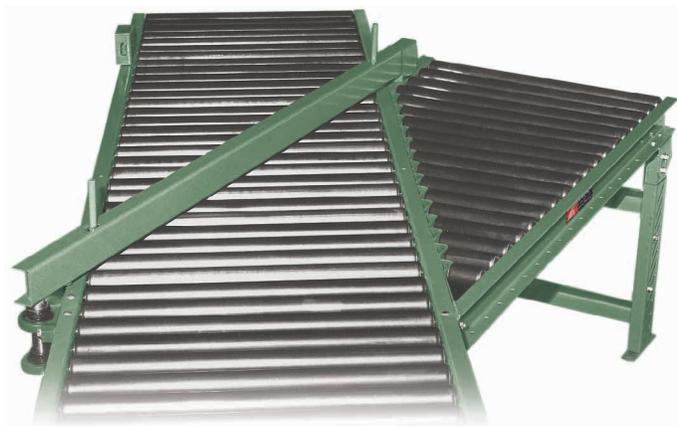
ball bearing, with cast iron housings.

- ▶ **WEAR-STRIP:** 1/4" UHMW wear-strip attached to face of diverter.

**OPTIONAL:** Double solenoid and electrical controls.

■ 3 week shipment

## MANUAL DIVERTERS (POWER & GRAVITY)



#### SPECIFY MODEL NUMBER PER EXAMPLE

**MD30-21-7-R**

MD30-(between frames)-(frame size\*)-(left or right\*\*)

\*Specify 3.5 or 7 for depth of frame.

\*\*Specify L for left hand; R for right hand.

Manual diverters are used to divert packages off of a main conveying line onto other conveyors. Diverter can be used on powered or gravity conveyors. Conveyors shown are optional.

#### SPECIFICATIONS

- ▶ **DIVERTER ARM:** 1-3/4" x 3" x 1-3/4" 12 ga.
  - ▶ **BEARINGS:** Removable type, heavy duty ball bearing, with cast iron housings.
  - ▶ **LOCK:** Spring loaded lock built into diverter arm for operation at both ends.
  - ▶ **OPTIONAL:** Wear-strip on diverter arm.
- 3 week shipment

## TAKE-UPS SCREW TYPE AUXILIARY TAKE-UP (FOR LIVE ROLLERS)



Screw type auxiliary take-ups are the most common take-ups used on models 638CALR, 796CALR, 196ZPA and 251CALR for additional belt take-up. Live roller model ATS4 shown at left and ATS6 shown below.



**SPECIFY MODEL NUMBER PER EXAMPLE**

**ATS4-33-R**

ATS(pulley diameter\*)-(between frames)-  
(live roller type)

\*Specify 4 for model ATS4 with 4" dia. pulleys or 6 for model ATS6 with 6" dia. pulleys.

**SPECIFICATIONS**

- ▶ **4" AUX. TAKE-UP:** (2) 4" dia. pulleys with 1-3/16" dia. shaft, machine crowned.
- ▶ **6" AUX. TAKE-UP:** (2) 6" dia. pulleys with 1-7/16" dia. shaft, machine crowned.
- ▶ **FRAME:** Depth of (4") 8" x 10 ga. formed steel, Depth of (6") 9-1/2" x 10 ga. formed steel.

- ▶ **TAKE-UP:** 24" belt take-up.
- ▶ **BEARINGS:** Heavy duty, relubable, ball bearings with cast iron housings.

MODEL ATS4 FOR LIVE ROLLERS							
BF	15"	19"	21"	25"	27"	33"	39"
WT	105	113	117	125	129	141	153
MODEL ATS6 FOR LIVE ROLLERS							
BF	15"	19"	21"	25"	27"	33"	39"
WT	119	129	135	146	151	167	183

■ 2 week shipment

## SCREW TYPE AUXILIARY TAKE-UP (FOR BELT CONVEYORS)



Screw type auxiliary take-ups are the most common take-ups used for models 725TB, 700SB, 700BSB, 450BOS, 796RB, 796RBF, 700SBF and 751RB for additional belt take-up. Belt conveyor model ATS4 shown at left and ATS6 shown above.

**SPECIFY MODEL NUMBER PER EXAMPLE**

**ATS4-21-B**

ATS(pulley diameter\*)-(between frames)-  
(belt conveyor type\*\*)

\*Specify 4 for model ATS4 with 4" dia. pulleys or 6 for model ATS6 with 6" dia. pulleys.

\*\*When attaching to 725TB or 450BOS, BF dimension = belt width + 1".

**SPECIFICATIONS**

- ▶ **4" AUX. TAKE-UP:** (2) 4" dia. pulleys with 1-3/16" dia. shaft, machine crowned.
- ▶ **6" AUX. TAKE-UP:** (2) 6" dia. pulleys with 1-7/16" dia. shaft, machine crowned.
- ▶ **FRAME:** Depth of (4") 8"

- x 10 ga. formed steel, Depth of (6") 9-1/2" x 10 ga. formed steel.
- ▶ **TAKE-UP:** 24" belt take-up.
- ▶ **BEARINGS:** Heavy duty, relubable, ball bearings with cast iron housings.

MODEL ATS4 FOR BELT CONV.								
BELT	6"	12"	18"	24"	30"	36"	42"	48"
BF	9"	15"	21"	27"	33"	39"	45'	51"
WT	122	134	146	158	170	182	194	206
MODEL ATS6 FOR BELT CONV.								
BELT	6"	12"	18"	24"	30"	36"	42"	48"
BF	9"	15"	21"	27"	33"	39"	45'	51"
WT	132	148	164	180	196	212	228	244

■ 2 week shipment

# POWER ACCESSORIES NOSE-OVER BRACKETS



■ 3 week shipment

### SPECIFICATIONS

- ▶ **CONSTRUCTION:** 12 ga. galv. steel. Single nose-over adjusts from 0-20° and double nose-over adjusts from 0-35°.
- ▶ **CARRIER ROLLERS:** 1.9" dia. x 16 ga. galv. steel, model 196G.
- ▶ **SNUB ROLLERS:** 2.5" dia. x 11 ga. galv. steel, model 251S.

Nose-over brackets may be attached to slider bed or roller bed belt conveyors to smoothly bridge the transition of inclined or declined bed sections to horizontal bed sections. **NOTE:** 1-foot bed section supplied on double nose-over models.

**SPECIFY MODEL NUMBER PER EXAMPLE**

**NO-D-15-3-RB**

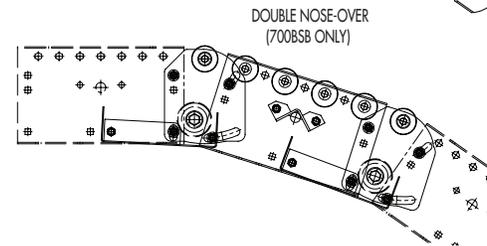
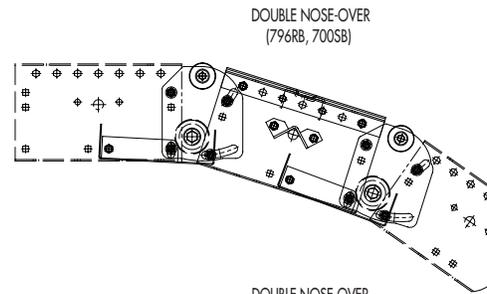
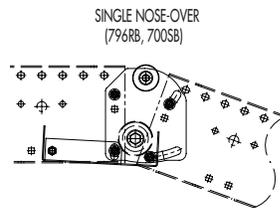
NO-(single or double nose-over\*)-(between frames\*\*)-(roller centers@)-(conveyor type@@)

\*Specify D for double or S for single nose-over.

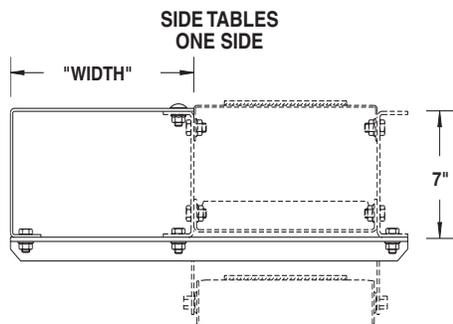
\*\*Specify overall width for model 700BSB.

@Applicable for models 796RB and 700SB.

@@Specify RB for roller bed (model 796RB); SB for slider bed (model 700SB); BSB for slider bed (model 700BSB).



## SIDE TABLES



Side tables are commonly used by workers in assembly operations when mounted on roller bed, slider bed and boxed slider bed belt conveyors.

**SPECIFY MODEL NUMBER PER EXAMPLE**

**ST-O-21-196RB-10**

ST-(one side or both sides\*)-(side table width\*\*)-(conveyor type)-(length)

\*Specify O for one side or B for both sides.

\*\*Side table width available in 9", 15" or 21".

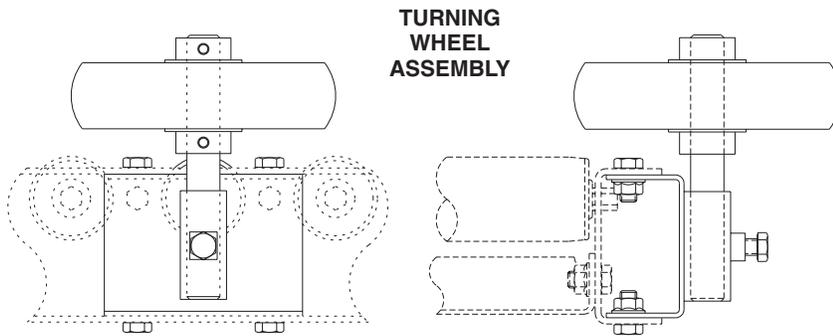
■ 3 week shipment

### SPECIFICATIONS

- ▶ **CONSTRUCTION:** 12 ga. formed HRS steel, 7" deep.
- ▶ **MOUNTING HARDWARE:** Included as standard integral feature of side tables. Always specify overall width and model no. of conveyor side tables mount to so that proper width and type mounting cross braces are supplied.

# POWER ACCESSORIES

## TURNING WHEEL/TURNING POST ASSEMBLY



**TURNING WHEEL ASSEMBLY**

**SPECIFY MODEL NUMBER PER EXAMPLE**

**TW-3.5**

T(wheel or post\*)-(frame depth or roller size\*\*)

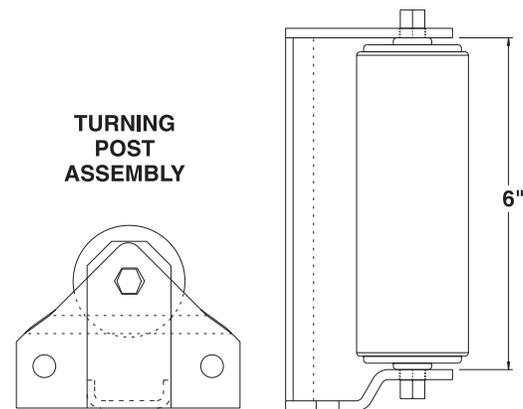
\*Specify W for turning wheel or P for turning post.

\*\*For turning wheel specify frame size as 2.5, 3.5, 4.5 or 7. For turning post, indicate roller type as either 196 or 251.

Turning wheel and turning post assemblies (turning post shown lower right) are commonly used in applications with converging or diverging spurs. These simple transition devices assist products with smooth transition to or from spur line.

### SPECIFICATIONS

- ▶ **TW:** 6" dia. x 1-1/2" wide face rubber wheel with 3/4" dia. bore; shaft is 3/4" dia. w/ locking collar positioned above and below wheel. Shaft adjusts vertically up/down to accommodate product height.
- ▶ **TP:** 196G roller (medium duty) or 251S roller (heavy duty), both 6" BF mounted in 7 ga. frame assembly.



**TURNING POST ASSEMBLY**

■ 2 week shipment

## MOTOR DRIVE ASSEMBLY

This is a complete 1/3 HP drive featuring Baldor motor and Boston reducer including motor, reducer, reducer mounting plate ("motor base"), No. 50 roller drive chain, chain guard with cover and two drive sprockets. Specify conveyor that drive mounts to for proper allocation of drive components.



**SPECIFY MODEL NUMBER PER EXAMPLE**

**MDA-1/3-21-60**

MDA-(horsepower)-(between frames\*)-(speed)

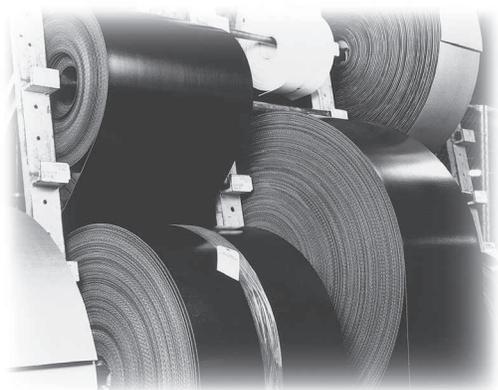
\*Conveyor model number and BF must be indicated for proper allocation of drive components

■ 3 week shipment

### SPECIFICATIONS

- ▶ **MOTOR:** Baldor 1/2 HP, 230/460/3, 60 cycle, Super "E".
- ▶ **MOTOR BASE:** Underneath mount with push plate for chain take-up.
- ▶ **REDUCER:** Boston, 30:1 ratio, right angle.
- ▶ **SPEED:** 60 FPM, constant.

**POWER ACCESSORIES**  
**BELTING**

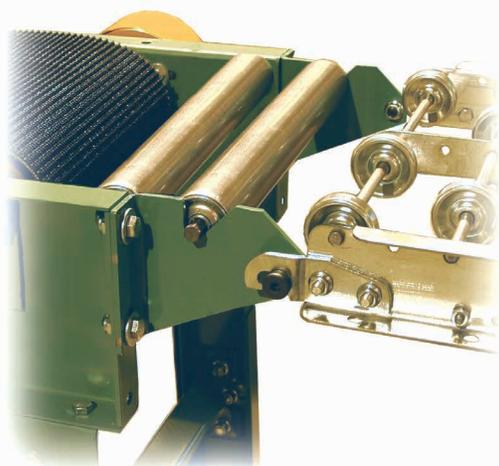


**BELTING**

BELT DESCRIPTION
PVC-120 Black (FS X FS)
PVC-120 Black (C X FS)
PVC Black RT
PVC-150 Black (C X FS)
White Food Grade PVC-120 (C X FS)
1/2" x 1" Galvanized Flat Wire Mesh
PVC-120 with 1-1/2" High Molded Cleats on 12" Centers
Belt Splice (2 laced ends included)

Consult factory for belting not shown above and for non-stock belting availability.

**CONNECTOR BRACKET**

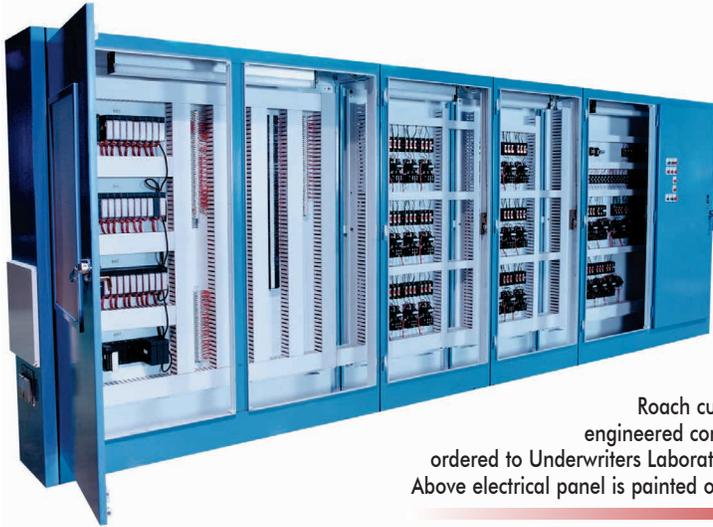


Prevent pinch points that exist when gravity conveyors are permanently attached to power conveyors, using connector brackets with safety pop-out rollers.

► **CONSTRUCTION:** brackets are 10 ga. HRS painted steel and bolt at end of powered conveyor to butt couplings; gravity conveyor attaches to connector bracket

► **POP-OUT ROLLERS:** mounts into slot on bracket for safety design; use of connector bracket eliminates dangerous pinch points

CONNECTING MODEL
WA & WS WHEEL
1-3/8" DIA X 18 GA.
1.9" DIA. X 16 GA.
1.9" DIA X 12 GA.
1.9" X 9 GA.
2-1/2" DIA. X 11 GA.

**ELECTRICAL CONTROLS**
**CUSTOM DESIGNED ELECTRICAL SYSTEMS/COMPONENT CONTROLS**


Roach custom-designed and engineered control panels may be ordered to Underwriters Laboratories UL® approval. Above electrical panel is painted optional Roach blue.



■ 3 week shipment

**GENERAL**

Roach offers custom designed electrical controls as an integral feature of turnkey SYSTEMS capabilities. We locate photo cells, limit switches, operator interface terminals (OIT), push button stations, run conduit and make field connections--whatever it takes to put control in the hands of your system operators.

Most frequently controls packages contain Allen Bradley brand controls, our standard control components. However, occasionally it is necessary to use other brands to facilitate customer requests.

Consult Roach to learn how our team of electrical engineers can design, install and implement a custom electrical systems package--placing your systems operators in TOTAL control.



Roach Continuous Vertical Conveyors (model CVC) are manufactured with controls specifically designed to meet the needs of your specialized application. Notice the controls panel mounted on the side of the above conveyors at the lower feed level. Shown

below are some of the sample COMPONENT controls used on various conveyors when turnkey system controls are not required. Components such as manual starters, magnetics starters, push button stations, etc., may be utilized to perform more simplistic operator functions. NOTE: When quoting and purchasing COMPONENT controls, electrical controls must be selected based on the operation and by adhering to ALL local & national electrical codes.



# FLEXIBLE WHEEL CONVEYOR

**FLEX**



The Roach Flexible conveyor was designed for those times when a fixed conveyor is not applicable. Engineered with the workplace in mind the Flexible is built from quality components that can withstand the rigors of loading docks and back room areas while handling a wide variety of materials. Manufactured in the tradition of Roach excellence the Flexible is one conveyor that will last for years to come.

Model No.	Width	Axle Center	Wheel Per Axle	Contracted Length Expanded Length
FWC-18-3-6-LENGTH	18"	3"	6	1.91:1 Ratio
FWC-18-4-6-LENGTH	18"	4"	6	2.47:1 Ratio
FWC-18-5-6-LENGTH	18"	5"	6	3.04:1 Ratio
FWC-24-3-8-LENGTH	24"	3"	8	1.91:1 Ratio
FWC-24-4-8-LENGTH	24"	4"	8	2.47:1 Ratio
FWC-24-5-8-LENGTH	24"	5"	8	3.04:1 Ratio
FWC-30-3-10-LENGTH	30"	3"	10	1.91:1 Ratio
FWC-30-4-10-LENGTH	30"	4"	10	2.47:1 Ratio
FWC-30-5-10-LENGTH	30"	5"	10	3.04:1 Ratio

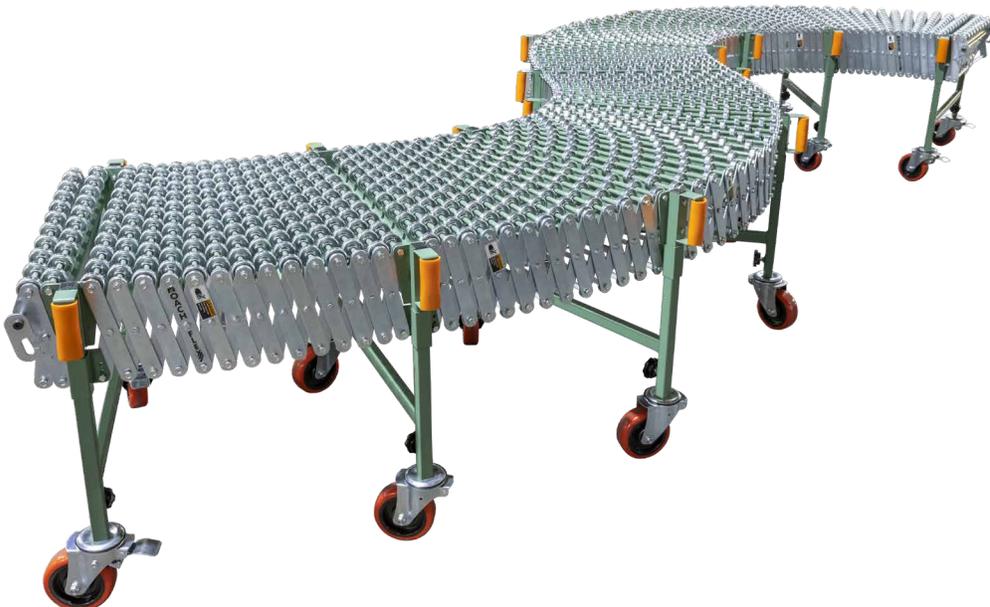
■ 3 week shipment

## SPECIFICATIONS

- ▶ **WHEELS:** 1-15/16" dia. prelubricated steel ball bearing skate wheel with hardened raceway.
- ▶ **AXLES:** Heavy duty 5/16" galvanized steel bolt type axle and lock nut. 5" axle centers.
- ▶ **SIDE LINKS:** Heavy duty 7 gauge steel.
- ▶ **LEG SUPPORTS:** Solid weld construction. Four point leg support connections. Handles on each leg.
- ▶ **CASTERS:** 6" x 2" casters.
- ▶ **CONVEYING SURFACE:** 18", 24", 30"
- ▶ **HEIGHT ADJUSTMENT:** 31-1/2" TO 42-1/2"
- ▶ **EXPANSION RATIO:** 3.04:1 with 5" axle centers.
- ▶ **CAPACITY:** 350 lb. per FT.

## OPTIONS

- 1.91:1 Ratio with 3" axle center
- 2.47:1 Ratio with 4" axle center
- Fixed and retractable end stops
- Impact load table



POWERFLEX

**F  
L  
E  
X**



**When fixed is not applicable  
& gravity is not practical.**

**1.97:1 Expansion Ratio**

**Heavy Duty 5" Axle Centers**

**350 lb/FT Capacity**

**30" Conveying Surface**

**Link Multiple Units**

**End Stop Sensors**

**Accumulation Optional**

The excellent tracking performance of the Powerflex can be seen as materials follow the conveyor path and around curves with extraordinary accuracy. All PowerFlex conveyors are designed with end line sensors to prevent damage to packages by end stops.

Roach PowerFlex is the most durable flexible solution available for any industry application including parcel, e-commerce and retail, airports, warehouse and distribution centers, packaging, and more. The Powerflex Accumulation option is designed to enhance efficiency, reduce downtime, and improve overall material flow. Gain control of sorting, packaging, quality checks, & load balancing through each accumulation zone.



## POWERED ROLLER FLEX CONVEYOR

Model No.	Width BF	Axle Center	Roller Diameter	Expanded Length	Contracted Length	Expansion Ratio
FPRC-30-3-40	30"	3"	1.5"	41'-4"	21'	1.97:1 Ratio
FPRC-30-3-60	30"	3"	1.5"	60'-7"	30'8"	1.97:1 Ratio

■ 3 week shipment

## ACCUMULATION

Model No.	Width BF	Axle Center	Roller Diameter	Expanded Length	Contracted Length	Expansion Ratio
FPRAC-30-3-40	30"	3"	1.5"	40'-5"	23'-6"	1.72:1 Ratio
FPRAC-30-3-60	30"	3"	1.5"	60'-1"	34'-3"	1.75:1 Ratio

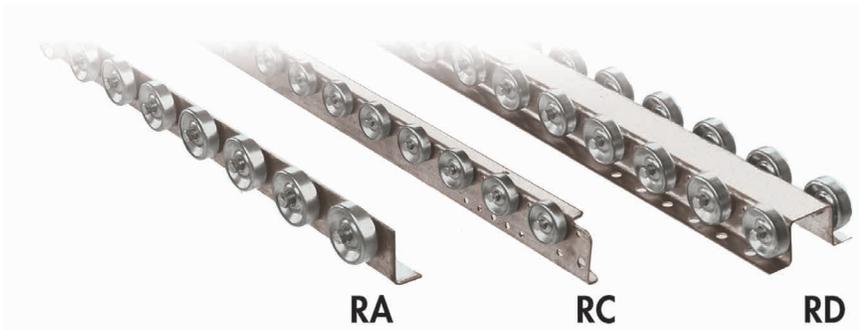
■ 3 week shipment

## SPECIFICATIONS

- ▶ **WHEELS:** 1-15/16" dia. prelubricated steel ball bearing skate wheel with hardened raceway.
- ▶ **AXLES:** Heavy duty 5/16" galvanized steel bolt type axle and lock nut. 5" axle centers.
- ▶ **SIDE LINKS:** Heavy duty 7 gauge steel.
- ▶ **LEG SUPPORTS:** Solid weld construction. Four point leg support connections. Handles on each leg.
- ▶ **CASTERS:** 6" x 2" casters.
- ▶ **CONVEYING SURFACE:** 30"
- ▶ **HEIGHT:** 32"
- ▶ **CAPACITY:** 350 lb. per FT.



## RAIL WHEEL CONVEYORS | RA, RC, RD, RJ, RU

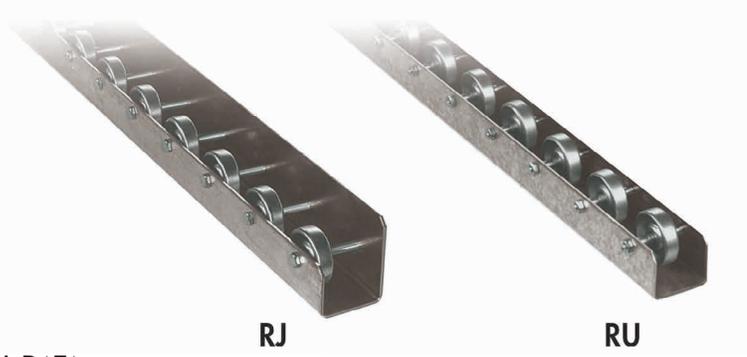
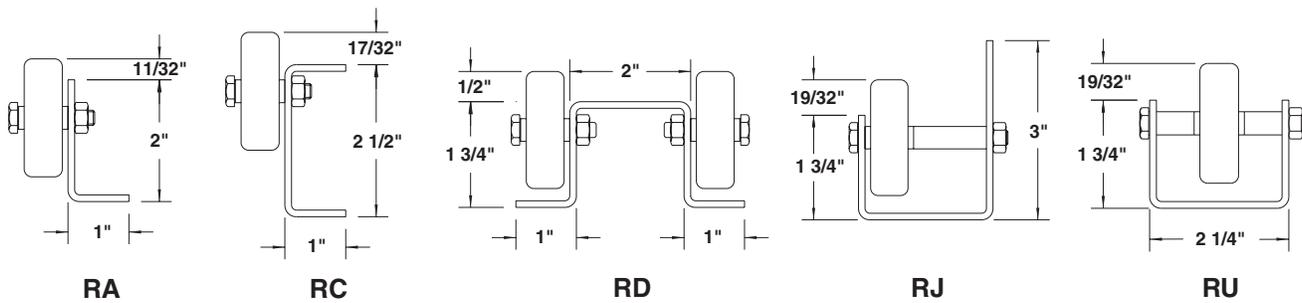


**SPECIFY MODEL NUMBER PER EXAMPLE**  
**EXAMPLE**  
**RA-4**  
 R(rail wheel configuration\*)-(length)  
 \*Specify RA, RC, RD, RJ or RU.



For replacement wheels, refer to part #BRW04600

Rail wheel conveyors are commonly floor or rack mounted to convey unit loads utilizing an arrangement of two or more rail conveyors mounted parallel. Rail wheel conveyors are lightweight.



### SPECIFICATIONS

- ▶ **RAILS:** 12 ga. galvanized steel rails are formed to several different configurations, including RA, RC, RD, RJ, and RU rail wheel conveyors.
- ▶ **WHEELS:** 1-15/16" dia. prelubricated ball bearing wheel with hardened raceway, zinc plated, 50 lb. capacity.
- ▶ **AXLES:** 1/4" dia. galvanized steel bolt-type with lock nut.
- ▶ **LENGTHS:** Available in 1'-0" increments from 1'-0" to 10'-0".
- ▶ **COUPLINGS:** Not supplied, specify type required for pricing.
- ▶ **WHEEL CENTERS:** 3" centers typical on all patterns.

### TECHNICAL DATA

MODEL	Weights Per FT. (lbs.)	Weights Per 10' (lbs.)	Max. Frame Capacity per FT. (lbs.) 5' Support Center	Max. Frame Capacity per FT. (lbs.) 10' Support Center
RA	1.7	17	50	6
RC	2.2	22	146	18
RD	3.8	38	125	15
RJ	3.1	31	198	24
RU	2.7	27	113	14

■ 2 week shipment

# RAIL WHEEL CONVEYORS | RCD-3 & RCD-1.5



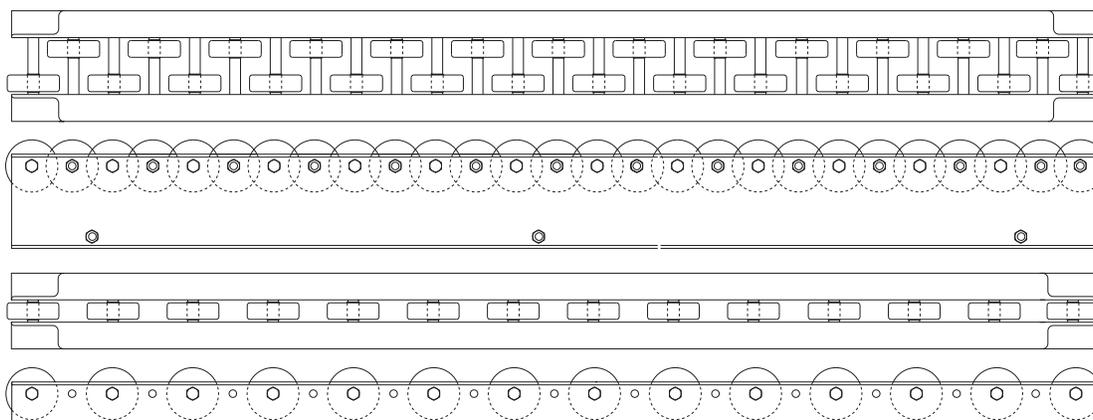
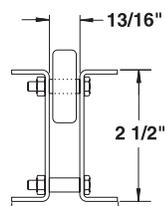
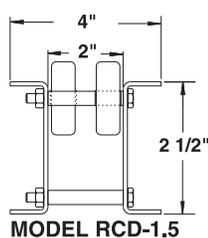
**SPECIFY MODEL NUMBER PER EXAMPLE**

**RCD1.5-9**  
RCD(wheel configuration\*)-(length)  
\*Specify 1.5 for 1-1/2" staggered wheel pattern or  
3 for 3" wheel pattern.

Model RCD rail wheel conveyors is available in two popular styles. Model RCD-3 features wheels on 3" pattern while model RCD-1.5 includes 1-1/2" staggered dense wheel pattern.



For replacement wheels, refer to part #BRW04600



## TECHNICAL DATA

Model	Weights Per FT. (lbs.)	Weights Per 10' (lbs..)	Wheels Per FT.	Max. Frame Capacity Per FT. (lbs.) 5' Support Center	Max. Frame Capacity Per FT. (lbs.) 10' Support Center
RCD-1.5	4.3	43	8	130	35
RCD-3	3.4	34	4	130	35

## SPECIFICATIONS

- ▶ **RAILS:** 12 ga. galvanized steel rails are formed to two varying width rail wheel conveyors, models RCD.
- ▶ **WHEELS:** 1-15/16" dia. prelubricated ball bearing wheel with hardened raceway, zinc plated, 50 lb. capacity.
- ▶ **AXLES:** 1/4" dia. galvanized steel bolt-type with lock nut.
- ▶ **LENGTHS:** Available in 1'-0" increments from 1'-0" to 10'-0".
- ▶ **COUPLINGS:** Not supplied, specify type required for pricing.
- ▶ **WHEEL CENTERS:** Wheels provided on 3" centers with model RCD3; wheels provided on 1-1/2" centers, staggered pattern on model RCD1.5.

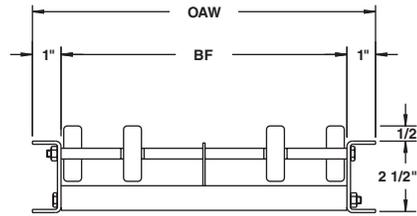
■ 2 week shipment

## WP/WS | GRAVITY WHEEL CONVEYOR



For replacement wheels, refer to part #BRW04600 for zinc plated or #BRW04610 for aluminum.

Optional: Use SL supports on page 137



### STRAIGHT SECTION MODEL NUMBER WS-24-20-10

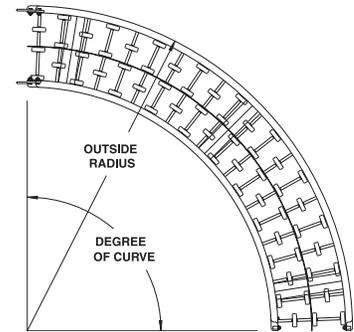
(painted or galv. steel\*)-(overall width)-  
(wheels per foot)-(length)

\*Specify WP for painted frame; WS for galv. steel.

### CURVED SECTION MODEL NUMBER WSC-24-90

(painted or galv. steel\*)-(overall width)-(degree)

\*Specify WPC for aluminum frame; WSC for galv. steel.



### SPECIFICATIONS

► **WHEELS:** 1-15/16" dia. prelubricated ball bearing wheel with hardened raceway. Zinc-plated wheel capacity is 50 lbs. per wheel.

► **AXLES:** 1/4" dia. galvanized steel bolt-type axle and lock nut.

► **FRAMES:** Formed galvanized steel channel 2-1/2" x 1" x 12 ga. (138P optional painted frame)

► **COUPLINGS:** Hook and rod; hooks on one end and rod ("stud") other end.

► **FRAME CAPACITY:** Galv. steel 350 lbs. max. distributed live load per 10' section, or 1300 lbs. per 5' section.

► **RADIUS (CURVES):** 4' or 5' outside radius. See chart below.

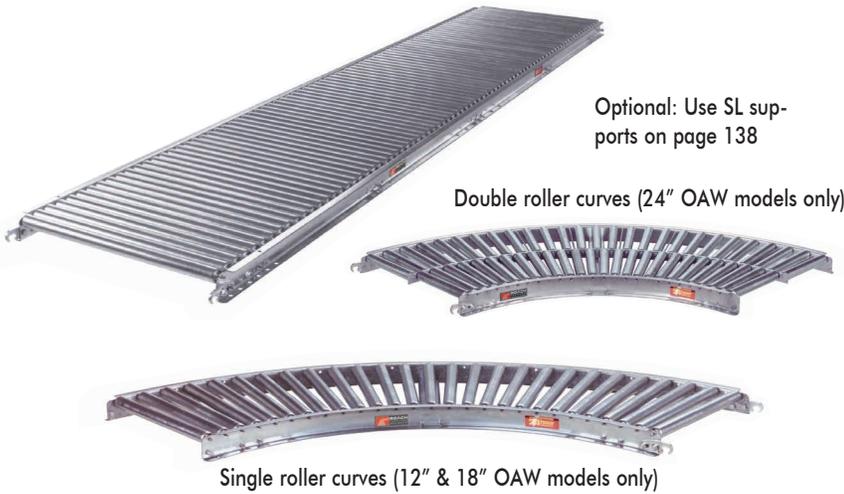
STRAIGHT SECTION				CURVED SECTIONS		
Overall Width	Wheels Per FT.	Model WS Gal. 10' WT. (lbs.)	Model WS Gal. Per FT. WT. (lbs.)	Curve Outside Radius	Model WSC Galv. 90° WT. (lbs.)	Model WSC Galv. 45° WT. (lbs.)
12"	6	64	6.4	-	-	-
	8	67	6.7	-	-	-
	10	70	7.0	4'	70	35
	12	74	7.4	-	-	-
	16	81	8.1	-	-	-
18'	12	78	7.8	-	-	-
	14	85	8.5	-	-	-
	16	88	8.8	4'	80	43
	18	93	9.3	-	-	-
	20	99	9.9	-	-	-
24"	16	96	9.6	-	-	-
	18	102	10.2	-	-	-
	20	105	10.5	4'	92	49
	24	113	11.3	-	-	-
	28	119	11.9	-	-	-
30"	24	148	14.8	-	-	-
	32	169	16.9	5'	104	59
	40	190	19	-	-	-

■ 2 week shipment

### ⚠ WARNING

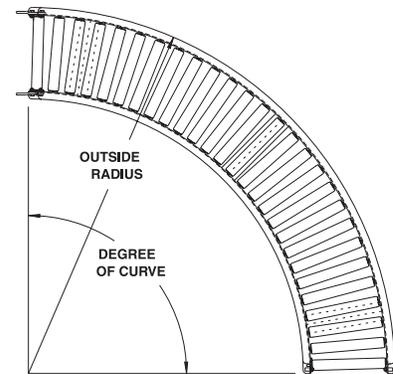
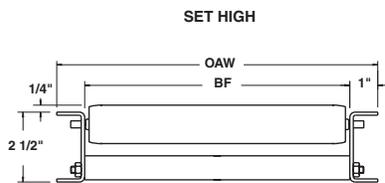
Prevent pinch points that exist when gravity conveyors are permanently attached to power conveyors and other equipment!

# 138P/138G | 1-3/8" DIA. X 18 GA. GRAVITY ROLLER CONVEYOR



**STRAIGHT SECTION MODEL NUMBER**  
**138G-18-3-H-8**  
 (painted or galvanized steel\*)-(overall width)-  
 (roller centers)-(set high or low)-(length)  
 \*Specify 138P for painted frame; 138G for galv. steel.

**CURVED SECTION MODEL NUMBER**  
**138AC-12-H-45**  
 (painted or galv. steel\*)-(overall width)-  
 (set high or low)-(degree)  
 \*Specify 138PC for painted frame; 138GC for galv. steel.



## SPECIFICATIONS

- ▶ **ROLLERS:** Galv. steel (model 138G); both with smooth swaged ends. Roller capacity is 50 lbs. for 138G.
- ▶ **AXLES:** 1/4" dia. galvanized steel shaft, spring loaded.

- ▶ **FRAMES:** Formed galvanized steel channel 2-1/2" x 1" x 12 ga. (138P optional painted frame)
- ▶ **COUPLINGS:** Hook and rod; hooks on one end and rod ("stud") other end.

- ▶ **BEARINGS:** Integral plain ball bearings, zinc plated, oiled.
- ▶ **FRAME CAPACITY:** Galv. steel 350 lbs. max. distributed live load per 10' section, or 1300 lbs. per 5' section.

STRAIGHT SECTION					CURVED SECTIONS			
Roller Centers	Length	Model 138G Gal. 12" OAW WT. (lbs.)	Model 138G Gal. 18" OAW WT. (lbs.)	Model 138G Gal. 24" OAW WT. (lbs.)	Curve Width	Curve Outside Radius	Roller Design	Curve Degree
1.5"	10'	93	131	168	12"	4'	Single	90°
3"	10'	65	85	106	12"	4'	Single	45°
4.5"	10'	56	70	85	18"	4'	Single	90°
6"	10'	51	63	75	18"	4'	Single	45°
9"	10'	46	55	64	24"	4'	Double	90°
12"	10'	44	52	59	24"	4'	Double	45°

NOTE: Nominal 1.5" roller centers on all curved section inside channels.

■ 2 week shipment

**WARNING**

Prevent pinch points that exist when gravity conveyors are permanently attached to power conveyors and other equipment!

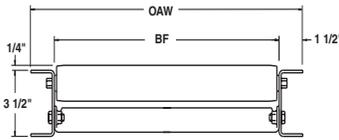
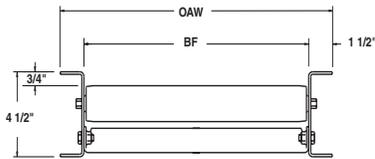
## 196G | 1.9" DIA. X 16 GA. GALVANIZED STEEL GRAVITY ROLLER CONV.



Double roller design



Single roller design



### STRAIGHT SECTION MODEL NUMBER

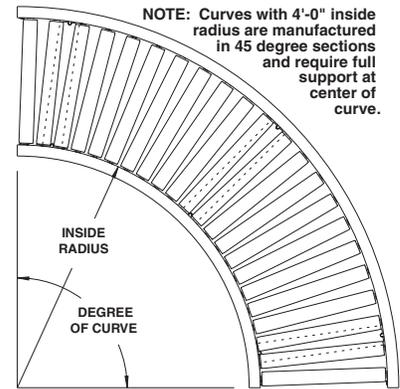
196G-21-3-H-9

196G-(between frames)-(roller centers)-  
(set high or low)-(length)

### CURVED SECTION MODEL NUMBER

196GC-39-H-90

196GC-(between frames)-(set high or low)-(degree)



### SPECIFICATIONS

► **ROLLERS:** 1.9" x 16 ga. galv. steel tubing, model 196G, with smooth swaged ends.

► **FRAMES:** Formed steel painted channel 3-1/2" x 1-1/2" x 10 ga. set high; 4-1/2" x 1-1/2" x 10 ga. set low.

► **BEARINGS:** Integral plain ball bearings, zinc plated, grease packed.

► **FRAME CAPACITY:** 250 lbs. per roller, or 1300 lbs. maximum distributed live load per 10' section with supports at 10' centers; 3200 lbs. at 5' centers.

► **COUPLINGS:** Butt type.

► **AXLES:** 7/16" hex shaft, spring loaded.

► **OPTIONAL FRAME:** 4" @ 5.4 lbs. struc. steel channel frame, rollers 3/16" high, may vary due to structural tolerances.

STRAIGHT SECTION (WT lbs.)							CURVED SECTIONS					
Nominal Roller Length	Between Frames	3" RC 10'	4.5" RC 10'	6" RC 10'	9" RC 10'	12" RC 10'	Curve Inside Radius	Curve Roller Design	90° Rollers Per Curve	90° WT. lbs.	45° Rollers Per Curve	45° WT. lbs.
*6"	*7"	123	103	94	84	79	-	-	-	-	-	-
12"	13"	165	133	117	101	93	2'-8-1/2"	Single	22	217	11	120
14"	15"	179	143	124	106	97	2'-8-1/2"	Single	22	246	11	134
16"	17"	193	152	132	112	102	2'-8-1/2"	Single	22	274	11	147
18"	19"	207	162	140	118	107	2'-8-1/2"	Single	22	303	11	161
20"	21"	221	172	148	123	111	2'-8-1/2'	Single	22	331	11	175
22"	23"	234	182	155	129	116	2'-8-1/2"	Double	41	360	21	188
24"	25"	248	191	163	135	120	2'-8-1/2"	Double	41	388	21	202
26"	27"	262	201	171	140	125	2'-8-1/2"	Double	41	417	21	216
30"	31"	290	221	186	152	134	4'	Double	40	474	20	243
32"	33"	304	231	194	157	129	4'	Double	40	503	20	257
36"	37"	332	250	209	168	148	4'	Double	40	560	20	284
38"	39"	346	260	217	174	153	4'	Double	40	589	20	298
42"	43"	374	280	233	185	162	4'	Double	40	646	20	325
46"	47"	401	299	248	197	171	4'	Double	40	703	20	353
50"	51"	429	319	263	208	180	4'	Double	40	760	20	380

\*7" BF straight sections furnished with spring loaded shafts in set high position ONLY.

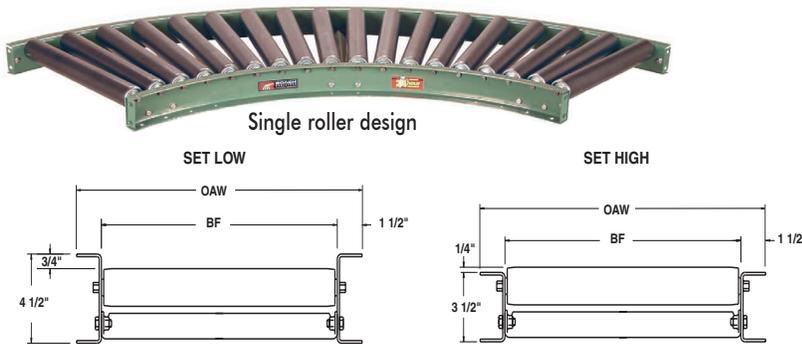
Optional: Use SM supports on page 137

### ⚠ WARNING

To prevent pinch points that exist when gravity conveyors are permanently attached to power conveyors, use connector brackets with safety pop-out rollers shown on pg. 111.

■ 2 week shipment

# 192S | 1.9" DIA. X 12 GA. GRAVITY ROLLER CONVEYOR

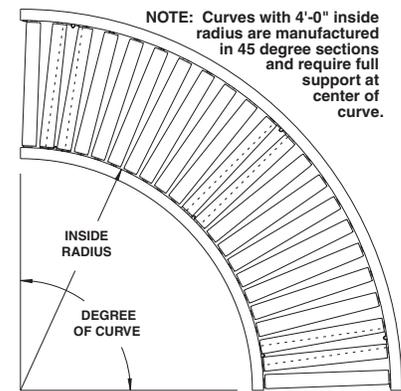


**STRAIGHT SECTION MODEL NUMBER**  
192S-13-3-H-5

192S-(between frames)-(roller centers)-  
(set high or low)-(length)

**CURVED SECTION MODEL NUMBER**  
192SC-27-H-90

192SC-(between frames)-(set high or low)-(degree)



## SPECIFICATIONS

► **ROLLERS:** 1.9" x 12 ga. steel tubing, model 192S, with smooth swaged ends.

► **FRAMES:** Formed steel painted channel 3-1/2" x 1-1/2" x 10 ga. set high; 4-1/2" x 1-1/2" x 10 ga. set low.

► **ROLLER CAPACITY:** 260 lbs. per roller.

► **BEARINGS:** Integral plain ball bearings, zinc plated, grease packed.

► **FRAME CAPACITY:** 1300 lbs. maximum distributed live load per 10' section with supports at 10' centers; 3200 lbs. at 5' centers.

► **COUPLINGS:** Butt type.

► **AXLES:** 7/16" hex shaft, spring loaded.

► **OPTIONAL FRAME:** 4" @ 5.4 lbs. struc. steel channel frame, rollers 3/16" high, may vary due to structural tolerances.

STRAIGHT SECTION (WT lbs.)							CURVED SECTIONS					
Nominal Roller Length	Between Frames	3" RC 10'	4.5" RC 10'	6" RC 10'	9" RC 10'	12" RC 10'	Curve Inside Radius	Curve Roller Design	90° Rollers Per Curve	90° WT. lbs.	45° Rollers Per Curve	45° WT. lbs.
12"	13"	196	153	132	111	100	2'-8-1/2"	Single	22	217	11	120
14"	15"	215	167	142	118	106	2'-8-1/2"	Single	22	246	11	134
16"	17"	235	180	153	126	112	2'-8-1/2"	Single	22	274	11	147
18"	19"	254	194	163	133	118	2'-8-1/2"	Single	22	303	11	161
20"	21"	273	207	174	141	124	2'-8-1/2"	Single	22	331	11	175
22"	23"	293	220	184	148	130	2'-8-1/2"	Double	41	360	21	188
24"	25"	312	234	195	156	136	2'-8-1/2"	Double	41	388	21	202
26"	27"	332	247	205	163	142	2'-8-1/2"	Double	41	417	21	216
30"	31"	370	274	226	178	154	4'	Double	40	474	20	243
32"	33"	390	288	237	186	160	4'	Double	40	503	20	257
36"	37"	428	314	257	200	172	4'	Double	40	560	20	284
38"	39"	448	328	268	208	178	4'	Double	40	589	20	298
42"	43"	487	355	289	223	190	4'	Double	40	646	20	325
46"	47"	525	382	310	238	202	4'	Double	40	703	20	353
50"	51"	564	408	331	253	214	4'	Double	40	760	20	380

Optional: Use SM supports on page 137

■ 2 week shipment

### WARNING

To prevent pinch points that exist when gravity conveyors are permanently attached to power conveyors, use connector brackets with safety pop-out rollers shown on pg. 111.

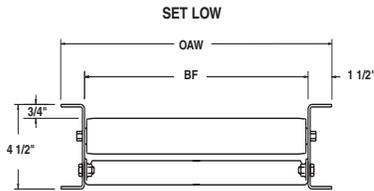
## 199S | 1.9" DIA. X 9 GA. GRAVITY ROLLER CONVEYOR



Double roller design



Single roller design

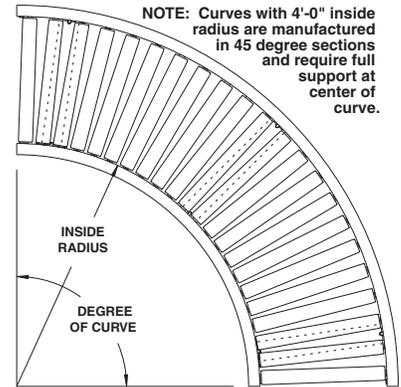


**STRAIGHT SECTION MODEL NUMBER**  
199S-51-3-H-10

199S-(between frames)-(roller centers)-  
(set high or low)-(length)

**CURVED SECTION MODEL NUMBER**  
199SC-37-H-90

199SC-(between frames)-(set high or low)-(degree)



### SPECIFICATIONS

► **ROLLERS:** 1.9" x 9 ga. steel tubing, model 199S, with straight ends reamed to provide smooth bearing seats.

► **FRAMES:** Formed steel painted channel 3-1/2" x 1-1/2" x 10 ga. set high; 4-1/2" x 1-1/2" x 10 ga. set low.

► **ROLLER CAPACITY:** 260 lbs. per roller.

► **BEARINGS:** Integral plain ball bearings, zinc plated, grease packed.

► **FRAME CAPACITY:** 1300 lbs. max. distributed live load per 10' section with supports at 10' centers; 3200 lbs. at 5' ctrs.

► **COUPLINGS:** Butt type.

► **AXLES:** 7/16" hex shaft, spring loaded.

► **OPTIONAL FRAME:** 4" @ 5.4 lbs. struc. steel channel frame, rollers 3/16" high, may vary due to structural tolerances.

STRAIGHT SECTION (WT lbs.)							CURVED SECTIONS					
Nominal Roller Length	Between Frames	3" RC 10'	4.5" RC 10'	6" RC 10'	9" RC 10'	12" RC 10'	Curve Inside Radius	Curve Roller Design	90° Rollers Per Curve	90° WT. lbs.	45° Rollers Per Curve	45° WT. lbs.
12"	13"	224	172	146	120	107	2'-8-1/2"	Single	22	217	9	120
14"	15"	248	188	159	129	114	2'-8-1/2"	Single	22	246	1	134
16"	17"	272	205	171	138	121	2'-8-1/2"	Single	22	274	9	147
18"	19"	296	221	184	147	128	2'-8-1/2"	Single	22	303	9	161
20"	21"	319	238	197	156	135	2'-8-1/2'	Single	22	331	9	175
22"	23"	343	254	209	165	143	2'-8-1/2"	Double	41	360	17	188
24"	25"	367	270	222	174	150	2'-8-1/2"	Double	41	388	17	202
26"	27"	391	287	235	183	157	2'-8-1/2"	Double	41	417	17	216
30"	31"	439	320	260	201	171	4'	Double	40	474	20	243
32"	33"	462	336	273	210	178	4'	Double	40	503	20	257
36"	37"	510	369	298	228	192	4'	Double	40	560	20	284
38"	39"	534	385	311	237	199	4'	Double	40	589	20	298
42"	43"	582	418	336	254	214	4'	Double	40	646	20	325
46"	47"	629	451	362	272	228	4'	Double	40	703	20	353
50"	51"	677	484	387	290	242	4'	Double	40	760	20	380

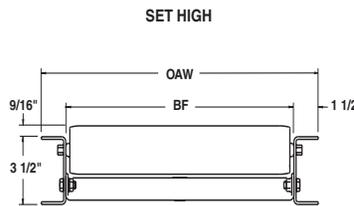
Optional: Use SM supports on page 137

■ 2 week shipment

### ⚠ WARNING

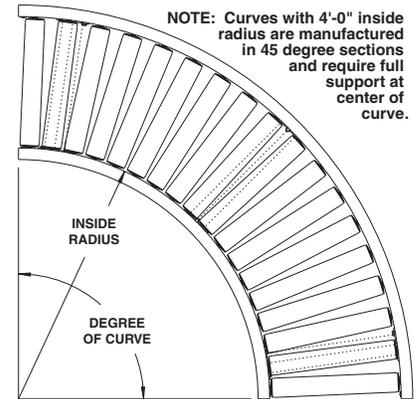
Prevent pinch points that exist when gravity conveyors are permanently attached to power conveyors and other equipment!

# 254S | 2-1/2" DIA. X 14 GA. STEEL GRAVITY ROLLER CONVEYOR



**STRAIGHT SECTION MODEL NUMBER**  
**254S-43-9-H-4**  
 254S-(between frames)-(roller centers)-  
 (set high or low)-(length)

**CURVED SECTION MODEL NUMBER**  
**254SC-19-H-45**  
 254SC-(between frames)-(set high or low)-(degree)



## SPECIFICATIONS

- ▶ **ROLLERS:** 2-1/2" x 14 ga. steel tubing, model 254S, with smooth swaged ends.
- ▶ **FRAMES:** Formed steel painted channel 3-1/2" x 1-1/2" x 10 ga. set high; 4-1/2" x 1-1/2" x 10 ga. set low.
- ▶ **ROLLER CAPACITY:** 290 lbs. per roller.
- ▶ **BEARINGS:** Integral plain ball bearings, zinc plated, grease packed.
- ▶ **FRAME CAPACITY:** 1300 lbs. maximum distributed live load per 10' section with supports at 10' centers; 3200 lbs. at 5' centers.
- ▶ **COUPLINGS:** Butt type.
- ▶ **AXLES:** 7/16" hex shaft, spring loaded.
- ▶ **OPTIONAL FRAME:** 4" @ 5.4 lbs. struc. steel channel frame, rollers 3/16" high, may vary due to structural tolerances.

STRAIGHT SECTION (WT lbs.)							CURVED SECTIONS						
Nominal Roller Length	Between Frames	3" RC 10'	4.5" RC 10'	6" RC 10'	9" RC 10'	12" RC 10'	Curve Inside Radius	Curve Roller Design	90° Rollers Per Curve	90° WT. lbs.	45° Rollers Per Curve	45° WT. lbs.	
12"	13"	183	144	125	106	96	2'-8/1/2"	Single	18	217	9	120	
14"	15"	203	158	136	113	102	2'-8-1/2"	Single	18	246	1	134	
16"	17"	222	172	146	121	108	2'-8-1/2"	Single	18	274	9	147	
18"	19"	242	185	157	129	114	2'-8-1/2"	Single	18	303	9	161	
20'	21"	262	199	168	136	120	2'-8-1/2'	Single	18	331	9	175	
22"	23"	281	213	178	144	127	2'-8-1/2"	Double	37	360	17	188	
24"	25"	301	226	189	151	133	2'-8-1/2"	Double	37	388	17	202	
26"	27"	321	240	199	159	139	2'-8-1/2"	Double	37	417	17	216	
30"	31"	360	267	221	174	151	4'	Double	40	474	20	243	
32"	33"	380	281	231	182	157	4'	Double	40	503	20	257	
36"	37"	419	308	253	197	169	4'	Double	40	560	20	284	
38"	39"	439	322	263	205	175	4'	Double	40	589	20	298	
42"	43"	478	349	284	220	188	4'	Double	40	646	20	325	
46"	47"	518	376	306	235	200	4'	Double	40	703	20	353	
50"	51"	557	404	327	250	212	4'	Double	40	760	20	380	

Optional: Use SM supports on page 137

■ 2 week shipment

### WARNING

To prevent pinch points that exist when gravity conveyors are permanently attached to power conveyors, use connector brackets with safety pop-out rollers shown on pg. 111.

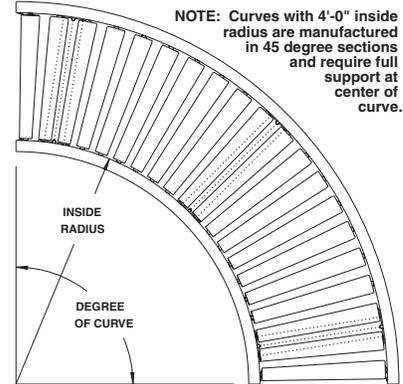
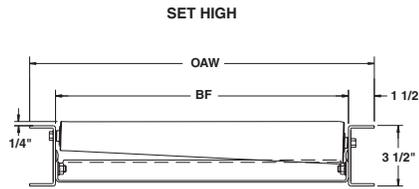
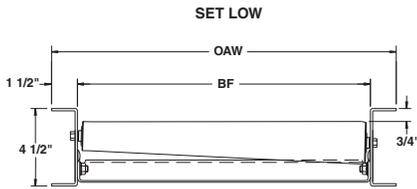
## 254TC | 2-1/2" DIA. X 14 GA. TAPERED ROLLER CURVE



Optional: Use SM supports on page 137

**254TC CURVED SECTION MODEL NUMBER**  
**254TC-13-H-90**

254TC-(between frames)-(set high or low)-(degree)



### SPECIFICATIONS

► **TAPERED ROLLERS:** 2-1/2" dia. to 1-11/16" dia. x 14 ga. steel tubing, model 254T, with smooth swaged ends.

► **FRAMES:** Formed steel painted channel 3-1/2" x 1-1/2" x 10 ga. set high; 4-1/2" x 1-1/2" x 10 ga. set low.

► **ROLLER CAPACITY:** 250 lbs. per roller.

► **AXLES:** 7/16" hex shaft, spring loaded.

► **BEARINGS:** Integral plain ball bearings, zinc plated, grease packed,

removable type bearings.

► **FRAME CAPACITY:** 650 lbs. maximum distributed live load with supports at each end of curve section and at the outside of a 90° curve section.

► **COUPLINGS:** Butt type.

TAPERED ROLLER CURVES						
Nominal Roller Length	Between Frames	CURVE INSIDE RADIUS	90° ROLLERS PER CURVE	90° WEIGHT lbs.	45° ROLLERS PER CURVE	45° WEIGHT lbs.
12"	13"	2'-8-1/2"	20	61	10	37
14"	15"	2'-8-1/2"	20	68	10	40
16"	17"	2'-8-1/2"	20	75	10	43
18"	19"	2'-8-1/2"	20	82	10	47
20"	21"	2'-8-1/2"	20	89	10	50
22"	23"	2'-8-1/2"	20	97	10	53
24"	25"	2'-8-1/2"	20	104	10	56
26"	27"	2'-8-1/2"	20	111	10	59
30"	31"	4'	32	125	16	66
32"	33"	4'	32	132	16	69
36"	37"	4'	32	146	16	76
38"	39"	4'	32	153	16	79
*42"	*43"	4'	32	168	16	85
*46"	*47"	4'	32	182	16	92
*50"	*51"	4'	32	196	16	98

■ 2 week shipment

### ⚠ WARNING

Prevent pinch points that exist when gravity conveyors are permanently attached to power conveyors and other equipment!

# 251S | 2-1/2" DIA. X 11 GA. STEEL GRAVITY ROLLER CONVEYOR



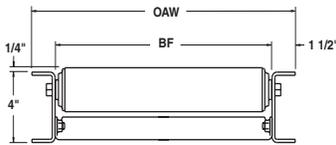
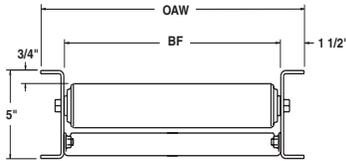
Optional: Use SH or SS supports on page 138



Double roller design



Single roller design



### STRAIGHT SECTION MODEL

#### NUMBER

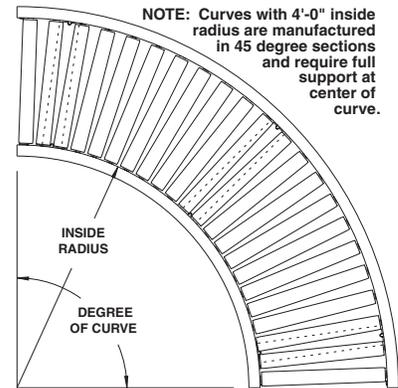
251S-51-3-H-8

251S-(between frames)-(roller centers)-  
(set high or low)-(length)

### CURVED SECTION MODEL NUMBER

251SC-33-L-90

251SC-(between frames)-(set high or low)-(degree)



### SPECIFICATIONS

► **ROLLERS:** 2-1/2" x 11 ga. steel tubing, model 251S, with flanged type bearings pressed into straight ends.

► **ROLLER CAPACITY:** 540 lbs. per roller.

► **BEARINGS:** Precision ABEC bearings.

► **FRAMES:** Formed steel painted channel 4" x 1-1/2" x 7 ga. set high; 5" x 1-1/2" x 7 ga. set low.

► **FRAME CAPACITY:** 3400 lbs. maximum distributed live load per 10' section with supports at 10' ctrs; 7500 lbs. at 5' ctrs.

► **COUPLINGS:** Butt type.

► **AXLES:** 11/16" hex shaft, spring loaded.

► **OPTIONAL FRAME:** For structural steel channel frame, see next page.

STRAIGHT SECTION (WT lbs.)							CURVED SECTIONS					
Nominal Roller Length	Between Frames	3" RC 10'	4.5" RC 10'	6" RC 10'	9" RC 10'	12" RC 10'	Curve Inside Radius	Curve Roller Design	90° Rollers Per Curve	90° WT. lbs.	45° Rollers Per Curve	45° WT. lbs.
*6"	*7"	234	186	161	137	125	-	-	-	-	-	-
12"	13"	327	249	210	171	152	2'-8-1/2"	Single	18	217	9	120
14"	15"	358	270	227	183	161	2'-8-1/2"	Single	18	246	9	134
16"	17"	389	292	243	194	170	2'-8-1/2"	Single	18	274	9	147
18"	19"	421	313	259	205	178	2'-8-1/2"	Single	18	303	9	161
20'	21"	452	334	275	217	187	2'-8-1/2'	Single	18	331	9	175
22"	23"	483	355	292	228	196	2'-8-1/2"	Single	18	360	9	188
24"	25"	514	377	308	239	205	2'-8-1/2"	Single	18	388	9	202
26"	27"	545	398	324	251	214	2'-8-1/2"	Single	18	417	9	216
30"	31"	607	440	357	274	232	4'	Double	40	474	20	243
32"	33"	638	462	373	285	241	4'	Double	40	503	20	257
36"	37"	700	504	406	308	259	4'	Double	40	560	20	284
38"	39"	731	525	422	319	268	4'	Double	40	589	20	298
42"	43"	794	568	455	342	285	4'	Double	40	646	20	325
46"	47"	856	610	487	365	303	4'	Double	40	703	20	353
50"	51"	918	653	520	387	321	4'	Double	40	760	20	380

\*7" BF and 9" BF straight sections furnished with spring loaded shafts in set high position ONLY.

### WARNING

To prevent pinch points that exist when gravity conveyors are permanently attached to power conveyors, use connector brackets with safety pop-out rollers shown on pg. 111.

■ 2 week shipment

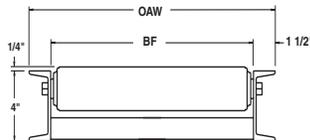
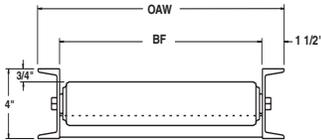
## 251S STRUCTURAL | 2-1/2" DIA. X 11 GA. STEEL GRAVITY ROLLER CONVEYOR



Double roller design



Single roller design

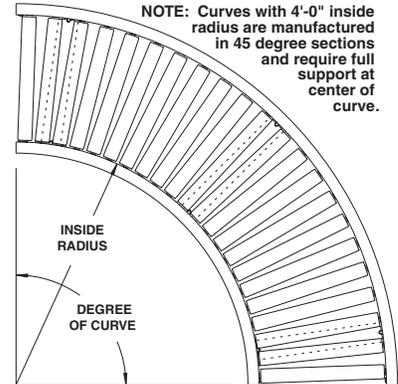


**STRAIGHT SECTION MODEL NUMBER**  
251S-45-6-L-9-S

251S-(between frames)-(roller centers)-(set high or low)-(length)-(structural frame)

**CURVED SECTION MODEL NUMBER**  
251SC-31-H-90-S

251SC-(between frames)-(set high or low)-(degree)-(structural frame)



### SPECIFICATIONS

► **ROLLERS:** 2-1/2" x 11 ga. steel tubing, model 251S, with flanged type bearings pressed into straight ends.

► **ROLLER CAPACITY:** 540 lbs. per roller.

► **BEARINGS:** Precision ABEC bearings.

► **FRAMES:** 4" at 5.4 lbs. structural steel painted channel.

► **FRAME CAPACITY:** 3750 lbs. maximum distributed live load per 10' section with supports at 10' ctrs; 8000 lbs. at 5' ctrs.

► **COUPLINGS:** Butt type.

► **AXLES:** 11/16" hex shaft, spring loaded.

STRAIGHT SECTION (WT lbs.)												CURVED SECTIONS					
Nominal Roller Length	Between Frames	3" RC 10'	3" RC 5'	4.5" RC 10'	4.5" RC 5'	6" RC 10'	6" RC 5'	9" RC 10'	9" RC 5'	12" RC 10'	12" RC 5'	Curve Inside Radius	Curve Roller Design	90° Rollers Per Curve	90° WT. lbs.	45° Rollers Per Curve	45° WT. lbs.
*8"	*9"	303	153	257	131	234	108	186	96	167	84	-	-	-	-	-	-
12"	13"	365	185	304	155	263	125	209	108	184	95	2'-8-1/2"	Single	18	196	9	99
14"	15"	396	203	328	168	270	135	223	116	192	101	2'-8-1/2"	Single	18	212	9	107
16"	17"	429	219	353	181	278	143	234	121	202	105	2'-8-1/2"	Single	18	227	9	115
18"	19"	460	235	377	193	294	152	246	128	211	111	2'-8-1/2"	Single	18	243	9	122
20'	21"	491	251	400	206	311	161	258	135	220	116	2'-8-1/2'	Single	18	259	9	131
22"	23"	524	267	446	218	328	169	271	141	232	121	2'-8-1/2"	Single	18	275	9	138
24"	25"	555	284	450	232	345	179	282	148	239	126	2'-8-1/2"	Single	18	290	9	146
26"	27"	582	297	470	241	358	185	291	151	245	128	2'-8-1/2"	Single	18	306	9	154
30"	31"	646	330	518	266	390	202	317	166	263	138	4'	Double	40	441	20	237
32"	33"	678	346	543	279	408	212	338	172	272	144	4'	Double	40	460	20	257
36"	37"	739	378	589	303	440	228	351	184	290	153	4'	Double	40	495	20	265
38"	39"	770	394	613	315	456	247	363	190	299	168	4'	Double	40	513	20	276
42"	43"	833	426	661	340	486	254	387	203	317	179	4'	Double	40	550	20	297
44"	45"	864	443	685	353	501	263	399	209	326	185	4'	Double	40	568	20	306
46"	47"	895	459	709	365	516	272	411	216	335	191	4'	Double	40	586	20	316
50"	51"	958	491	757	389	546	289	435	228	353	202	4'	Double	40	622	20	336

\*9" BF straight sections furnished with spring loaded shafts in set high position ONLY.

Optional: Use SH or SS supports on page 138

### WARNING

Prevent pinch points that exist when gravity conveyors are permanently attached to power conveyors and other equipment!

■ 3 week shipment

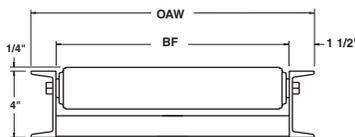
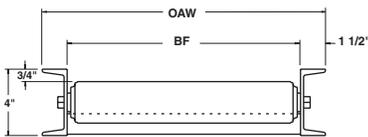
# 297S | 2-9/16" DIA. X 7 GA. STEEL GRAVITY ROLLER CONVEYOR



Double roller design



Single roller design



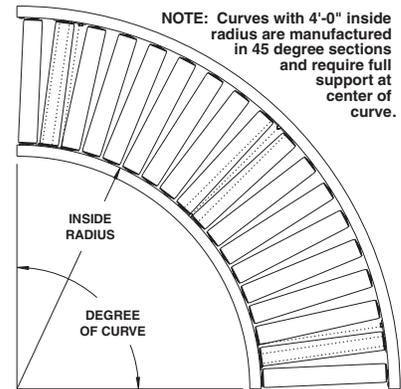
**STRAIGHT SECTION MODEL**

**NUMBER 297S-45-6-L-6**

297S-(between frames)-(roller centers)-  
(set high or low)-(length)

**CURVED SECTION MODEL NUMBER  
297SC-39-H-90**

297SC-(between frames)-(set high or low)-(degree)



**SPECIFICATIONS**

- ▶ **ROLLERS:** 2-9/16" x 7 ga. steel tubing, model 297S, with straight ends, reamed to provide smooth bearing seats.
- ▶ **ROLLER CAPACITY:** 540 lbs. per roller.

- ▶ **AXLES:** 11/16" hex shaft, spring loaded.
- ▶ **BEARINGS:** Precision ABEC bearings.
- ▶ **FRAMES:** 4" at 5.4 lbs. structural steel painted channel.

- ▶ **COUPLINGS:** Butt type.
- ▶ **FRAME CAPACITY:** 3750 lbs. maximum distributed live load per 10' section with supports at 10' centers; 8000 lbs. at 5' centers.

STRAIGHT SECTION (WT lbs.)							CURVED SECTIONS					
Nominal Roller Length	Between Frames	3" RC 10'	4.5" RC 10'	6" RC 10'	9" RC 10'	12" RC 10'	Curve Inside Radius	Curve Roller Design	90° Rollers Per Curve	90° WT.	45° Rollers Per Curve	45° WT.
12"	13"	416	317	267	218	193	2'-8-1/2"	Single	18	217	11	120
14"	15"	457	345	289	232	204	2'-8-1/2"	Single	18	246	11	134
16"	17"	498	373	310	247	216	2'-8-1/2"	Single	18	274	11	147
18"	19"	539	401	331	261	227	2'-8-1/2"	Single	18	303	11	161
20"	21"	581	428	352	276	238	2'-8-1/2"	Single	18	331	11	175
22"	23"	622	456	373	291	249	2'-8-1/2"	Single	18	360	21	188
24"	25"	663	484	395	305	261	2'-8-1/2"	Single	18	388	21	202
26"	27"	704	512	416	320	272	2'-8-1/2"	Single	18	417	21	216
30"	31"	786	568	458	349	294	4'	Double	40	474	20	243
32"	33"	828	596	480	364	306	4'	Double	40	503	20	257
36"	37"	910	651	522	393	328	4'	Double	40	560	20	284
38"	39"	951	679	543	407	339	4'	Double	40	589	20	298
42"	43"	1033	735	586	436	362	4'	Double	40	646	20	325
46"	47"	1116	791	628	466	384	4'	Double	40	703	20	353
50"	51"	1198	847	671	495	407	4'	Double	40	760	20	380

Optional: Use SH or SS supports on page 138

■ 3 week shipment

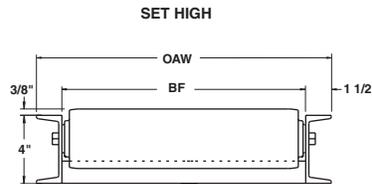
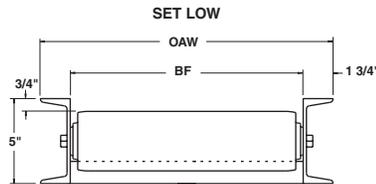
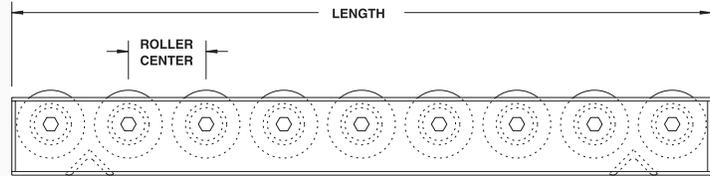
**⚠ WARNING**

To prevent pinch points that exist when gravity conveyors are permanently attached to power conveyors, use connector brackets with safety pop-out rollers shown on pg. 111.

## 3509S | 3-1/2" DIA. X 9 GA. STEEL GRAVITY ROLLER CONVEYOR



**STRAIGHT SECTION MODEL NUMBER**  
**3509S-47-4-H-3**  
 3509S-(between frames)-(roller centers)-  
 (set high or low)-(length)



### SPECIFICATIONS

- ▶ **ROLLERS:** 3-1/2" x 9 ga. steel tubing, model 3509S, with straight ends, reamed to provide smooth bearing seats.
- ▶ **ROLLER CAPACITY:** 700 lbs. per roller.
- ▶ **AXLES:** 11/16" hex shaft, spring loaded.
- ▶ **FRAMES:** 4" at 5.4 lbs. structural steel painted channel set high; 5" at 6.7 lbs. structural steel painted channel set low (extra charge for set low).
- ▶ **COUPLINGS:** Butt type.
- ▶ **BEARINGS:** Precision ABEC bearings.
- ▶ **FRAME CAPACITY:** 3750 lbs. maximum distributed live load per 10' section with supports at 10' centers; 8000 lbs. at 5' centers.

STRAIGHT SECTIONS (WT lbs.)					
NOMINAL ROLLER LENGTH	BETWEEN FRAMES	4" RC 10'	6" RC 10'	8" RC 10'	12" RC 10'
10"	11"	296	234	203	172
14"	15"	366	280	238	195
18"	19"	435	327	273	218
22"	23"	505	373	307	242
26"	27"	575	420	342	265
30"	31"	645	466	377	288
34"	35"	714	513	412	311
38"	39"	784	559	447	334
42"	43"	854	606	482	358
44"	45"	888	629	499	369
46"	47"	923	652	516	381
50"	51"	993	699	551	404

Optional: Use SH or SS supports on page 138

■ 3 week shipment

### ⚠ WARNING

Prevent pinch points that exist when gravity conveyors are permanently attached to power conveyors and other equipment!

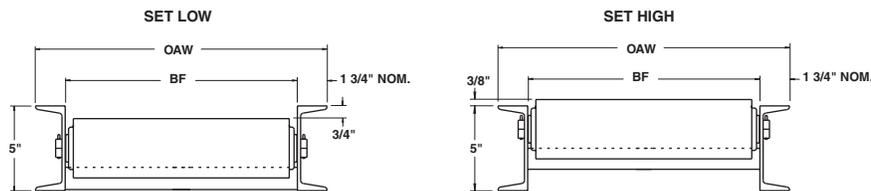
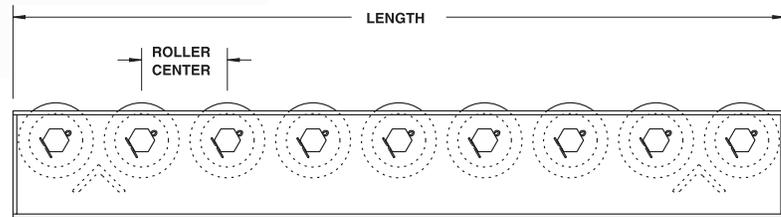
# 3530S | 3-1/2" DIA. X .300 STEEL GRAVITY ROLLER CONVEYOR



## STRAIGHT SECTION MODEL NUMBER

**3530S-47-6-H-7**

3530S-(between frames)-(roller centers)-  
(set high or low)-(length)



## SPECIFICATIONS

► **ROLLERS:** 3-1/2" x .300 steel tubing, model 3530S, with straight ends, reamed to provide smooth bearing seats.

► **ROLLER CAPACITY:** 2500 lbs. per roller.

► **AXLES:** 1-1/16" hex with shaft retaining angles.

► **FRAMES:** 5" at 6.7 lbs. structural steel painted channel.

► **BEARINGS:** Precision ABEC bearings.

► **COUPLINGS:** Butt type.

► **FRAME CAPACITY:** 6600 lbs. maximum distributed live load per 10' section with supports at 10' centers; 16,000 lbs. at 5' centers.

STRAIGHT SECTIONS (WT lbs.)					
NOMINAL ROLLER LENGTH	BETWEEN FRAMES	4" RC 10'	6" RC 10'	8" RC 10'	12" RC 10'
6"	7"	364	288	250	212
10"	11"	500	379	318	257
14"	15"	635	469	386	303
18"	19"	771	560	454	348
22"	23"	907	650	522	393
26"	27"	1043	741	589	438
30"	31"	1178	831	657	484
34"	35"	1314	1235	980	726
38"	39"	1450	1012	793	574
42"	43"	1586	1103	861	619
44"	45"	1653	1148	895	642
46"	47"	1721	1193	929	665
50"	51"	1857	1284	997	710

Optional: Use SH or SS3530 supports on page 138

■ 3 week shipment

### ⚠ WARNING

To prevent pinch points that exist when gravity conveyors are permanently attached to power conveyors, use connector brackets with safety pop-out rollers shown on pg. 111.

## MODEL B | BALL TRANSFER UNITS

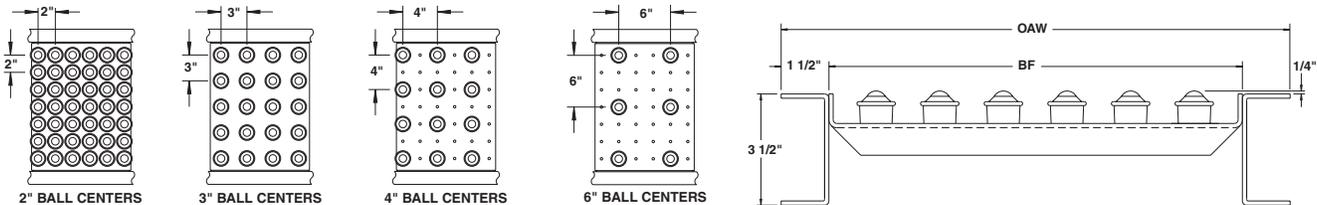


**BALL TRANSFER MODEL NUMBER**  
**B-27-3-5**  
 B-(between frames)-(ball centers)-(length)



For replacement ball assemblies, refer to part #BRW04650

**DETERMINE BALL SPACING** by dividing minimum package dimension by 2.5. Center to center ball spacing results with minimum of 9 ball casters required to support each package.



### SPECIFICATIONS

- ▶ **BALL ASSEMBLIES:** 1" dia. steel ball x 1-13/16" overall housing diameter. Mounting bolt is 1/4"-20.
- ▶ **BALL CAPACITY:** 50 lbs. per ball with max. unit load not to exceed the capacity of 4 balls (200#).

- ▶ **FRAMES:** 3-1/2" x 1-1/2" x 10 ga. steel with balls in set high position (1/4" above side frames) only.
- ▶ **FRAME CAPACITY:** 1300 lbs. maximum distributed live load per 10' section with supports at 10' ctrs; 3200 lbs. at 5' ctrs.

- ▶ **PLATES:** Balls are attached in square pattern to 10 ga. formed plates up to 39" BF. Above 39", plates are 7 ga.
- ▶ **COUPLINGS:** Butt type.

BALL TRANSFERS								
BETWEEN FRAMES	2" CENTERS BALLS PER FT.	3" CENTERS BALLS PER FT.	4" CENTERS BALLS PER FT.	6" CENTERS BALLS PER FT.	2" CENTERS WT. PER FT. (lbs.)	3" CENTERS WT. PER FT. (lbs.)	4" CENTERS WT. PER FT. (lbs.)	6" CENTERS WT. PER FT. (lbs.)
13"	36	20	12	6	28	22	19	16
15"	42	20	12	6	32	23	20	17
17"	48	24	15	8	35	26	23	18
19"	54	28	15	8	38	28	24	20
21"	60	28	18	8	42	30	26	21
23"	66	32	18	10	45	32	27	22
25"	72	36	21	10	48	34	29	24
27"	78	36	21	10	52	36	30	25
31"	90	44	24	12	58	40	34	26
33"	96	44	27	12	62	42	36	29
37"	108	52	30	14	69	45	39	30
39"	114	52	30	14	72	49	40	33
43"	126	60	33	16	79	53	43	34
47"	138	64	36	18	85	57	47	40
51"	150	68	39	18	92	61	50	42

Optional: Use SM supports on page 137

■ 2 week shipment

### WARNING

To prevent pinch points that exist when gravity conveyors are permanently attached to power conveyors, use connector brackets with safety pop-out rollers shown on pg. 111.

## GRAVITY BUTT SPURS

## WHEEL AND 1-3/8" DIA. X 18 GA. GALV. ROLLER BUTT SPURS



Roach gravity roller butt spurs divert flow of goods at 30° or 45°, right or left and 90° by simply adding a standard 45° curve to spur.

## SPECIFICATIONS

► **ROLLERS:** 1-3/8" x 18 ga. galvanized steel roller, model 138G, on model BSR.

► **WHEELS:** 1-15/16" dia. prelubricated ball bearing wheel with hardened raceway, zinc plated on model BSW.

► **FRAMES:** Formed galvanized steel channel 2-1/2" x 1" x 12 ga.; supplied with hook and rod coupling.

## ROLLER BUTT SPURS MODEL NUMBER

BSR-12-1.5-30-R

BSR-(overall width\*)-(roller centers\*\*)-(degree@)-(left or right hand#)

\*Specify 12", 18" or 24" OAW.

\*\*Specify 1.5" or 3" roller centers. NOTE: 2 week

shipment on models with 1.5" roller centers.

@Specify 30° or 45°.

#See page 26 to determine hand of spur.

## WHEEL BUTT SPURS MODEL NUMBER

BSW-12-30-R

BSW-(overall width\*)-(degree@)-(left or right hand#)

\*Specify 12", 18" or 24" OAW.

@Specify 30° or 45°.

#See page 26 to determine hand of spur.

■ 2 week shipment

## 1.9" DIA. X 16 GA. STEEL ROLLER BUTT SPURS



Roach gravity roller butt spurs divert flow of goods at 30° or 45°, right or left and 90° by simply adding a standard 45° curve to spur.

## SPECIFICATIONS

► **ROLLERS:** 1.9" x 16 ga. galv. steel, model 196G.

► **FRAMES:** Formed steel channel, 3-1/2" x 1-1/2" x 10 ga.; 13", 15", 17", 19", 21", 23", 25", 27", 31", 33", 37", 39", 43", 47" and 51" BF available.

► **ROLLER CENTERS:** Model RBS furnished with 3" roller centers.

► **BEARINGS:** Integral plain ball bearings, zinc plated, grease packed.

## 1.9" ROLLER BUTT SPURS MODEL NUMBER

RBS-13-30-R

RBS-(between frames)-(degree@)-(left or right hand#)

@Specify 30° or 45°.

#See page 26 to determine hand of spur.

■ 2 week shipment

**PRODUCT STOPS**

**MEDIUM DUTY PNEUMATIC ROLLER AND BLADE STOPS (FOR GRAVITY)**



Pneumatic gravity conveyor stops are used where automatic line control is required such as slug accumulation, indexing, etc. This stop is designed for 3-1/2" and 4" deep frames.

**PNEUMATIC STOPS MODEL NUMBER**

**PRSL-196-21**

P (roller or blade stop\*)(left or right\*\*)-  
(roller type@)-(between frames)

\*Specify RS for roller stop; BS for blade stop.

\*\*Specify L for left hand; R for right hand.

@Specify 196 for 196S, 192 for 192S, 199 for 199S.

■ 3 week shipment

**SPECIFICATIONS**

- ▶ **ROLLER STOP:** 1.9" dia. x 16 ga. galv. steel 196G roller for medium duty; 2.5" dia. x 11 ga. steel 251S roller for heavy duty.
- ▶ **BLADE STOP:** 7 ga. formed angle.
- ▶ **AIR CYLINDER:** Double action.(60-80 PSI required)
- ▶ **BEARINGS:** Removable type, heavy duty ball bearing, with cast iron housings.

- ▶ **SOLENOID VALVE:** Single.
- ▶ **LOCK:** Positive over center locking device to hold position.
- ▶ **WIDTHS:** 13", 15", 17", 19", 21", 23", 25", 27", 31", 33", 37", 39", 43", 45", 47" and 51" BF.
- ▶ **OPTIONAL:** Double solenoid/elec. controls.

**MEDIUM DUTY MANUAL ROLLER AND BLADE STOPS (FOR GRAVITY)**



Manual operated gravity conveyor stops are hand operated and used where line control is required such as slug accumulation, indexing, workstations, etc. This stop is designed for 3-1/2" and 4" deep frames.

**MANUAL STOPS MODEL NUMBER**

**MBSR-192-25**

M (roller or blade stop\*)(left or right\*\*)-  
(roller type@)-(between frames)

\*Specify RS for roller stop; BS for blade stop.

\*\*Specify L for left hand; R for right hand.

@Specify 196 for 196S, 192 for 192S, 199 for 199S.

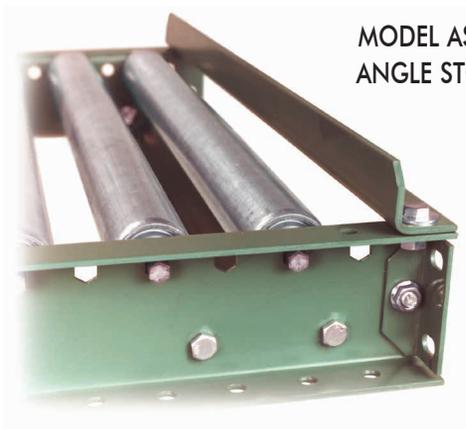
■ 3 week shipment

**SPECIFICATIONS**

- ▶ **ROLLER STOP:** 1.9" dia. x 16 ga. galv. steel 196G roller for medium duty; 2.5" dia. x 11 ga. steel 251S roller for heavy duty.
- ▶ **BEARINGS:** Removable type, heavy duty ball bearing, with cast iron housings.

- ▶ **LOCK:** Positive over center locking device to hold position.
- ▶ **BLADE STOP:** 7 ga. formed angle.
- ▶ **WIDTHS:** 13", 15", 17", 19", 21", 23", 25", 27", 31", 33", 37", 39", 43", 45", 47" and 51" BF.

## PRODUCT STOPS ANGLE AND ROLLER STOPS



**MODEL ASM  
ANGLE STOP**

Both angle and roller stops serve as an economical means to stopping goods at a given fixed point. "BR" brackets or angle stop quickly attaches to conveyor frame top flange.

### SPECIFICATIONS

► **ANGLE STOP:** Model ASL for light duty and ASM for medium duty applications (1-1/2" x 1-1/2" x 10 ga.); Model ASH for heavy duty applications (1-1/2" x 1-1/2" x 7 ga.).

► **ROLLER STOP:** Includes pair of brackets and roller as specified in model number.

► **WIDTHS:** Medium and heavy duty 13", 15", 17", 19", 21", 23", 25", 27", 31", 33", 37", 39", 43", 45", 47" and 51" BF; light duty available in 12", 18" and 24" OAW.

### ANGLE STOPS MODEL NUMBER ASM-33

AS (light, medium or heavy duty\*)-(between frames\*\*)  
\*Specify L for light duty, M for medium duty or H for heavy duty.

\*\*Specify OAW for model ASL, available in 12", 18" and 24" OAW only and is suited specifically for wheel conveyors and 138 gravity series.

### ROLLER STOPS MODEL NUMBER BR-196G-21

BR-(roller type\*)-(between frames)

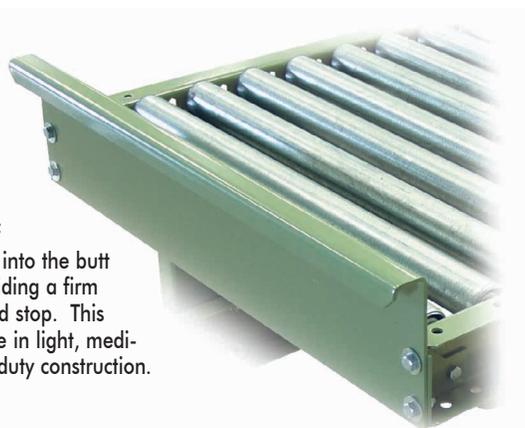
\*Specify 138G, 196G, 192S, 199S, 254S, 251S or 297S.

■ 3 week shipment



**MODEL BR  
ROLLER STOP**

## BUTT END STOPS



Butt end stops attach to end of conveyor frame into the butt couplings, providing a firm end-of-unit fixed stop. This stop is available in light, medium and heavy duty construction.

### SPECIFICATIONS

► **CONSTRUCTION:** 12 ga. for model BSL; 10 ga. for BSM; 7 ga. for BSH.

► **FRAME SIZE:** Model BSL for 2.5" frame height ONLY; model BSM for 3.5", 4" and 4.5"; model BSH for 4" and 5" frame heights.

► **HEIGHT:** Designed to extend 1.5" above top of frame.

### BUTT END STOPS MODEL NUMBER BSH-1.5-4-51

BS (light, medium, heavy or extra heavy duty\*)-(height above frame)-(frame size)-(between frames@)  
\*Specify L for light duty, M for medium duty or H for heavy duty.

@Specify 12", 18" or 24" overall width for model BSL light duty butt end stop.

■ 3 week shipment

► **WIDTHS:** Model BSM and BSH widths include 13", 15", 17", 19", 21", 23", 25", 27", 31", 33", 37", 39", 43", 45", 47" and 51" BF; BSL available in 12", 18" and 24" OAW only.

MISC. ACCESSORIES  
PNEUMATIC BRAKE ASSEMBLY

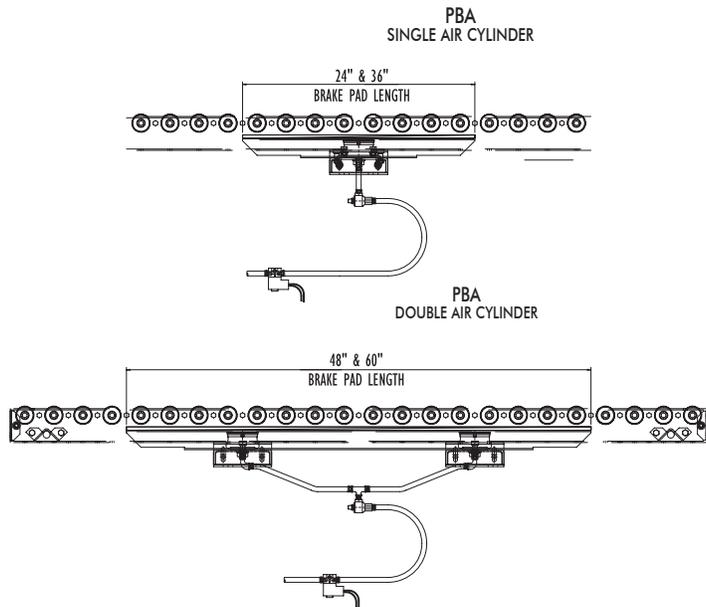


Model PBA pneumatic brake assembly is used to automatically brake rollers for flow control and also for indexing when combined with pneumatic stop. Model above for medium duty applications while model at right designed for heavy duty use. Both shown mounted in optional conveyor.

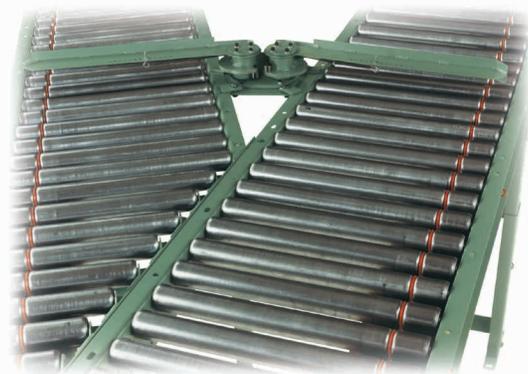
**PNEUMATIC BRAKES MODEL NUMBER  
PBAM-24**  
PBA(medium or heavy duty\*)-(brake length)  
\*Specify M for medium duty or H for heavy duty  
**■ 3 week shipment**

**SPECIFICATIONS**

- ▶ **AIR CYLINDERS:** 1/2" stroke.
- ▶ **SOLENOID VALVE:** Single, 110 volt.
- ▶ **CONSTRUCTION:** 7 ga. formed with 5/16" pad.
- ▶ **LENGTH:** 24", 36" and 48" (specify).
- ▶ **OPTIONAL:** Double solenoid and electrical controls.



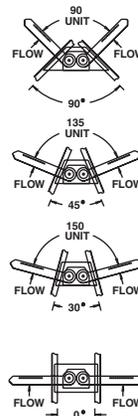
TRAFFIC COP



Traffic cops control merges allowing first carton striking an arm to pass. This action automatically locks the other arm in place until the first carton clears the arm. Model TC shown attached to optional conveyor.

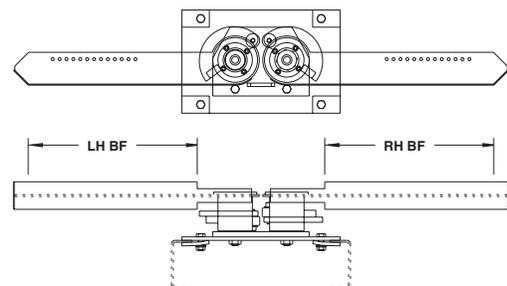
**TRAFFIC COPS MODEL NUMBER  
TC-135-21-21**  
TC-(degree of unit\*)-(left hand between frames)-  
(right hand between frames)  
\*Specify 90°, 135°, 150° or 180°.

■ 3 week shipment



**SPECIFICATIONS**

- ▶ **CONSTRUCTION:** Arms constructed of 10 ga. HRS steel with 14 ga. face, welded for unit durability.
- ▶ **UNIT ARC:** 90°, 135°, 150° and 180° available.
- ▶ **TORQUE:** Minimum 5" - lb.; maximum per arm 2500" - lb.



# GATES

## MANUAL GATES



Manual gate assemblies are one of the most common conveyor accessories. Simple to install, manual gate assemblies offer passage to and from operator work cells as well as providing access for fork trucks, walkways, etc. Gates include hardware and conveyor section.

■ 3 week shipment

MODEL NO.	TYPE OF CONVEYOR	MINIMUM ELEVATION	MINIMUM LENGTH	MAXIMUM LENGTH	MAXIMUM WEIGHT
WSGM	GALV. WHEEL	3-5/8"	6"	5'	75 lbs.
138GGM	138G GALV.	3-3/8"	6"	5'	75 lbs.
196GGM	196G GALV.	4-3/8"	6"	5'	75 lbs.
192SGM	192S STEEL	4-3/8"	6"	5'	75 lbs.
254SGM	254S STEEL	4-11/16"	6"	5'	75 lbs.

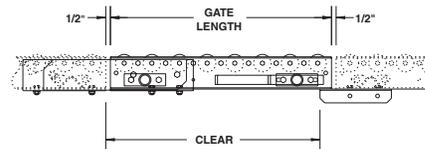
**CAUTION:** Maximum weight of gate section must NOT exceed 75 lbs. If gate weight (i.e. conveyor section) exceeds 75 lbs., use spring loaded gate below.

### MANUAL GATES MODEL NO. (ROLLER) 196GGM-13-6-3

(gate model)-(between frames\*)-(roller centers)-(length)  
\*Specify 12", 18" or 24" overall width on gate models 138GGM and 138AGM.

### MANUAL GATES MODEL NO. (WHEEL) WSGM-18-12-2

(gate model)-(overall width\*)-(wheels per foot)-(length)  
\*Specify 12", 18" or 24" overall width on gate models WSGM and WAGM.



## SPRING LOADED GATES

MODEL NO.	TYPE OF CONVEYOR	MINIMUM ELEVATION	MINIMUM LENGTH	MAXIMUM LENGTH	MAXIMUM WEIGHT
WSGS	GALV. WHEEL	13" TOR	2'-6"	5'	150 lbs.
138GGS	138G GALV.	13" TOR	2'-6"	5'	150 lbs.
196GGS	196G GALV.	13" TOR	2'-6"	5'	150 lbs.
192SGS	192S STEEL	13" TOR	2'-6"	5'	150 lbs.
254SGS	254S STEEL	13" TOR	2'-6"	5'	150 lbs.
251SGS	251S STEEL	13" TOR	2'-6"	5'	150 lbs.

**CAUTION:** If gate weight exceeds 150 lbs., consult factory.

■ 3 week shipment

Spring loaded gate assemblies may be used to provide openings and walkways for operators, pedestrians or fork truck traffic or to simply make work areas in and around conveyors readily accessible. Tensioned springs offer increased lift capacity with minimal effort. Gates include hardware and conveyor section.

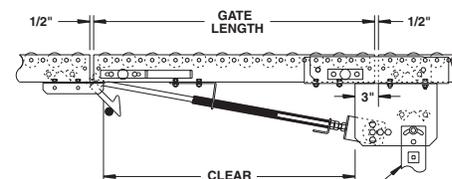


### SPRING LOADED GATES MODEL NO. (ROLLER) 251SGS-31\*-6-2

(gate model)-(between frames\*)-(roller centers)-(length)  
\*Specify 12", 18" or 24" overall width on gate models 138GGS and 138AGS.

### SPRING LOADED GATES MODEL NO. (WHEEL) WSGS-24-20-3

(gate model)-(overall width\*)-(wheels per foot)-(length)  
\*Specify 12", 18" or 24" overall width on gate models WSGS and WAGS.



LOWER ELEVATION SUPPORT REQUIRED AT GATE HINGE SECTION. ADD 4-1/2" TO FRAME DEPTH TO DETERMINE PROPER SUPPORT.

## SUPPORT ACCESSORIES CASTERS

CASTER	CODE/CAPACITY PER PAIR	CASTER	CODE/CAPACITY PER PAIR
4" DIA. RUBBER RIGID	4RR/600 lbs.	4" DIA. RUBBER SWIVEL	4RSB/-
4" DIA. STEEL RIGID	4SR/700 lbs.	6" DIA. RUBBER RIGID	6RR/1120 lbs.
4" DIA. V-GROOVE RIGID	4VR/-	6" DIA. STEEL RIGID	6SR/1150 lbs.
4" DIA. RUBBER SWIVEL	4RS/600 lbs.	6" DIA. RUBBER SWIVEL	6RS/1120 lbs.
4" DIA. STEEL SWIVEL	4SS/700 lbs.	6" DIA. STEEL SWIVEL	6SS/1150 lbs.
4" DIA. V-GROOVE SWIVEL	4VS/-	6" DIA. STEEL SWIVEL W/BRAKE	6SSB/-
FLOORLOCK FOR 4" CASTER	-	FLOORLOCK FOR 6" CASTER	-

■ 2 week shipment

### SPECIFICATIONS

► **CASTERS:** 4" dia. or 6" dia., steel or rubber, swivel or rigid, V-groove casters; floor locks, wheel brakes available. Two casters supplied per support with enlarged mounting plate welded to legs.

► **CAPACITY:** Up to 1150 lb. caster capacity. Consult factory for heavy duty casters.

► **OPTIONAL:** Angle track for V-groove.



### CASTERS FOR LIGHT DUTY CONVEYORS

#### SLC-5-16-4SRBF

SLC-(elevation code)-(between frames\*)-(caster model\*\*)-(floorlock@)

\*Specify 10", 16" or 22" between frames only. Model SLC is suited specifically for wheel conveyors and 138 gravity series.

\*\*See chart for caster model number.  
@Specify F if floorlock required.

### CASTERS FOR MEDIUM DUTY CONVEYORS

#### SMC-4-13-4RSBF

S (medium or heavy duty\*) C-(elevation code)-(between frames)-(caster model\*\*)-(floorlock@)

\*Specify M for medium duty supports and H for heavy duty supports.

\*\*See chart for caster model number.  
@Specify F if floorlock required.

## KNEE BRACE AND ADJUSTABLE SUPPORT BRACKET

MEDIUM DUTY KNEE BRACE MODEL KB CODE NO.	HEAVY DUTY KNEE BRACE MODEL HKB CODE NO.	POLYTIER KNEE BRACE PKB CODE NO.	NOSE-OVER KNEE BRACE MODEL NOKB CODE NO.
2	2	-	6
4	4	4	-
6	6	6	-
8	8	8	-
10	10	10	-
12	12	-	-
-	14	-	-

■ 3 week shipment

### SPECIFICATIONS

► **KNEE BRACE:** Available in 3 styles; Model KB (10 ga.) for SL and SM supports, Model HKB (7 ga.) for SH and SS supports and Model PKB (10 ga.) for polytier supports.

► **C-3 ADJUSTABLE SUPPORT BRACKET:** 10 ga. construction on support Models SL and SM; 7 ga. on Model SH.



KB knee braces add strength to permanent supports and stability in portable applications. C-3 adjustable support bracket allows support to be attached easily to conveyor.



### SPECIFY KNEE BRACE MODEL NUMBER

#### KB-6

(model number\*)-(code number)

\*Specify KB (medium duty for SL or SM supports), HKB (heavy duty for SH or SS supports), PKB (for polytier supports) or NOKB (for mounting on nose-over).

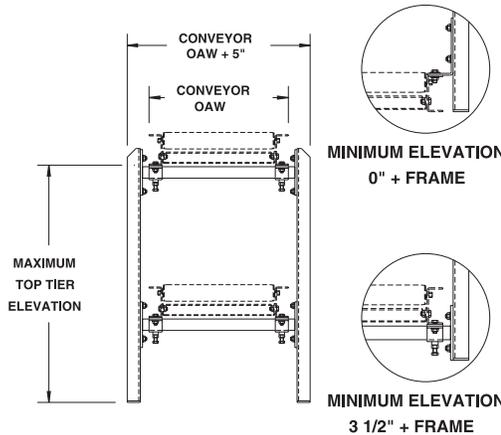
### ADJUSTABLE SUPPORT BRACKET C-3

#### C-3

C-3

## SPECIALTY SUPPORTS POLYTIER SUPPORTS

Polytier supports provide installation for two tiers of conveyor. Additional cross pipes are available for multi-tier (three or more tier) installation.



### POLYTIER SUPPORTS MODEL NUMBER PSM-6-43

PS (light or medium duty\*)-(elevation code)-(between frames\*\*)

\*Specify L for light duty or M for medium duty.

\*\*Specify 12", 18" or 24" OAW for model PSL, available for 12", 18" and 24" OAW conveyors only and is suited specifically for wheel conveyors and 138 gravity series.

### MINIMUM ELEVATION POLYTIER SUPPORTS PSM-6-0-43

PS (light or medium duty\*)-(elevation code)-0-(between frames\*\*)

\*Specify L for light duty or M for medium duty.

\*\*Specify 12", 18" or 24" OAW for model PSL, available for 12", 18" and 24" OAW conveyors only and is suited specifically for wheel conveyors and 138 gravity series.

### SPECIFICATIONS

► **CONSTRUCTION:** Upright legs 7 ga. channel construction; attachment "hat" brackets 7 ga.; cross pipes 1" inside dia.

► **CAPACITY:** 1250 lbs. per cross member. Capacity per set of legs is 2500 lbs (including conveyor and product weight).

**KNEE BRACES:** One pair per set of legs.

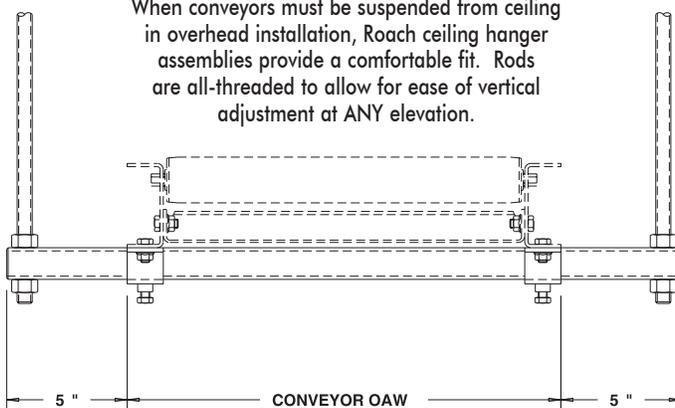
■ 3 week shipment

EL-EVATION CODE	MAX. TOP TIER ELEV.	EL-EVATION CODE	MAX. TOP TIER ELEV.
1	20-1/2"	9	68-1/2"
2	26-1/2"	10	74-1/2"
3	32-1/2"	11	80-1/2"
4	38-1/2"	12	86-1/2"
5	44-1/2"	13	92-1/2"
6	50-1/2"	14	98-1/2"
7	56-1/2"	15	104-1/2"
8	62-1/2"		

WIDTHS: 15", 17", 19", 21", 23", 25", 27", 31", 33", 37", 39", 43", 45", 47" and 51" BF.

## CEILING HANGERS

When conveyors must be suspended from ceiling in overhead installation, Roach ceiling hanger assemblies provide a comfortable fit. Rods are all-threaded to allow for ease of vertical adjustment at ANY elevation.



### CEILING HANGERS MODEL NO. (LIGHT DUTY) CHL-18

CHL-(overall width\*)

\*Specify 12", 18" or 24" overall width ONLY.

### CEILING HANGERS MODEL NO. (MED. DUTY) CHM-21

CHM-(between frames)

NOTE: If attaching to powered conveyor, specify model number for proper allocation of spacer channels, if required. Ceiling hangers are designed for light & medium duty applications (14, 12 and 10 ga. frames). For heavy duty applications, consult factory for pricing & availability.

■ 3 week shipment

### SPECIFICATIONS

► **HANGERS:** (2) 7' long threaded rods (5/8" dia. - 11 UNC) provide nom. 6' product clearance.

► **MOUNTING BRACKETS:** Cross-pipe to span underneath conveyor is painted 1" I.D. steel pipe; Retainer or "Hat" brackets bolt to lower flange of conveyor frame are 7 ga.

► **WIDTHS:** 13", 15", 17", 19", 21", 23", 25", 27", 31", 33", 37", 39", 43", 45", 47" and 51" BF.

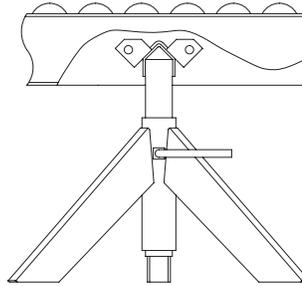
# SUPPORTS

## LIGHT DUTY TRIPOD SUPPORTS



**TRIPOD**  
400 lbs. capacity

Tripod supports are the choice for fast set-up or temporary installations. Easily adjustable, tripods are designed for wheel conveyors and 138 gravity series roller conveyors. Tripods are simply placed underneath conveyor section crossbrace as shown in detail at right.



**SPECIFY MODEL NUMBER FOR**

**TRIPODS**  
**T-18-40**

T-(overall width\*)-(elevation code)  
\*Specify 12", 18" or 24" overall width only.  
Tripods are suited specifically for wheel conveyors and 138 gravity series conveyors ONLY.

**SPECIFICATIONS**

► **CONSTRUCTION:** Top channel of tripod is 1-9/16" x 15/16" x 12 ga. welded to 1" inside diameter pipe. Tripod base is 12 ga. construction.

ELEVATION CODE	HEIGHT ADJUSTMENT MIN. (TOP OF TRIPOD)	HEIGHT ADJUSTMENT MAX. (TOP OF TRIPOD)	12" OAW WT. (lbs.)	18" OAW WT. (lbs.)	24" OAW WT. (lbs.)
18	9-1/4"	15-1/4"	8	9	10
30	15-1/4"	27-1/4"	11	12	13
40	21-1/4"	37-1/4"	13	14	15
52	27-1/4"	49-1/4"	15	16	17
72	37-1/4"	69-1/4"	18	19	20
110	57-1/4"	107-1/4"	25	26	27

■ 3 week shipment

## SINGLE LEG SUPPORTS

EL-EVATION CODE	MODEL SLL/SLM HEIGHT ADJUSTMENT MIN. (TOP OF LEG)	MODEL SLL/SLM HEIGHT ADJUSTMENT MAX. (TOP OF LEG)	MODEL SLH HEIGHT ADJUSTMENT MIN. (TOP OF LEG)	MODEL SLH HEIGHT ADJUSTMENT MAX. (TOP OF LEG)
1	7-1/4"	10-1/4"	6-1/4"	7-3/4"
2	10-1/4"	13-1/4"	7-3/4"	10-3/4"
3	13-1/4"	16-1/4"	10-3/4"	13-3/4"
4	16-1/4"	22-1/4"	13-3/4"	16-3/4"
5	20-1/4"	26-1/4"	16-3/4"	19-3/4"
6	24-1/4"	36-1/4"	19-3/4"	25-3/4"
7	34-1/4"	46-1/4"	25-3/4"	31-3/4"
8	46-1/4"	58-1/4"	31-3/4"	43-3/4"
9	58-1/4"	70-1/4"	43-3/4"	55-3/4"
10	70-1/4"	82-1/4"	55-3/4"	67-3/4"
11	80-1/4"	92-1/4"	67-3/4"	79-3/4"
12	90-1/4"	104-1/4"	79-3/4"	91-3/4"

**SPECIFICATIONS**

► **CONSTRUCTION:** SLL and SLM 12 ga. inside and outside channel assemblies with 10 ga. C-3 pivot plate. SLH 10 ga. inside and outside channel assemblies with 7 ga. C-3 pivot plate.

Single leg supports provide support where full "H-type" permanent supports are not normally required such as 90° curves with continuous side rails or where support cross-brace cannot be used.

**SINGLE LEG SUPPORTS MODEL NUMBER**

**SLM-6**

SL (light, medium or heavy duty)-(elevation code)

■ 3 week shipment



**SUPPORTS**

**MODEL SL LIGHT DUTY PERMANENT SUPPORTS**



**MODEL SL**  
1500 lbs. support capacity

**SPECIFICATIONS**

- **CONSTRUCTION:** 12 ga. inside and outside channel assemblies; C-3 plates are 10 ga.; cross braces are 10 ga. up to 27" BF and 7 ga. 31" BF and above.
- **WIDTHS:** 10", 16" & 22" BF ONLY.

**LIGHT DUTY SUPPORTS MODEL NUMBER SL-6-10**

SL-(elevation code)-(between frames\*)  
\*Specify 10", 16" or 22" between frames which is available for 12", 18" and 24" OAW conveyors ONLY and is suited specifically for wheel conveyors and 138 gravity series.

ELEVATION CODE	HEIGHT ADJUSTMENT MIN. (TOP OF SUPPORT)	HEIGHT ADJUSTMENT MAX. (TOP OF SUPPORT)	10"-22" BF WEIGHT (lbs.)
1	7-1/4"	10-1/4"	11
2	10-1/4"	13-1/4"	13
3	13-1/4"	16-1/4"	15
4	16-1/4"	22-1/4"	17
5	20-1/4"	26-1/4"	22
6	24-1/4"	36-1/4"	24
7	34-1/4"	46-1/4"	28
8	46-1/4"	58-1/4"	35
9	58-1/4"	70-1/4"	39
10	70-1/4"	82-1/4"	43
11	80-1/4"	92-1/4"	47
12	92-1/4"	104-1/4"	51

■ 3 week shipment

**MODEL SM MEDIUM DUTY PERMANENT SUPPORTS**

ELEVATION CODE	HEIGHT ADJUSTMENT MIN. (TOP OF SUPPORT)	HEIGHT ADJUSTMENT MAX. (TOP OF SUPPORT)	7-21" BF WT. (lbs.)	22-27" BG WT. (lbs.)	28-39" BF WT. (lbs.)	40-51" BF WT. (lbs.)
1	7-1/4"	10-1/4"	10	11	15	17
2	10-1/4"	13-1/4"	12	13	16	18
3	13-1/4"	16-1/4"	14	15	18	20
4	16-1/4"	22-1/4"	16	17	20	22
5	20-1/4"	26-1/4"	21	23	30	33
6	24-1/4"	36-1/4"	23	25	32	36
7	34-1/4"	46-1/4"	27	29	36	39
8	46-1/4"	58-1/4"	34	36	47	53
9	58-1/4"	70-1/4"	38	40	52	57
10	70-1/4"	82-1/4"	42	44	56	61
11	80-1/4"	92-1/4"	46	48	60	65
12	92-1/4"	104-1/4"	50	52	64	69

**MEDIUM DUTY SUPPORTS MODEL NO. SM-5-39**

SM-(elevation code\*)-(between frames)  
\*See chart at left

**MINIMUM ELEVATION SUPPORTS MODEL NO. SM0-1-17**

SM0-(elevation code\*)-(between frames)  
\*See chart below.

**SPECIFICATIONS**

- **CONSTRUCTION:** 12 ga. inside and outside channel assemblies; C-3 plates are 10 ga.; cross braces are 10 ga. up to 27" BF and 7 ga. 31" BF and above.
- **WIDTHS:** 7", 13", 15", 17", 19", 21", 23", 25", 27", 31", 33", 37", 39", 43", 45", 47" & 51" BF.

MIN. ELEVATION MEDIUM DUTY ELEVATION CODE	HEIGHT ADJ. RANGE (TOP OF SUPPORT)	UP TO 27" BF WT. (lbs.)	27"-51" BF WT. (lbs.)
1	3-1/2" — 4-1/8"	10	17
2	4-1/8" — 4-3/4"	10	17
3	4-3/4" — 5-3/8"	10	17
4	5-3/8" — 6"	10	17
5	6" — 6-5/8"	10	17
6	6-5/8" — 7-1/4"	10	17

■ 2 week shipment



**MODEL SM**  
1500 lbs. support capacity

## SUPPORTS

### MODEL SH HEAVY DUTY PERMANENT SUPPORTS

ELV. CODE	HEIGHT ADJ. MIN. (TOP OF SUPPORT)	HEIGHT ADJ. MAX. (TOP OF SUPPORT)	7-21" BF WT. (lbs.)	22-27" BF WT. (lbs.)	28-39" BF WT. (lbs.)	40-51" BF WT. (lbs.)
1	6-1/4"	7-3/4"	12	13	17	18
2	7-3/4"	10-3/4"	13	14	18	19
3	10-3/4"	13-3/4"	14	15	19	20
4	13-3/4"	16-3/4"	17	18	21	23
5	16-3/4"	19-3/4"	18	19	22	24
6	19-3/4"	25-3/4"	22	24	31	35
7	25-3/4"	31-3/4"	27	29	37	40
8	31-3/4"	43-3/4"	31	33	40	44
9	43-3/4"	55-3/4"	40	42	53	59
10	55-3/4"	67-3/4"	45	47	58	64
11	67-3/4"	79-3/4"	50	52	64	69
12	79-3/4"	91-3/4"	57	59	70	75

#### HEAVY DUTY SUPPORTS MODEL NO. SH-4-51

SH-(elevation code\*)-(between frames)  
\*See chart at left.

#### MINIMUM ELEVATION SUPPORTS MODEL NO. SH0-5-33

SH0-(elevation code\*)-(between frames)  
\*See chart below left.



**MODEL SH**  
3000 lbs. support capacity

#### SPECIFICATIONS

► **CONSTRUCTION:** 10 ga. inside and outside channel assemblies; C-3 plates are 7 ga.; cross braces are 10 ga. up to 27" BF and 7 ga. 31" BF and above.

► **WIDTHS:** 7", 9", 13", 15", 17", 19", 21", 23", 25", 27", 31", 33", 37", 39", 43", 45", 47", 51" BF only; 54", 57" and 63" BF.

#### MODEL SHO HEAVY DUTY

ELEVATION CODE	HEIGHT ADJ. RANGE (TOP OF SUPPORT)	UP TO 27" BF WT. (lbs.)	28"-51" BF WT. (lbs.)
1	3-1/2" — 4-1/8"	13	18
2	4-1/8" — 4-3/4"	13	18
3	4-3/4" — 5-3/8"	13	18
4	5-3/8" — 6"	13	18
5	6" — 6-5/8"	13	18

■ 3 week shipment

### HEAVY DUTY STRUCTURAL SUPPORTS



**MODEL SS**  
6000 lbs. support capacity



**MODEL SS3530**  
12000 lbs. support capacity

#### STRUCTURAL SUPPORTS MODEL NUMBER SS-4-31

SS-(elevation code)-(between frames)

#### 3530 STRUCTURAL SUPPORTS MODEL NO. SS3530-6-45

SS3530-(elevation code)-(between frames)

MODEL SS ELEV. CODE	HT. ADJ. RANGE (TOP OF SUPPORT)	7"-23" BF WT. (lbs.)	24"-51" BF WT. (lbs.)	52"-63" BF WT. (lbs.)	MODEL SS ELEV. CODE	HT. ADJ. RANGE (TOP OF SUPPORT)	7"-23" BF WT. (lbs.)	24"-51" BF WT. (lbs.)	52"-63" BF WT. (lbs.)	MODEL SS3530* ELEV. CODE	HT. ADJ. RANGE (TOP OF SUPPORT)
1	7-1/4" — 10-1/4"	26	39	44	13	99-1/2" — 114-1/2"	154	191	207	1	8-3/8" — 10-5/8"
2	10-1/4" — 13-1/4"	31	44	50	14	102-1/2" — 117-1/2"	160	198	214	2	10-3/8" — 13-1/8"
3	13-1/4" — 16-1/4"	35	47	53	15	105-1/2" — 120-1/2"	163	201	217	3	12-7/8" — 18-1/8"
4	16-1/4" — 22-1/4"	40	53	59	16	108-1/2" — 126-1/2"	166	204	220	4	17-7/8" — 23-3/8"
5	20-1/4" — 26-1/4"	45	58	64	17	112-1/2" — 130-1/2"	170	208	224	5	23-1/8" — 28-5/8"
6	24-1/4" — 36-1/4"	56	69	75	18	116-1/2" — 140-1/2"	180	218	234	6	28-3/8" — 33-7/8"
7	34-1/4" — 46-1/4"	83	108	119	19	126-1/2" — 150-1/2"	189	227	243	7	33-5/8" — 39-1/8"
8	46-1/4" — 58-1/4"	92	117	128	20	138-1/2" — 162-1/2"	200	238	254	8	38-7/8" — 44-3/8"
9	58-1/4" — 70-1/4"	105	130	141	21	150-1/2" — 174-1/2"	211	249	265	-	-
10	70-1/4" — 82-1/4"	116	141	152	22	162-1/2" — 186-1/2"	222	260	276	-	-
11	80-1/4" — 92-1/4"	136	174	191	23	172-1/2" — 196-1/2"	231	269	285	-	-
12	92-1/4" — 104-1/4"	147	185	202	24	184-1/2" — 208-1/2"	241	279	295	-	-

\*Model SS3530 adjustable in 1/4" increments ONLY.

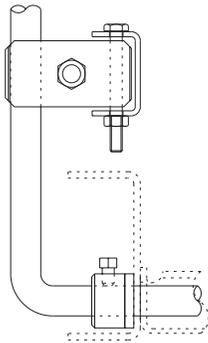
#### SPECIFICATIONS

► **BF'S:** 7", 9", 11", 13", 15", 17", 19", 21", 23", 25", 27", 31", 33", 35", 37", 39", 43", 45", 47", 51" BF only; 54", 57" & 63" BF.

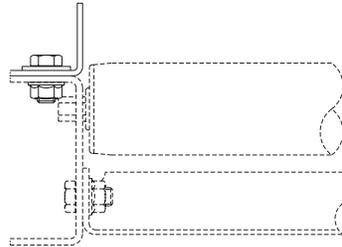
■ 2 week shipment

# GUARD RAILS

**MODEL GC**

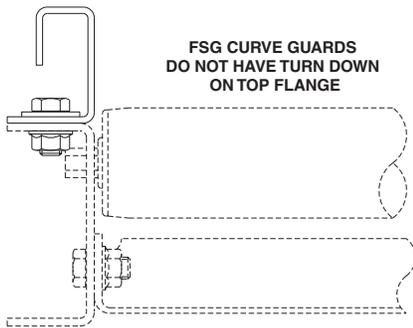


**MODEL GA1.5  
MODEL HGA1.5**

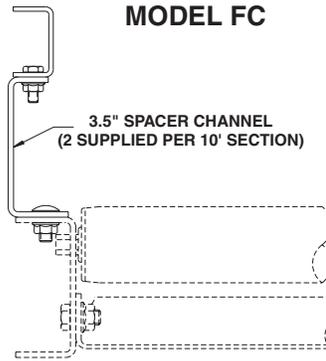


**ALWAYS SPECIFY CONVEYOR MODEL NUMBER AND FLANGE WIDTH GUARD RAILS WILL MOUNT ON**

**MODEL FSG**



**MODEL FC**



## SPECIFICATIONS

► **CONSTRUCTION:** All medium duty rails are 12 ga. HRS steel; heavy duty rails are 7 ga. HRS steel; all are powder painted EXCEPT guard rails for light duty conveyors normally supplied with galv. or alum. frames which are galv.; with mounting holes.

► **GUARD RAILS:** Available in several styles; model GC, adjustable channel guards; model FC, fixed channel guards; model GA1.5, angle guards (1.5" high); model HGA1.5, heavy duty angle guards (1.5" high); model FSG, formed steel guards (7 heights from 2" to 24" high). Specify both sides or outside only when ordering AND conveyor model number to ensure receipt of proper guard rails & mounting hardware which is supplied as required.

GUARD RAIL MODEL NO.	WT./FT. (lbs.) BOTH SIDES
GC	3.9
FC	3.5
GA1.5	2.3
FSG-2	4.2
FSG-4	5.7
FSG-6	7.2
HGA1.5	4.0

**MODEL GC GUARD RAILS MODEL NO. GC-90-15**

GC-(degree or length)-(between frames)

**GA1.5 GUARD RAILS MODEL NO. (STRAIGHT)**

**GA-1.5-1.5-60**

(model\*)-(guard height)-(bottom flange\*\*)-(length)

\*Specify GA or HGA for heavy duty guard rails.

\*\*Specify .75", 1" or 1.5".

**GA1.5 GUARD RAILS MODEL NO. (CURVE)**

**GGA1.51.59032.513**

(GGA1.5 or PGA1.5\*) (bottom flange\*\*) (degree#)

(radius##) (assembly code@)

\*Specify GGA1.5 for galv. or alum. frames; PGA1.5 for painted.

\*\*Specify .75", 1" or 1.5".

#Specify 30°, 45°, 60° or 90°.

##Specify applicable inside radius or outside radius.

@Specify N for inside guard only, U for outside guard only or between frames width for guards on both sides.

**FSG GUARD RAILS MODEL NO. (STRAIGHT)**

**FSG-4-C-36**

FSG-(guard height\*)-(bottom flange\*\*)-(length)

\*Specify 2, 4 or 6.

\*\*Specify .75" or 1.5".

**FSG GUARD RAILS MODEL NO. (CURVE)**

**GFGSG2-1.59032.5U**

(model\*) (guard height\*\*)-(bottom flange#) (degree##)

(radius@) (assembly code@@)

\*Specify GFGSG for galv.-to be used only on models supplied w/ galv. or alum. frames; or PFGSG for painted.

\*\*Specify 2, 4, 6, 8, 12, 18 or 24

#Specify .75", 1" or 1.5".

##Specify 30°, 45°, 60° or 90°.

@Specify applicable inside radius or outside radius.

@@Specify N for inside guard only, U for outside guard only or between frames width for guards on both sides.

**MODEL FC GUARD RAILS MODEL NO. FC-60-39**

FC-(degree or length)-(between frames)

■ 3 week shipment

ROLLERS

ROLLERS FOR GRAVITY AND POWER APPLICATIONS

ROLLER #	OUTSIDE DIA.	WALL	MATERIAL	SHAFT DIA.	SHAFT RETENTION	BEARING #	BEARING MT.	MAX. LOAD	GRAVITY MODEL.	POWER/ MAX. SPEED
108G	1"	18 GA.	Galvanized	1/4" Round	Springloaded	BRW04710	Press In	35 lbs.	YES	-
138G	1-3/8"	18 GA.	Galvanized	1/4" Round	Springloaded	BRW04515	Swaged	50 lbs.	YES	-
138G	1-3/8"	18 GA.	Galvanized	5/16" Hex	Springloaded	BRW04520-01	Swaged	50 lbs.	-	120FPM
138T	1.9" — 1-3/8"	16 GA.	Steel	5/16" Hex	Springloaded	BRW04531-02/04519	Press In/ Swaged	100 lbs.	YES	120FPM
196G	1.9"	16 GA.	Galvanized	7/16" Hex	Springloaded	BRW04530	Swaged	260 lbs.	YES	120FPM
192S	1.9"	12 GA.	Steel	7/16" Hex	Springloaded	BRW04535	Swaged	260 lbs.	YES	120FPM
192S	1.9"	12 GA.	Steel	7/16" Hex	Springloaded	BRW04586	Press In	300 lbs.	-	150FPM
199S	1.9"	9 GA.	Steel	7/16" Hex	Springloaded	BRW04535	Swaged	260 lbs.	YES	150FPM
254S	2.5"	14 GA.	Steel	7/16" Hex	Springloaded	BRW04575	Press In	290 lbs.	YES	150FPM
254T	2.5" — 1-11/16"	14 GA.	Steel	7/16" Hex	Springloaded	BRW04575	Press In	290 lbs.	YES	120FPM
251S	2.5"	11 GA.	Steel	11/16" Hex	Springloaded	BRW04564	Crimped	540 lbs.	YES	-
251S	2.5"	11 GA.	Steel	11/16" Hex	Springloaded	BRW04565	Crimped	540 lbs.	-	150FPM
297S	2-9/16"	7 GA.	Steel	11/16" Hex	Springloaded	BRW04564	Crimped	540 lbs.	YES	-
297S	2-9/16"	7 GA.	Steel	11/16" Hex	Springloaded	BRW04565	Crimped	540 lbs.	-	150FPM
3509S	3.5"	9 GA.	Steel	11/16" Hex	Springloaded	BRW04578	Crimped	700 lbs.	YES	-
3530S	3.5"	.300	Steel	1-1/16" Hex	Pinned	BRW04737	Press In	2500 lbs.	YES	-

\*ALL LOADS ARE RATED AT 60 SFM (SURFACE FEET PER MINUTE) AND ARE BASED ON MINIMUM STANDARD BF WIDTH. \*\*For higher speeds, consult factory.

LIGHT DUTY ROLLERS

MEDIUM DUTY ROLLERS

HEAVY DUTY ROLLERS

MODEL 108G w/ BRW04710



MODEL 138G w/ BRW04515



MODEL 138G w/ BRW04520



MODEL 138T w/ BRW04531-02 AND BRW04519 (SMALL END)



MODEL 196G w/ BRW04530



MODEL 192S w/ BRW04535



MODEL 199S w/ BRW04535



MODEL 254S w/ BRW04575



MODEL 254T w/ BRW04575



MODEL 251S w/ BRW04547



MODEL 297S w/ BRW04547



MODEL 3509S w/ BRW04588



MODEL 3530S w/ BRW04737



■ 2 week shipment

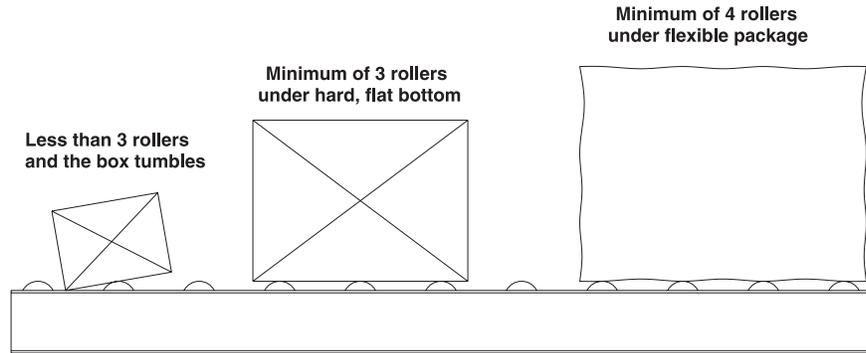
ROLLER MODEL	BEARING MODEL	7" BF WT. (lbs.)	9" BF WT. (lbs.)	11" BF WT. (lbs.)	13" BF WT. (lbs.)	15" BF WT. (lbs.)	17" BF WT. (lbs.)	19" BF WT. (lbs.)	21" BF WT. (lbs.)	23" BF WT. (lbs.)	25" BF WT. (lbs.)	27" BF WT. (lbs.)	31" BF WT. (lbs.)	33" BF WT. (lbs.)	35" BF WT. (lbs.)	37" BF WT. (lbs.)	39" BF WT. (lbs.)	43" BF WT. (lbs.)	45" BF WT. (lbs.)	47" BF WT. (lbs.)	51" BF WT. (lbs.)
196G	BRW04530	1.6	1.9	2.3	2.6	2.8	3.0	3.4	3.7	3.9	4.3	4.6	5.1	5.4	5.7	6.0	6.3	7.0	7.3	7.6	8.1
192S	BRW04535	2.3	2.8	3.4	3.8	4.5	5.2	5.6	6.0	6.6	7.2	7.7	8.8	9.4	9.9	10.6	11.0	12.1	12.7	13.2	14.3
199S	BRW04586	2.6	3.3	4.0	4.5	5.3	6.1	6.6	7.1	7.8	8.5	9.2	10.5	11.2	11.8	12.6	13.1	14.5	15.2	15.8	17.1
254S	BRW04575	2.1	2.5	3.0	3.4	3.9	4.4	4.8	5.2	5.7	6.2	6.6	7.5	8.4	9.3	9.8	10.2	11.3	11.8	12.3	13.3
254T	BRW04575	2.0	2.4	2.8	3.2	3.7	4.1	4.5	4.9	5.4	5.8	6.2	7.0	7.5	7.9	8.3	8.7	9.6	10.0	10.4	11.3
251S	BRW04564	4.2	4.9	5.6	6.4	7.1	7.8	8.5	9.2	9.9	10.7	11.4	12.8	13.5	14.3	15.0	15.7	17.1	17.9	18.6	20.0
297S	BRW04565	4.6	5.6	6.7	7.6	8.7	9.8	10.8	11.8	12.3	13.8	15.3	16.9	17.9	19.0	20.0	21.0	23.0	24.1	25.1	27.2
3509S	BRW04578	6.5	7.7	8.8	9.9	11.0	12.1	13.3	14.4	15.6	16.7	17.8	20.1	21.2	22.3	23.5	24.6	26.9	28.0	29.1	31.4
3530S	BRW04737	11.2	13.5	15.9	18.3	20.6	23.0	25.3	27.6	30.0	32.3	34.7	39.4	41.8	44.1	46.4	48.8	53.5	55.9	58.2	62.8

ROLLER MODEL	BEARING MODEL	10" BF WTS. (lbs.)	16" BF WTS. (lbs.)	22" BF WT. (lbs.)
138G	BRW04515	1.0	1.5	2.0

# GRAVITY SPACING

## ROLLER CENTER SPACING

In order to convey your product smoothly and efficiently, it must be supported by a minimum of three rollers. To compute the center to center roller spacing required, divide the length of your package by 3. The dividend is your required spacing. For example, a package 24" long, divided by 3, yields a dividend of 8. Therefore, the required spacing would be 8" center to center. Flexible bottom packages require four or more supporting rollers per package.



## GRADE SUGGESTIONS - DROP PER 10'-0" SECTION

COMMODITY	WT. (lbs.)	PLAIN OR DUST PROOF BEARINGS	GREASE PACKED BEARINGS	COMMODITY	WT. (lbs.)	PLAIN OR DUST PROOF BEARINGS	GREASE PACKED BEARINGS
CARTONS	1-5	9"	-	WOOD CASES	20-50	5"	7-1/2"
	5-15	7-1/2"	-		50-100	4-1/2"	6-1/2"
	15-50	6"	9"		100-250	4"	5"
CRATES	20-50	5"	7-1/2"	TOTE PANS	50-100	4"	6-1/2"
	5-100	4-1/2"	6-1/2"		100-250	3-1/2"	5"
	100-250	4"	5"		250-500	3"	4-1/2"
MILK CASES	EMPTY	6"	10"	BARRELS	EMPTY	5"	6-1/2"
	FULL	5"	6"		FULL	4"	5"
BEVERAGE CASES	EMPTY	6"	-	MILK CANS	EMPTY	6"	10"
	FULL	5"	7-1/2"		FULL	4-1/2"	6"
LUMBER	STD. BOARD	5"	7-1/2"	BRICK	-	5"	6-1/2'

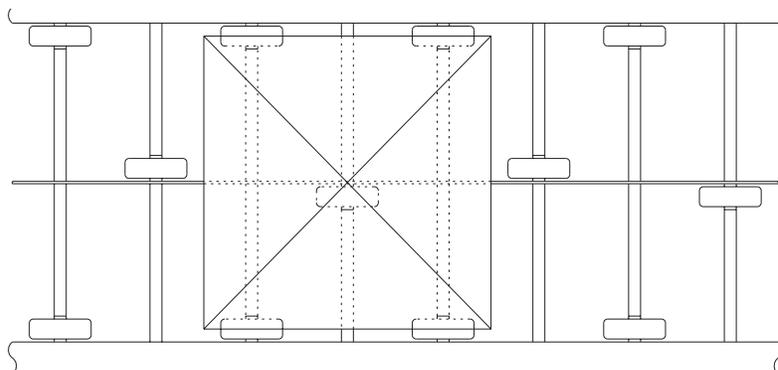
Grades recommended here are not exact and should be used only to estimate your requirements. Figures at left are intended for average conditions, using proper size rollers for materials handled. Additional grade may be required in some cases.

Starting a package from rest on level lines requires a push of approximately 3% of the total load. For heavy loads a pitch of 1/8" per foot will reduce push required.

The amount of drop required for 90° curves with 4' inside radius is approximately the same as required per 10' section.

## WHEEL SPACING

Products to be conveyed on wheel conveyor should have a smooth and firm bottom to maximize conveyability. It is important to note that wheel conveyor should have a minimum of 5 wheels under smallest box size and a minimum of 3 axles under it at all times.



# LINE SHAFT HORSEPOWER DATA

## GENERAL

Since many sections and accessories may be coupled to one drive, it is important that the motor be properly sized for each application.

Table I (at right) may be used as a general guide to selection of drive motor sizes for typical installations.

When powered accessories are added to straight sections, the maximum allowable length must be adjusted. Table II (below) lists the horsepower required for the various accessories.

Factors that are important to power requirements include the number of rollers per foot, the total length of straight sections, the number and type of powered accessories and the desired speed of the conveyor.

TABLE I - MAXIMUM ALLOWABLE STRAIGHT LENGTHS							
HORSE-POWER	ROLLER CENTERS	30FPM	45FPM	60FPM	75FPM	90FPM	120FPM
1/3	3"	57	37	28	22	19	14
1/3	4"	75	50	37	30	25	19
1/3	6"	112	75	56	45	37	28
1/2	3"	84	56	42	34	28	20
1/2	4"	112	75	56	45	38	28
1/2	6"	168	112	84	67	56	42
3/4	3"	126	84	63	50	42	32
3/4	4"	168	112	84	67	56	42
3/4	6"	200	168	126	100	84	63
1	3"	-	112	84	67	56	42
1	4"	-	150	112	90	75	56
1	6"	-	200	168	135	112	84
1-1/2	3"	-	-	126	100	84	63
1-1/2	4"	-	-	168	135	112	84
1-1/2	6"	-	-	200	200	168	126
2	3"	-	-	-	135	112	84
2	4"	-	-	-	180	150	112
2	6"	-	-	-	200	200	168

NOTE: Drive cannot be located more than 75' from either end on 3" RC; 90' from either end on 4" RC; or 100' from either end on 6" RC.

## 796LS CAPACITY

The drive capacity accepted is 15 lbs. per roller. The type of package and/or material being conveyed may increase or decrease this capacity. Very hard, rigid, flat bottom containers increase roller capacity while soft, uneven surfaces will decrease it.

NOTE: Drive capacity for model 738LS is 10 lbs. per roller; 7.5 lbs. roller capacity for model 738LSC.

## ROLLER CENTERS

The number of rollers required per package is dependent upon package weight, package length, drive capacity per roller, and type of surface. The package formulas (at right) should be used to determine the maximum allowable roller centers. Use the lesser of the two values rounded to the nearest standard roller centers. Finally, only use model 738LS for light duty applications where close roller centers are required.

### PACKAGE WEIGHT FORMULA

- + Length of package (in inches)
- ÷ Weight of package
- = Subtotal
- × 15 # (Drive capacity of rollers; use 10 # for 738LS)
- = Maximum Roller Centers

### PACKAGE LENGTH FORMULA

- + Length of package (in inches)
- ÷ 3
- = Maximum Roller Centers

TABLE II - HP REQUIREMENT FOR ACCESSORIES						
POWERED ACCESORIES	30FPM	45FPM	60FPM	75FPM	90FPM	120FPM
30° CURVE	.03	.05	.06	.07	.09	.12
45° CURVE	.04	.07	.09	.11	.13	.17
60° CURVE	.06	.09	.12	.15	.18	.24
90° CURVE	.08	.12	.15	.19	.23	.30
Converging Spur	.13	.18	.26	.34	.40	.52
Diverging Spur	.16	.23	.32	.39	.46	.63
Powered Gate	.04	.05	.07	.09	.11	.15
Chain Cross Over	.02	.02	.02	.03	.04	.05

NOTE: When accessories are added to straight line shaft conveyor sections, the maximum allowable lengths shown in Table I must be adjusted. Use the adjustment formula at right to determine the adjusted maximum length.

### LINE SHAFT ADJUSTMENT FORMULA

- Maximum HP (Table I)
- Total HP of accessories (Table II)
- = Subtotal
- ÷ Maximum HP (Table I)
- × Max. allowable straight length (Table I)
- = Adjusted straight Length

# CALCULATING HORSEPOWER

## FORMULAS

### BELT CONVEYORS & BELT DRIVEN LIVE ROLLERS

- + Product (Total Live Load)\*
- + Belt Weight\*\*
- + Roller Weight (N/A on Slider Bed Belt Conv.)\*\*
- + Drive Weight (250#)
- = Subtotal
- x Friction Factor (See Chart This Page)
- x 1.25 (25% Contingency Factor)
- = Effective Belt Pull
- x Speed of Conveyor
- ÷ 33,000 Horsepower Factor
- ÷ .95 Chain Reductions
- ÷ .85 GRE / Reducer Losses
- = Horsepower

### BELT CONVEYORS (INCLINE OR DECLINE)

- + Product (Total Live Load)
- + Belt Weight\*\*
- + Roller Weight (N/A on Slider Bed Belt Conv.)\*\*
- + Drive Weight (250#)
- = Subtotal
- x Friction Factor (See Chart This Page)
- = Subtotal
- + (Actual Live Load on Incline--See Chart This Page) x Sine of Incline--See Chart This Page)
- = Subtotal
- x 1.25 (25% Contingency Factor)
- = Effective Belt Pull
- x Speed of Conveyor
- ÷ 33,000 Horsepower Factor
- ÷ .95 Chain Reductions
- ÷ .85 GRE / Reducer Losses
- = Horsepower

\*On zero pressure accumulators, only 1/2 of total live load should be used since only 1/2 of load should be in motion at any given time with conveyor design (does NOT apply to Smart Zone® models).

\*\*See weight charts opposite page.

@See slat and chain weight chart opposite page (slat and chain weight applies only to slat conveyor).

When calculating horsepower, use charts at right to determine proper shaft and pulley diameter. This will ensure that the pulley and shaft selected will be of the proper size (diameter) to adequately handle the loading and effective belt pull on the unit.

In Table I, use the 180° arc of contact for end drives and 210° for center

### CHAIN DRIVEN LIVE ROLLERS

- + Product (Total Live Load)\*
- + Roller Weight\*\*
- + Sprocket and Chain Weight (add 3 lbs./roller)\*\*
- + Drive Weight (250#)
- = Subtotal
- x Friction Factor (See Chart This Page)
- x 1.25 (25% Contingency Factor)
- = Effective Chain Pull
- x Speed of Conveyor
- ÷ 33,000 Horsepower Factor
- ÷ .95 Chain Reductions
- ÷ .85 GRE / Reducer Losses
- = Horsepower

### SLAT AND CHAIN DRAG CONVEYORS

- + Product (Total Live Load)\*
- + Slat and Chain Weight@
- + Drive Weight (100#)
- = Subtotal
- x Friction Factor (See Chart This Page)
- x 1.25 (25% Contingency Factor)
- = Effective Chain Pull
- x Speed of Conveyor
- ÷ 33,000 Horsepower Factor
- ÷ .95 Chain Reductions
- ÷ .85 GRE / Reducer Losses
- = Horsepower

FRICTION FACTOR	
MODEL	FRICTION FACTOR
Slider Bed Belt Conveyor	.30
Roller Bed Belt Conveyor	.05
Belt Driven Live Roller	.10
Chain Driven Live Roller	.06
Slat Conveyor	.20
Chain Drag Conveyor	.20

SINES	
DEGREE	SINE
5°	.08715
10°	.17365
11°	.19081
12°	.20791
13°	.22495
14°	.24192
15°	.25882
16°	.27364
17°	.29237
18°	.30902
19°	.32557
20°	.34202
21°	.35837
22°	.37461
23°	.39073
24°	.40674
25°	.42262
26°	.43837
27°	.45399
28°	.46947
29°	.48481
30°	.50000
35°	.57358
40°	.64279

Pulley Face Width	Shaft Dia. 1-3/16"	Shaft Dia. 1-7/16"	Shaft Dia. 1-15/16"	Shaft Dia. 2-7/16"	Shaft Dia. 2-15/16"
12"	1000	1500	3700	6300	10600
14"	920	1500	3700	6300	10600
18"	670	1200	3700	6300	10600
20"	590	1100	3500	6300	10600
22"	530	950	3100	6300	10600
26"	440	790	2600	5600	10600
32"	350	620	2100	4400	9100
38"	290	510	1700	3700	7500
44"	240	440	1400	3100	6400
51"	210	370	1200	2700	5500
57"	180	330	1100	2400	4900

drives. Multiply the figure shown by the belt width to find the effective belt pull of a pulley.

Once the proper pulley diameter is known, the diameter of the shaft must be determined. Table II specifies effective belt pull ratings for various diameter shafts at selected pulley face width.

Pulley Dia.	180° End Drive	210° Center Drive
8"	85# PIW BELT	60# PIW BELT
12"	125# PIW BELT	90# PIW BELT
18"	230# PIW BELT	170# BELT
24"	345# PIW BELT	250# PIW BELT

# ROLLER LOAD CAPACITY

ROLLER-MODEL	7"BF WTS. (lbs.)	9"BF WTS. (lbs.)	11"BF WTS. (lbs.)	13"BF WTS. (lbs.)	15"BF WTS. (lbs.)	17"BF WTS. (lbs.)	19"BF WTS. (lbs.)	21"BF WTS. (lbs.)	23"BF WTS. (lbs.)	25"BF WTS. (lbs.)	27"BF WTS. (lbs.)	31"BF WTS. (lbs.)	33"BF WTS. (lbs.)	35"BF WTS. (lbs.)	37"BF WTS. (lbs.)	39"BF WTS. (lbs.)	43"BF WTS. (lbs.)	45"BF WTS. (lbs.)	47"BF WTS. (lbs.)	51"BF WTS. (lbs.)
196S	1.6	1.9	2.2	2.5	2.7	2.9	3.3	3.6	3.8	4.1	4.4	4.9	5.2	5.5	5.8	6.1	6.7	7.0	7.3	7.8
196G	1.6	1.9	2.3	2.6	2.8	3.0	3.4	3.7	3.9	4.3	4.6	5.1	5.4	5.7	6.0	6.3	7.0	7.3	7.6	8.1
192S	2.3	2.8	3.4	3.8	4.5	5.2	5.6	6.0	6.6	7.2	7.7	8.8	9.4	9.9	10.65	11.0	12.1	12.7	13.2	14.3
199S	2.6	3.3	4.0	4.5	5.3	6.1	6.6	7.1	7.8	8.5	9.2	10.5	11.2	11.8	12.6	13.1	14.5	15.2	15.8	17.1
254S	2.1	2.5	3.0	3.4	3.9	4.4	4.8	5.2	5.8	6.2	6.6	7.5	8.4	9.3	9.8	10.2	11.3	11.8	12.3	13.3
254T	2.0	2.4	2.8	3.2	3.7	4.1	4.5	4.9	5.4	5.8	6.2	7.0	7.5	7.9	8.3	8.7	9.6	10.0	10.4	11.3
251S	4.2	4.9	5.6	6.4	7.1	7.8	8.5	9.2	9.9	10.7	11.4	12.8	13.5	14.3	15.0	15.7	17.1	17.9	18.6	20.0
297S	4.6	5.6	6.7	7.6	8.7	9.8	10.8	11.8	12.3	13.8	15.3	16.9	17.9	19.0	20.0	21.0	23.0	24.1	25.1	27.2
3509S	6.5	7.7	8.8	9.9	11.0	12.1	13.3	14.4	15.6	16.7	17.8	20.1	21.2	22.3	23.5	24.6	26.9	28.0	29.1	31.4
3530S	11.2	13.5	15.9	18.3	20.6	23.0	25.3	27.6	30.0	32.3	34.7	39.4	41.8	44.1	46.4	48.8	53.5	55.9	58.2	62.8

LIGHT DUTY ROLLER WEIGHTS			
ROLLER MODEL	10" BF WTS. (lbs.)	16" BF WTS. (lbs.)	22" BF WTS. (lbs.)
138G	1.0	1.5	2.0

SLAT & CHAIN WEIGHTS PER FT. OF CONVEYOR					
SLAT WIDTH	25" WT. (lbs.)	31" WT. (lbs.)	37" WT. (lbs.)	43" WT. (lbs.)	49" WT. (lbs.)
7 GA HRS	71	82	96	104	115

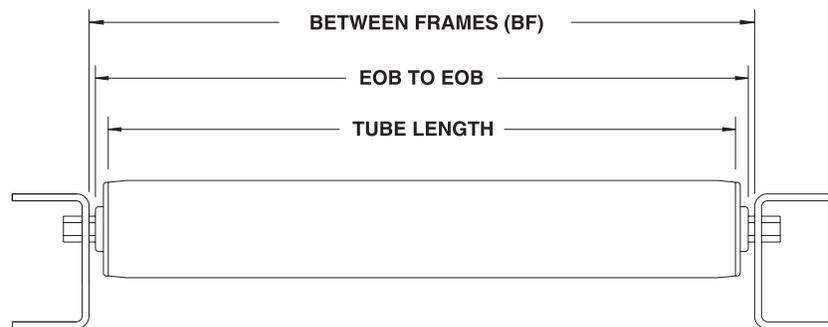
CHAIN WEIGHTS (lbs.) PER FT. OF CONVEYOR			
CHAIN SIZE	CONVEYOR SPEED	CHAIN WT./FT.	LOAD RATING
NO. 40	25 FPM	.41	443
NO. 40	50 FPM	.41	432
NO. 50	25 FPM	.68	690
NO. 50	50 FPM	.68	675
NO. 60	25 FPM	.96	995
NO. 60	50 FPM	.96	970
NO. 80	25 FPM	1.7	1770
NO. 80	50 FPM	1.7	1730
NO. 100	25 FPM	2.7	2760
NO. 100	50 FPM	2.7	2690

BELTING WEIGHTS										
BELTING TYPE	BELTING SURFACE	2-1/4" BELT WIDTH	6" BELT WIDTH	12" BELT WIDTH	18" BELT WIDTH	24" BELT WIDTH	30" BELT WIDTH	36" BELT WIDTH	42" BELT WIDTH	48" BELT WIDTH
PVC-120	C x FS	-	.51	1.02	1.53	2.04	2.55	3.06	3.57	4.08
PVC-120	FS x FS	-	.24	.48	.72	.96	1.20	1.44	1.68	1.92
PVC	RUFF-TOP	-	.45	.90	1.35	1.80	2.25	2.70	3.15	3.60
PVC-150	C x FS	.241	-	-	-	-	-	-	-	-

## ROLLER LENGTH

### DETERMINING ROLLER LENGTH

The best method for ordering additional or replacement rollers is to always specify the between frames dimension (BF). This will ensure a proper fit for rollers and conveyor frames. If the end-user does not know what the BF dimension is, simply have this person measure between the frames of the specified unit. However, there are times when getting a between frames dimension is difficult. In this instance, it is very important to use the proper terminology to select a roller size. The only dimension acceptable in determining roller length when the BF is not known, is the "end-of-bearing" measurement. The importance here cannot be overstated. Since conveyor/roller man-



ufacturers vary the length of the roller tube in relation to the manner in which the bearing is inserted--and depending on the individual bearing being used--countless dimensions are possible. For example, one manufacturer may use an 18-1/2" long tube in production of its 19" BF roller. Another may be using a different

bearing or possibly a different method of installing the bearing and cut its tube to a length of 18-1/4". This 1/4" difference is enough--believe it or not--to be the culprit of serious problems--at exactly the time the end-user receives a shipment of non-returnable rollers the wrong length! See illustration above.

# CURVES AND SPURS

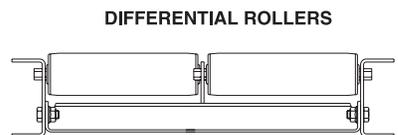
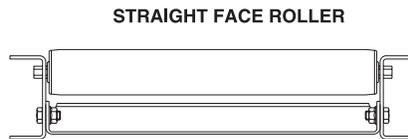
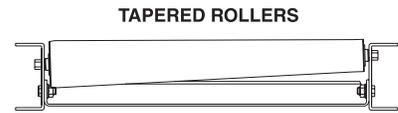
## GENERAL

► **STRAIGHT FACE ROLLERS** are recommended where packages of uniform size are conveyed and rubbing against guards is not objectionable.

► **DIFFERENTIAL ROLLERS** offer reduced package swerve. Package travels more easily. Guard rails should be used.

► **TAPERED ROLLERS** are recommended above all others because of their improved carrying surface. They hold the package in relatively the same position through the entire curve.

**NOTE:** Orientation of product may be affected because of straight rollers in curve. If orientation of product must be maintained, a tapered roller curve should be used. Consult factory.



PACKAGE LENGTH	PACKAGE WIDTH 4"	PACKAGE WIDTH 8"	PACKAGE WIDTH 12"	PACKAGE WIDTH 16"	PACKAGE WIDTH 20"	PACKAGE WIDTH 24"	PACKAGE WIDTH 28"	PACKAGE WIDTH 32"	PACKAGE WIDTH 36"
4"	6	10	14	18	22	26	30	34	38
8"	6	10	14	18	22	26	30	34	38
12"	7	10	14	18	22	26	30	34	38
16"	8	11	15	19	22	26	30	34	38
20"	9	12	15	19	23	27	30	34	38
24"	10	12	16	20	23	27	31	34	38
28"	11	13	17	20	24	28	31	35	39
32"	-	14	18	21	25	29	31	35	39
36"	-	-	-	-	-	-	32	36	40
40"	-	-	-	-	-	-	32	36	40
44"	-	-	-	-	-	-	33	37	41
48"	-	-	-	-	-	-	33	37	41
52"	-	-	-	-	-	-	34	38	42

To determine width needed, use formula shown below, or convenient table at left.

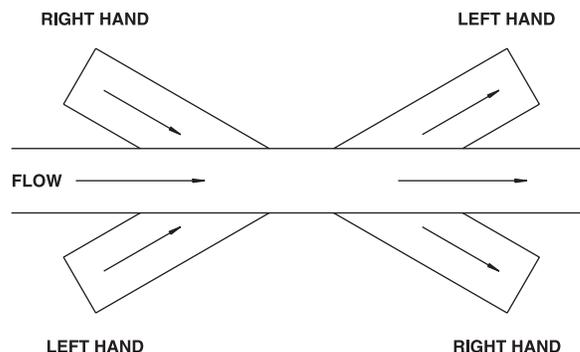
**CURVE WIDTH FORMULA**

$$\begin{aligned}
 &+ (\text{Inside Radius} + \text{Package Width})^2 \\
 &+ (\text{Package Length} \div 2)^2 \\
 &= \text{Subtotal} \\
 &\sqrt{\text{Subtotal}} \\
 &- \text{Inside Radius} \\
 &+ 2" \\
 &= \text{Width in Curve (BF)}
 \end{aligned}$$

**NOTE:** Length of package must not exceed length of inside radius.

## DETERMINING HAND OF SPUR

When placing an order for any spur, hand of spur must be determined and specified. The drawing at right illustrates both left hand and right hand spurs. It is acceptable to converge at either 30° or 45°. However, on diverging spurs, it is most desirable to divert at 30°.



# WHEEL CONVEYORS PATTERNS

## GENERAL

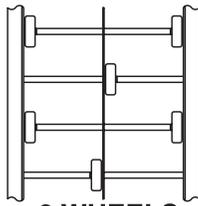
Gravity wheel conveyors are best suited for light duty applications. The key criteria is that the load bottom surface is flat, rigid and smooth. Soft bottom packages are not recommended since wheels may indent soft bottom contain-

ers, thus curtailing product movement. Also, consideration must be given to the construction of the bottom surface of the product container. A wooden crate, for example, may hang on individual wheels and not start from its

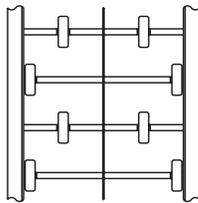
stopped position.

When calculating minimum wheel spacing required, the wheel patterns below may be used to determine minimum wheel spacing. Wheel axles are spaced on 3" centers.

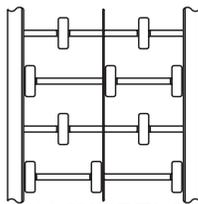
### 12" OAW



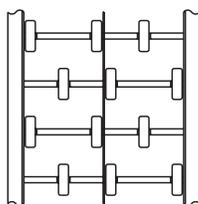
6 WHEELS



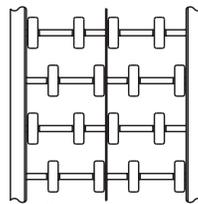
8 WHEELS



10 WHEELS

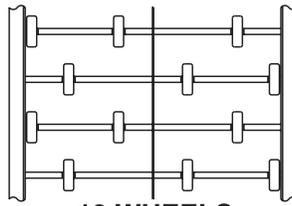


12 WHEELS

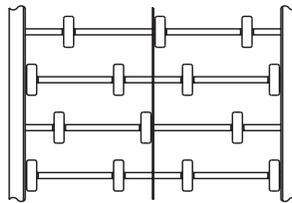


16 WHEELS

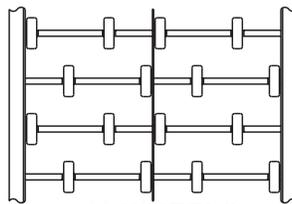
### 18" OAW



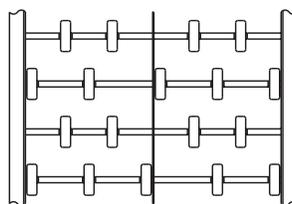
12 WHEELS



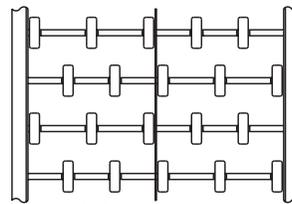
14 WHEELS



16 WHEELS

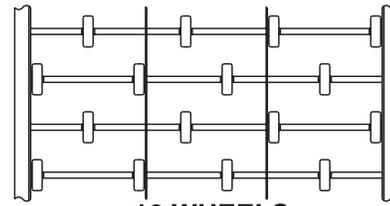


18 WHEELS

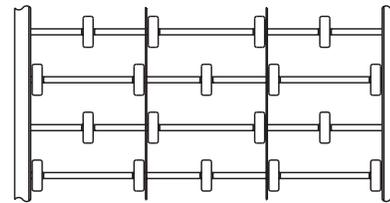


20 WHEELS

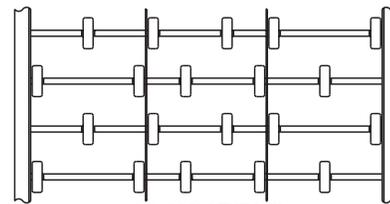
### 24" OAW



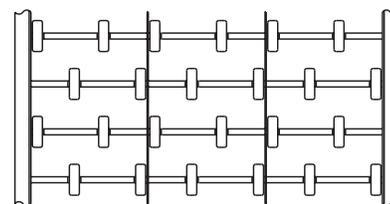
16 WHEELS



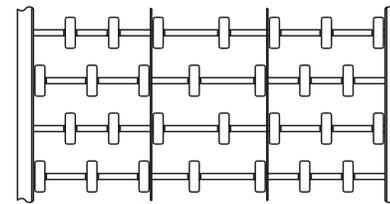
18 WHEELS



20 WHEELS



24 WHEELS



28 WHEELS



# ROACH CONVEYORS

## WARRANTY

- Materials used by Roach Conveyors are of good quality.
- Any part proving to be defective in materials or workmanship upon Roach inspection, will be replaced at NO cost, FOB, Trumann, Arkansas, for one year. Installation expense will be paid by others.
- Roach liability includes furnishing said part or parts; Roach is not liable for consequential damages, such as loss of profit, delays or expenses incurred by failure of said part or parts.
- Failure due to abuse, incorrect adjustments, exposure to corrosive or abrasive environment or operation under damp conditions does not constitute failure due to defects in workmanship or materials.
- Component parts not manufactured by Roach (motors, gear reducers, etc.) will be repaired or replaced at the option of their manufacturer. Contact nearest authorized service center for all warranty claims.

NOTE: Motors or gear reducers tampered with before inspection shall be considered free of ALL Warranty Claims.

--All specifications are subject to change without notice--  
--Drawings are intended for illustration ONLY and are not to scale--

Roach Conveyors  
808 Highway 463 North  
Trumann, AR 72472-1310



# American Made Conveyor Solutions



Custom Solutions for Unique Applications

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