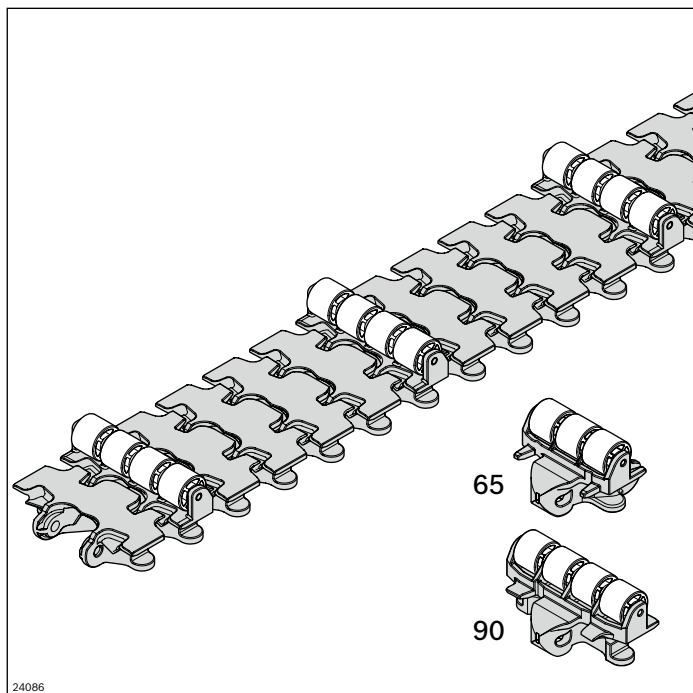


Roller cleat chain D20



The roller cleat chain D20 enables the transport of products on ascending or descending sections. See also “Layout instructions for roller cleat chains”, on page 34

- The maximum gradient depends on the product geometry (test required)
- Accumulation operation not permitted
- Maximum chain tensile force: 1250 N
- $AZ \geq 2$: Roller cleat chain supplemented with flat chain links (AZ = spacing distance)

- ▶ Extremely quiet chain running thanks to the patented chain design
- ▶ Materials meet the requirements of EU 10/2011 and FDA CFR 21

- ▶ For infeeding without any effort for cycle time adjustment

Required accessories for individual chain links:

Chain pin and jointed bolts, see page 31

Scope of delivery:

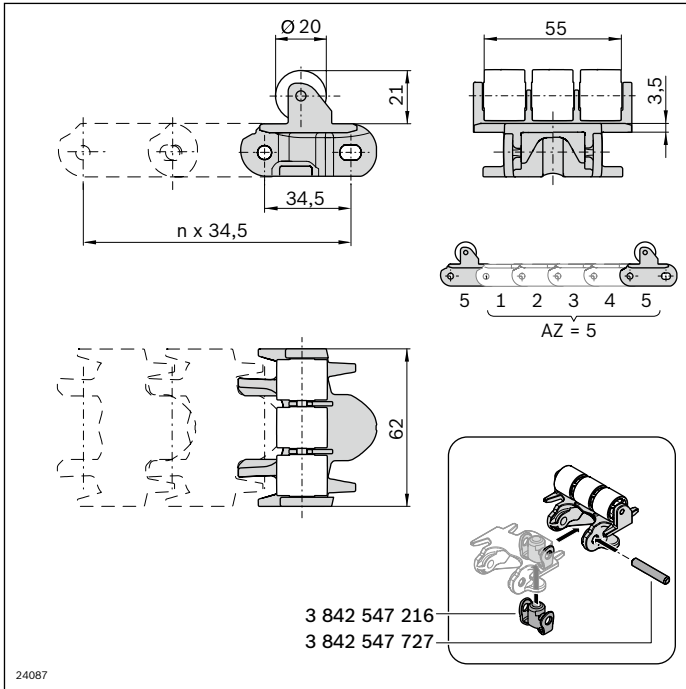
Chain: Complete, incl. chain pin and jointed bolts

Condition on delivery:

Chain: Fully assembled

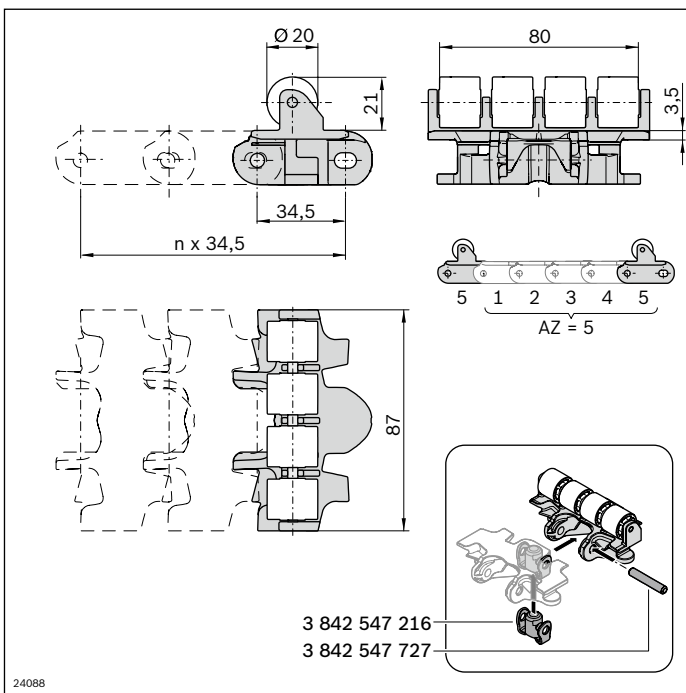
Material:

- Chain link: POM
- Roller: POM
- Chain pin: Stainless steel, 1.4301
- Jointed bolts: PA66



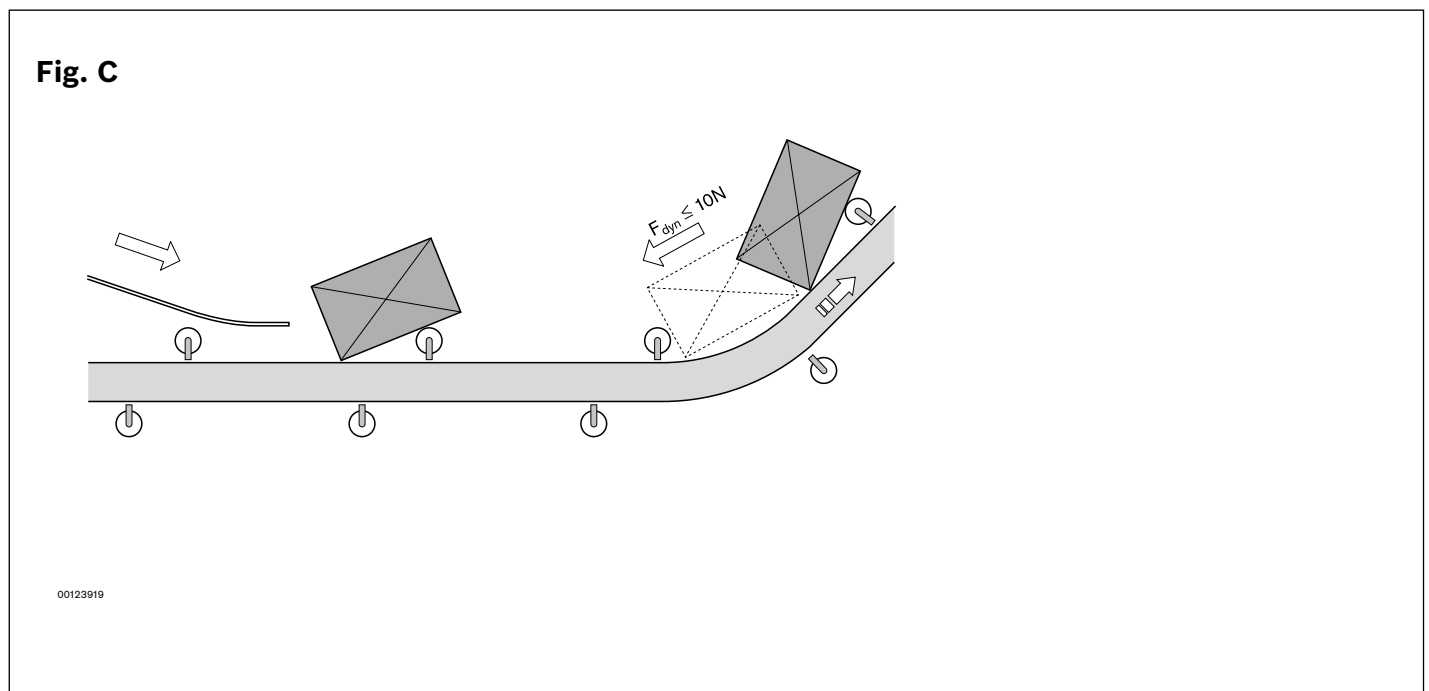
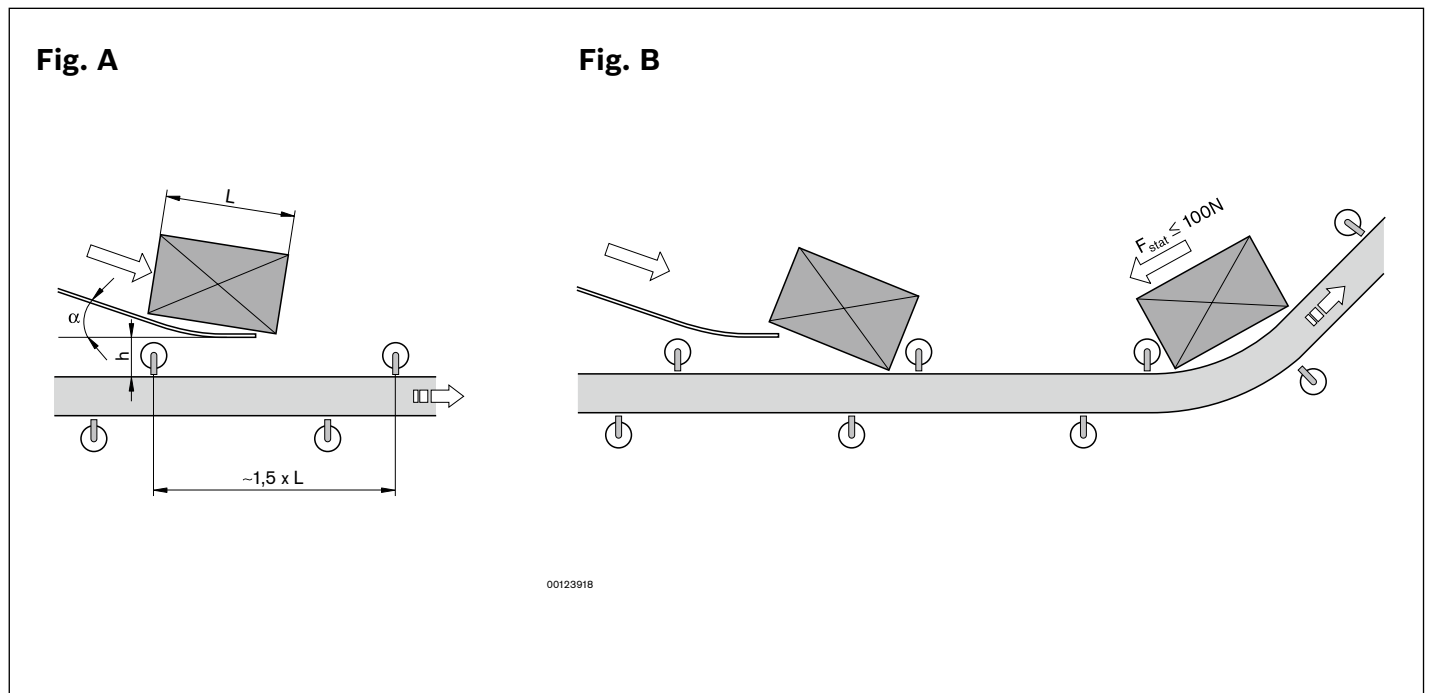
Roller cleat chain D20 VFplus 65	L (mm)		No.
Conveyor chain; AZ = 2 ... 84	2898	1	3 842 998 720/AZ
Chain link	10		3 842 546 020
Chain pin	100		3 842 547 727
Swivel pin	100		3 842 547 216

2



Roller cleat chain D20 VFplus 90	L (mm)		No.
Conveyor chain; AZ = 2 ... 84	2898	1	3 842 998 721/AZ
Chain link	10		3 842 546 021
Chain pin	100		3 842 547 727
Swivel pin	100		3 842 547 216

Layout instructions for roller cleat chains



Roller cleat chain

During uphill transport of packaged, bulky products (e.g. boxes), the products can slide between the roller cleats via a chute to be diagonally “inserted” into the transport direction from above. The product rolls into the next free pocket, which ensures continuous material flow without any expensive cycle time adjustment.

The roller diameter is dependent on the size of the transported goods.

When planning, observe the following (see Fig. A):

- Keep height of fall “h” and angle “ α ” as small as possible.
- The speed of the inserted product should be about the same as that of the conveyor system. Reduce higher speeds by braking (e.g. brushes) before inserting into the roller cleat chain.

Always prevent the product from transmitting its kinetic energy to the roller cleats

- Feed in the direction of transport of the roller cleat chain.
- Distance between roller cleats approx. 1.5x product length (ensures smooth movement through vertical curves).
- Removal speed:
2x product length x 1.5x product quantity/min.

This ensures that each product has two pockets available to slide into, either forwards or backwards (see Fig. B, C).

- Max. dynamic force of product when sliding backwards against the roller cleat: 10 N
- Max. static force due to adjacent product: 100 N

At higher forces, decrease the angle of inclination or reduce the speed of impact by installing individual static friction chain links between the roller cleats.