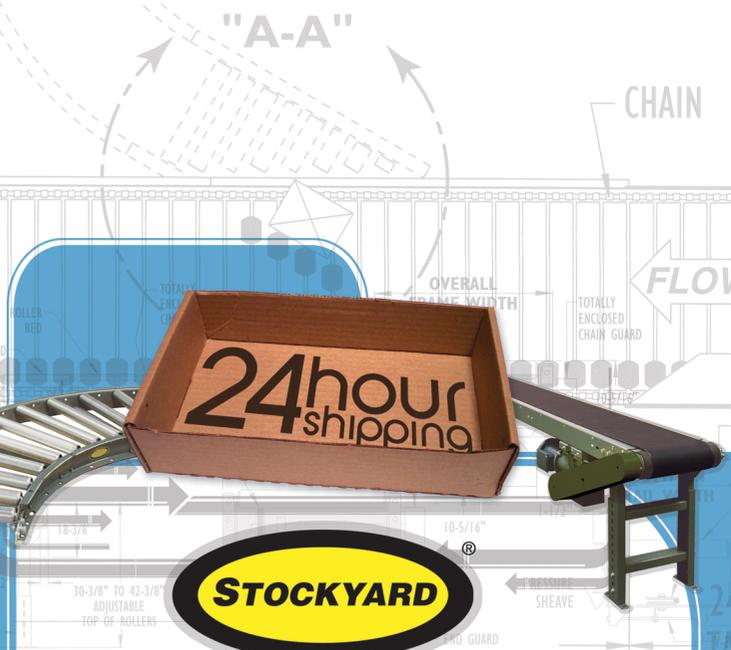
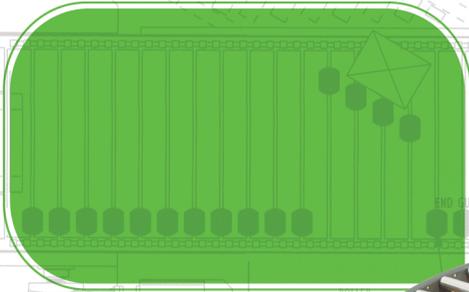




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\$20.00
April 08



Stockyard Reference Guide

Application, Selection, and Pricing Guide for all Stockyard Conveyors

24-Hour Standard Items - Guaranteed Shipping!

- Our most popular Gravity, Belt & Powered Conveyors
- Over 70,000 standard options
- Also available online

1-Week Standard Items - Guaranteed Shipping!

- Curves, Chain Driven Live Roller, Zero Pressure & Heavy Duty Gravity
- Choose from 6 different colors

Green 24-Hour	DK Blue 1-Week	White 1-Week	Beige 1-Week	Black 1-Week	Gray 1-Week
------------------	-------------------	-----------------	-----------------	-----------------	----------------

Any conveyors ordered from the Stockyard are now available for 1 week shipment with any of the six optional standard powder paint colors!



Contact 870.974.5600
www.hytrolstockyard.com



How To Use This Guide

Step 1 - Pick Your Product(s)

- Gravity Skatwheel - pages 3,4
- Light Duty Rollers - pages 5,6
- Heavy Duty Rollers - pages 7,8
- Horizontal Belt - pages 9,10
- Incline/Decline Belt - pages 11,12
- Live Roller - pages 13,14
- Accumulating - pages 15,16
- Portable - pages 17,18
- Conveyor Accessories - pages 19,20
- Conveyor Accessories - pages 21,22

Step 2 - Estimate Your Material Cost

follow example below...

MATERIAL ESTIMATE				
QTY	UNITS (per ft or ea.)	ITEM	COST PER UNIT	TOTAL
1	6	Belt / TA / pg. 10	\$100	\$600
1	2	Ball Table / BTT / pg. 4	\$150	\$300
			Total Material Cost	\$900



Step 3 - Estimate Your Installed Price

follow example below...

EXAMPLE 1 - QUICK METHOD

	TOTAL MATERIAL	FACTOR	TOTAL
Material Cost x 2.2	\$900	2.2	\$1,980

-- OR --

EXAMPLE 2 - ITEMIZED METHOD

CHOOSE REQUIRED ITEMS	TOTAL MATERIAL
Mechanical Installation (30% of Material Cost)	\$270
Electrical Controls (30% of Material Cost)	\$270
Field Wiring (Equal to Controls Cost or 30% of Material Cost)	\$270
Shipping & Handling and Misc. (30% of Material Cost)	\$270
	\$1,080

ITEMIZED SUMMARY

FACTOR	TOTAL
Material	\$900
	\$1,080
Total	\$1,980

Notes: This guide is intended to provide you with typical "ball park" information. Use it to get an idea if your concept warrants further investigation. Material costs include items that are normally supplied with a purchase. As you can imagine a large variation can occur from one application to the next. Thus, pricing can vary greatly. Labor and Transportation estimates are also based on typical rates.

Step 4 - Estimate Your Transit Time

- 1-2 Day Delivery
- 2-3 Day Delivery
- 3-4 Day Delivery
- 4-5 Day Delivery



All HYTROL Products Carry a

ONE-YEAR WARRANTY

A copy of this Warranty is included with every order shipped

F.O.B. Shipping Point

All orders processed and shipped from HYTROL's Stockyard and Manufacturing facility in Jonesboro, Arkansas

HYTROL Conveyor Co., Inc.

2020 Hytrol Street · Jonesboro, Arkansas 72401

Phone: (870) 935-3700 · Fax: (800) 852-3233

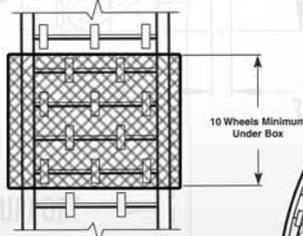
Step 5 - Contact A Distributor

Your Hytrol Distributor can provide you with a detailed proposal for a solution that meets your specific requirements. For additional information or to locate a distributor: www.hytrolstockyard.com

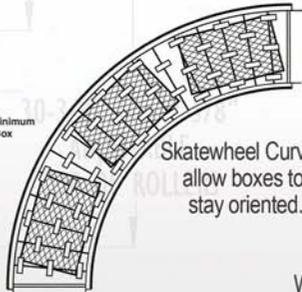


Gravity Skatewheel - Application

For: manual operations, light product with firm bottom, portable applications



10 Wheels Minimum Under Box



Skatewheel Curves allow boxes to stay oriented.



Wheel rails for floor loading.

Skatewheel - Various skatewheel patterns are available. There should always be ten wheels, minimum, under a box.

Move These On Wheel Conveyors

Any items with a smooth, flat bottom. These items can be wider than the conveyor, 6" over on each side is not too much. Center extra wide items carefully.



Totes



Beverages



Lumber



Bundles



Cases

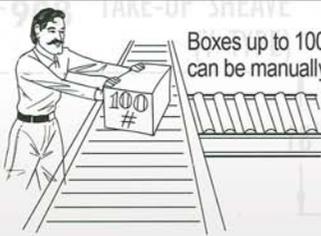


Trays

(TABLE BELOW IS ONLY A GUIDELINE)

ITEM	APPROXIMATE WEIGHT (IN POUNDS)	SLOPE OF CONVEYOR (INCHES PER 10 FT.)
BOXES, WOOD	15-25	6-1/4"
BOXES, WOOD	25-50	5"
BOXES, WOOD	50-100	3-3/4"
BOXES, WOOD	100-250	3-1/8"
CARTONS	3-6	8-3/4"
CARTONS	6-12	7-1/2"
CARTONS	12-25	6-1/4"
CARTONS	25-30	5"
CRATES	—	5" - 6-1/4"
LUMBER	—	5"
PANS, TOTE	—	2-1/2" - 5"

Ball Caster - Application



Boxes up to 100 lbs. can be manually pushed



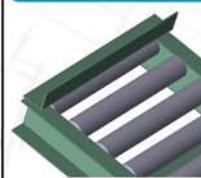
Boxes up to 200 lbs. can be manually pushed using a ball transfer

Gravity Skatewheel & Ball Caster - Comparison Chart

	 SW	 AW	 Wheel Rails	 FX200	 BIT	
Key Indicators for Typical Configuration						
Type	Steel Skatewheel	Aluminum Skatewheel	Steel Skatewheel Conveyor Rails	Extendable Skatewheel	Ball Transfer (Ball Casters) Table	
Ball Park Cost / Foot	\$45	\$50	\$20	\$100	\$150	
Application	Light Duty	Light Duty	Light Duty	Light Duty	Light Duty	
Lead Time	24 Hour / 1 Week	24 Hour / 1 Week	1 Week	24 Hour*	24 Hour / 1 Week	
Specifications						
Lengths	5' increments (5' & 10' bed sections)		10' increments	12', 24' (extended length)	1' increments	
Widths	12", 15", 18", 24"		N/A	18", 24"	12", 15", 16", 18", 20", 22", 24", 26", 28", 30", 34", 36", 40", 42"	
Capacity	10' ctr.	31 lbs. / ft.	10 lbs. / ft.	Up to 260 lbs. / ft.	200 lbs. / ft.	135 lbs. / ft.
	5' ctr.	250 lbs. / ft.	83 lbs. / ft.		620 lbs. / ft.	
Frame	Steel	Aluminum	Steel	Steel	Steel	
Wheel	1-15/16" dia.	1-15/16" dia.	1-15/16" dia.	1-15/16" dia.	1" dia. Ball Caster	
Conveying Surface	Galvanized Steel Wheels	Aluminum Wheels	Galvanized Steel Wheels	Galvanized Steel Wheels	Steel Ball Casters	
Accessories						
Permanent Supports	Optional	Optional	—	Included	Optional	
Temporary Supports	Optional	Optional	—	—	—	
Casters	Optional	Optional	—	Included	Optional	
Guard Rails	Optional	Optional	—	Optional	Optional	
End Stops	Optional	Optional	—	Included	Optional	

* NOTE: 24 hour shipment is subject to available stock for the FX200. 24 hour shipment not guaranteed.
Estimates based on nicely equipped conveyor: 24" wide x 50' long

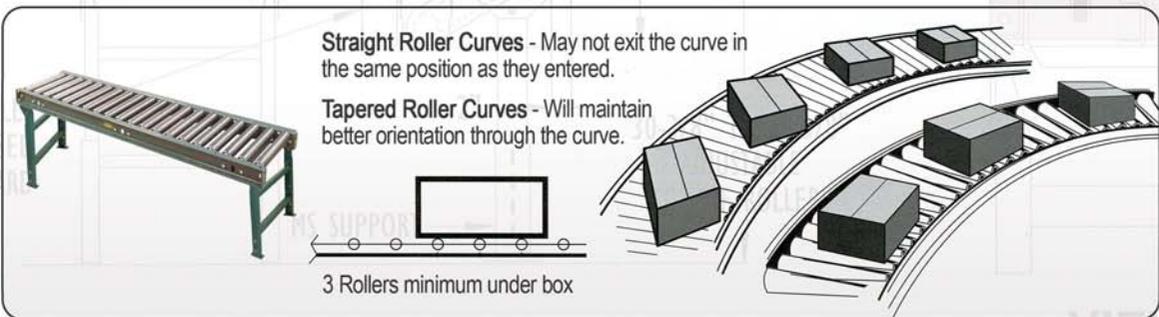
Related Items

<p>Curves</p>  <ul style="list-style-type: none"> » Gravity curves compliment gravity and power conveyors » Minimum pitch required for unassisted flow » Configure the conveyor for the space you have <p>See Page 21</p>	<p>Floor Supports</p>  <ul style="list-style-type: none"> » Easy to install "H" type supports for permanent applications » Many adjustable height ranges available » Available with casters for portable conveyor sections <p>See Page 19</p>	<p>Guard Rail</p>  <ul style="list-style-type: none"> » Keep product contained within conveyor surface » Adjustable or fixed positions available » Straight and curve guards available <p>See Page 20</p>	<p>Package Stops</p>  <ul style="list-style-type: none"> » Many styles of stops available for power and gravity conveyor » Fixed position or actuated styles available » Use stops at the end or intermediate points <p>See Page 20</p>	<p>Tripods</p>  <ul style="list-style-type: none"> » Hand adjustable supports for temporary applications » Use with straight or curved sections » For light duty conveyors <p>See Page 19</p>
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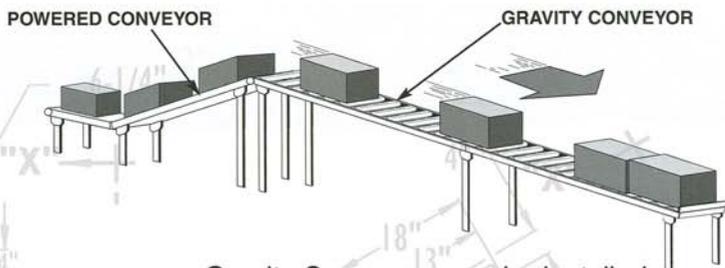
Light Duty Rollers - Application

For: manual operations, light product and/or irregular bottoms, side loading



Although less expensive than powered conveyor, gravity does not provide a positive flow of packages. The degree of pitch needed on a gravity conveyor will depend on several factors:

1. The type of conveyor, roller or skatowheel
2. Bearings greased packed or lightly oiled? (grease packed bearings roll slower)
3. The weight of the package.
4. The quality or firmness of the package bottom.



Gravity Conveyors can be installed on a decline or horizontal.

Move These On Roller Conveyors
Any items with an uneven or open bottom, or with a rim on the bottom. These items should never be bigger around than the rollers are long.

Baskets Cases Lumber

Totes Brick Barrels

(TABLE BELOW IS ONLY A GUIDELINE)

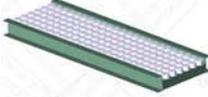
ITEM	APPROXIMATE WEIGHT (IN POUNDS)	SLOPE OF CONVEYOR (INCHES PER 10 FT.)
BASKETS	—	5"
BOXES, WOOD	15-25	6-1/4"
BOXES, WOOD	25-50	5"
BRICK	—	5"
CARTONS	3-6	8-3/4"
CARTONS	6-12	7-1/2"
CARTONS	12-25	6-1/4"
CARTONS	25-30	5"
DRUMS	150-300	2-1/2" - 3-3/4"
LUMBER	—	5"
PANS, TOTE	—	2-1/2" - 5"

Light Duty Rollers - Comparison Chart

		 SSR	 SAR	 19SR	 19GSR
Key Indicators for Typical Configuration					
Type	1-3/8" dia. x 18 ga. Steel Roller	1-3/8" dia. x 18 ga. Aluminum Roller	1.9" dia. x 16 ga. Unplated Steel Roller	1.9" dia. x 16 ga. Galvanized Roller	
Ball Park Cost / Foot	\$40	\$50	\$45	\$50	
Application	Light Duty	Light Duty	Medium Duty	Medium Duty	
Lead Time	24 Hour	24 Hour	24 Hour	24 Hour	
Specifications					
Lengths	5' increments (5' & 10' bed sections)				
Widths	12", 15", 18", 24"		16", 18", 20", 22", 24", 26", 28", 30", 34", 36", 40", 42"		
Capacity	10' ctr.	31 lbs. / ft.	10 lbs. / ft.	118 lbs. / ft.	118 lbs. / ft.
	5' ctr.	250 lbs. / ft.	83 lbs. / ft.	620 lbs. / ft.	620 lbs. / ft.
Frame	Steel	Aluminum	Steel	Steel	
Roller	1-3/8" dia.	1-3/8" dia.	1.9" dia.	1.9" dia.	
Conveying Surface	Galvanized Steel Rollers	Aluminum Rollers	Unplated Steel Rollers	Galvanized Steel Rollers	
Accessories					
Permanent Supports	Optional	Optional	Optional	Optional	
Temporary Supports	Optional	Optional	Optional	Optional	
Casters	Optional	Optional	Optional	Optional	
Guard Rails	Optional	Optional	Optional	Optional	
End Stops	Optional	Optional	Optional	Optional	

Estimates based on nicely equipped conveyor: 24" wide x 50' long

Related Items

<h3>Curves</h3>  <ul style="list-style-type: none"> » Gravity curves compliment gravity and power conveyors » Minimum pitch required for unassisted flow » Configure the conveyor for the space you have <p>See Page 21</p>	<h3>Ball Transfer</h3>  <ul style="list-style-type: none"> » Easily rotate or position products by hand » Transfer products to parallel or perpendicular conveyors » Great for filling, taping, inspection and assembly <p>See Page 4</p>	<h3>Floor Supports</h3>  <ul style="list-style-type: none"> » Easy to install "H" type supports for permanent applications » Many adjustable height ranges available » Available with casters for portable conveyor sections <p>See Page 19</p>	<h3>Guard Rail</h3>  <ul style="list-style-type: none"> » Keep product contained within conveyor surface » Adjustable or fixed positions available » Straight and curve guards available <p>See Page 20</p>	<h3>Gate</h3>  <ul style="list-style-type: none"> » Create convenient passageway for personnel and equipment » Available for most gravity and powered conveyors » Lift handles and locking mechanism for easy and safe operation <p>See Page 20</p>
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(FLAT T) For more information or to locate a distributor visit www.hytrilstockyard.com



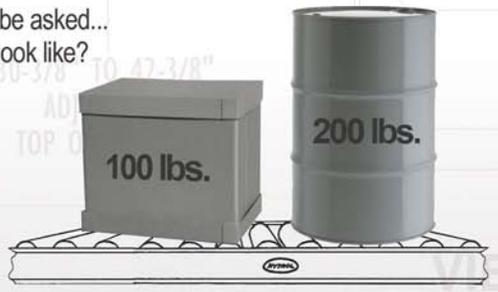
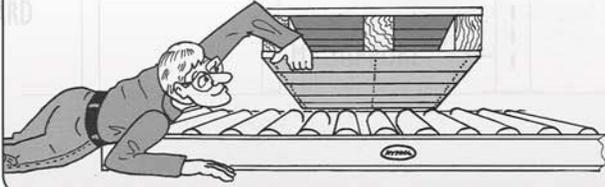
Heavy Duty Gravity Rollers - Application

For: manual operations, heavy product and/or irregular bottom, abusive applications

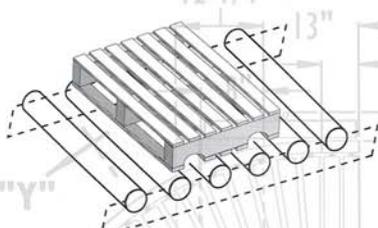
Heavy Duty Load Application

When a load application is presented, two key questions will be asked...

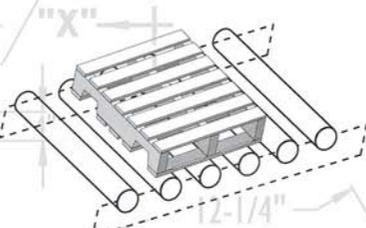
1. What does the conveying surface (bottom of the product) look like?
2. What is the load weight?



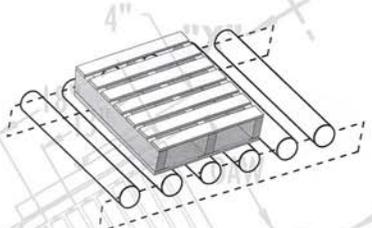
Although you may think you are conveying "Standard Pallet", don't believe it! While pallets may appear similar, they are NOT and careful attention must be given to the pallet bottom deck. Will the pallet "runners" be parallel or perpendicular to the conveyor rollers.



PARALLEL...



PERPENDICULAR...



OR MAYBE BOTH...

Runners perpendicular are always the best. Runners parallel should be avoided. If runners are in both directions, the pallet could be used bi-directly. ie., placed on the conveyor either way.



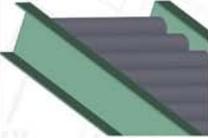
- A. Horizontal Gravity - Many pallets are moved on horizontal gravity roller conveyors simply by hand pushing.
- B. Decline Gravity - Pallets moving on decline conveyors, however, present different problems and usually require special braking to control the speed.

Heavy Duty Gravity Rollers - Comparison Chart

HYTROL STOCKYARD CONVEYOR		 199SR	 20SR	 2514SR	 25SR	 26SR
Key Indicators for Typical Configuration						
Type	1.9" dia. x 9 ga. Steel Roller	2.0" dia. x 12 ga. Steel Roller	2.5" dia. x 14 ga. Steel Roller	2.5" dia. x 11 ga. Steel Roller	2.5" dia. x 7 ga. Steel Roller	
Ball Park Cost / Foot	\$70	\$50	\$65	\$95	\$115	
Application	Heavy Duty	Heavy Duty	Heavy Duty	Heavy Duty	Heavy Duty	
Lead Time	24 Hour	24 Hour	24 Hour	24 Hour	1 Week	24 Hour / 1 Week
Specifications						
Lengths	5' increments (5' & 10' bed sections)					
Widths	16", 18", 20", 22", 24", 26", 28", 30", 34", 36", 40", 42"			16-1/4", 18-1/4", 20-1/4", 22-1/4", 24-1/4", 26-1/4", 28-1/4", 30-1/4", 34-1/4", 36-1/4", 40-1/4", 42-1/4", 46-1/4", 50-1/4", 54-1/4", 58-1/4"		
Capacity	10' ctr.	118 lbs. / ft.		288 lbs. / ft.		288 lbs. / ft.
	5' ctr.	620 lbs. / ft.		1620 lbs. / ft.		1620 lbs. / ft.
Frame	Steel	Steel	Steel	Formed Steel	Formed Steel	
Roller	1.9" dia.	2.0" dia.	2-1/2" dia.	2-1/2" dia.	2-5/8" dia.	
Conveying Surface	Unplated Steel Rollers	Unplated Steel Rollers	Unplated Steel Rollers	Unplated Steel Rollers	Unplated Steel Rollers	
Accessories						
Permanent Supports	Optional	Optional	Optional	Optional	Optional	Optional
Casters	Optional	Optional	Optional	Optional	Optional	Optional
Guard Rails	Optional	Optional	Optional	Optional	Optional	Optional
End Stops	Optional	Optional	Optional	Optional	Optional	Optional

Estimates based on nicely equipped conveyor: 24" wide x 50' long

Related Items

<p>Curves</p>  <ul style="list-style-type: none"> » Gravity curves compliment gravity and power conveyors » Removable "spring" loaded rollers » Configure the conveyor for the space you have <p>See Page 21</p>	<p>Floor Supports</p>  <ul style="list-style-type: none"> » Easy to install "H" type supports for permanent applications » Many adjustable height ranges available » Available with casters for portable conveyor sections <p>See Page 19</p>	<p>Stops</p>  <ul style="list-style-type: none"> » Fixed position or actuated styles available » Use stops at the end or intermediate points » Easily relocated to adapt with you <p>See Page 20</p>	<p>Rollers Set Low</p>  <ul style="list-style-type: none"> » Great for use with manual side entry points » Optional rollers set low for a built in guard rail » Keeps product contained in section <p>See Page 20</p>	<p>Guard Rail</p>  <ul style="list-style-type: none"> » Keep product contained within conveyor surface » Adjustable or fixed positions available » Straight and curve guards available <p>See Page 20</p>
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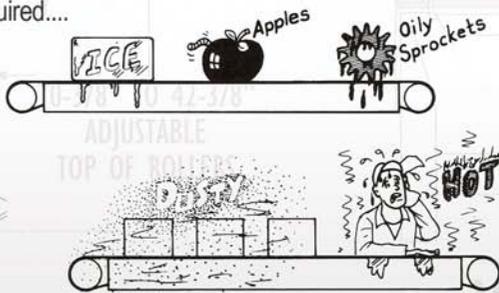
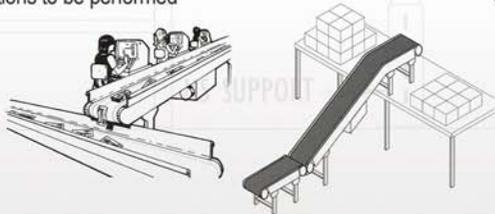


Horizontal Belt - Application

For: powered transportation, difficult to convey items, assembly line applications

Things To Consider When Determining Type Of Belt Required....

1. Characteristics of the product handled
2. Prevailing atmospheric conditions
3. Operations to be performed

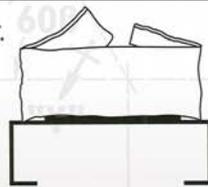


Roller Bed Belt Conveyor
 This conveyor increases the amount of load which can be conveyed. This is because the belt is now traveling over rollers which have a very low coefficient of friction.



Slider Bed Belt Conveyor
 This type of conveyor is probably the most widely used package handling power conveyor. Its solid steel bed construction is inexpensive, simple, quiet, and easy to install. It is frequently used for assembly operations and general transportation.

Boxes moved by belt conveyors should not exceed the overall width of the conveyor.



Boxes of poor quality should not exceed the width of the belt since box edges may drag

Horizontal Belt - Comparison Chart

     					
Key Indicators for Typical Configuration					
Type	Belt sliding on formed box bed	Belt sliding on formed box bed w/troughed sides	Belt sliding on formed box bed	Belt sliding on steel pan inserted in channel frame	Belt sliding on rollers inserted in channel frame
Ball Park Cost / Foot	\$100	\$120	\$130	\$120	\$120
Application	Light	Light	Medium	Medium	Heavy
Lead Time	24 Hour	24 Hr. / 1 Week	24 Hour / 1 Week	24 Hour	24 Hour / 1 Week
Specifications					
Lengths	6' Minimum to 102' Maximum (5' increments)	6' to 51' (5' increments)	7' to 102' (5' increments)	12' to 102' (5' increments)	
Widths	10", 12", 14", 16", 18", 20", 22", 24", 28"	8", 10", 12", 14", 18", 20", 22", 26", 32"	30", 36", 42"	18", 24", 30"	16", 18", 20", 22", 24", 26", 28", 30", 34", 36", 40", 42"
Capacity	75 lbs. / ft.	75 lbs. / ft.	100 lbs. / ft.	100 lbs. / ft.	225 lbs. / ft.
Frame	Steel Slider Bed	Steel Slider Bed	Steel Slider Bed	Channel Frame	Channel Frame
Conveying Surface	Black Belt Brushed both sides	Black Belt Brushed both sides	Black Belt Brushed both sides	Black Belt Brushed both sides	Black Belt Brushed both sides
Accessories					
Floor Supports	Optional	Optional	Optional	Optional	Optional
Multi-Level	Optional	Optional	Optional	Optional	Optional
Ceiling Supports	Optional	Optional	Optional	Optional	Optional
Guard Rails	Optional	Optional	Optional	Optional	Optional
Casters	Optional	Optional	Optional	Optional	Optional
Alternate Belting	Optional	Optional	Optional	Optional	Optional

Estimates based on nicely equipped conveyor: 24" wide x 50' long

Related Items

<h3>Inclines</h3>  <ul style="list-style-type: none"> » Configured with ruff top belt and transition to horizontal » Use with mezzanines or overhead lines » Reversing for use as an incline or decline <p>See Page 12</p>	<h3>Portables</h3>  <ul style="list-style-type: none"> » Portable units can be stored when not in use » Convey packages, parts and small objects » Use one conveyor for many applications <p>See Page 18</p>	<h3>Belting</h3>  <ul style="list-style-type: none"> » Many belts for specific applications » High grip, low grip, cleanable, sanitary » Many widths available on most belt conveyors <p>See Page 22</p>	<h3>Electrical Controls</h3>  <ul style="list-style-type: none"> » Start/stop, forward/reverse push button stations » Variable speed controls » Magnetic starters with overload protection <p>See Page 21</p>	<h3>Guard Rail</h3>  <ul style="list-style-type: none"> » Keep product contained within conveyor surface » Adjustable or fixed positions available » Transitions hardware to horizontal sections <p>See Page 20</p>
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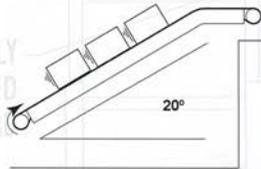
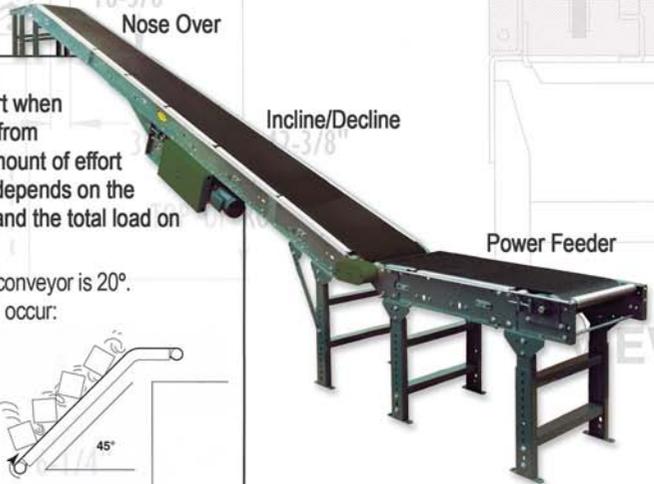
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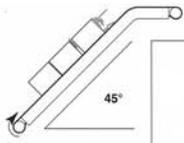
Incline/Decline Belt - Application

For: powered elevation changes, variety of products, reversing applications

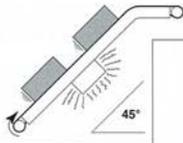


It takes more effort when moving boxes up from horizontal. The amount of effort or power it takes depends on the degree of incline and the total load on the conveyor.

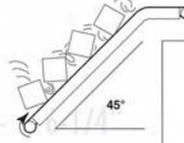
For most applications the maximum angle for an incline conveyor is 20°. If a 20° incline is exceeded, the following problems could occur:



A. Boxes may slip back down the conveyor.



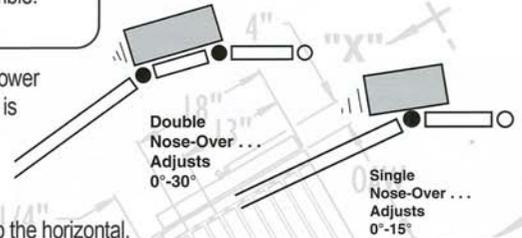
B. Drive capacity may be exceeded.



C. Boxes may tumble.

A power feeder should normally be 2-1/2 times as long as the belt width. Power feeders are best powered by a chain attached to the incline conveyor. This is called **chain driven power feeder**.

Another item available as standard on most incline conveyors and optional on others is a **nose-over**. This may be a single or double nose-over. This allows a smooth transition from the horizontal to the decline or the incline to the horizontal.



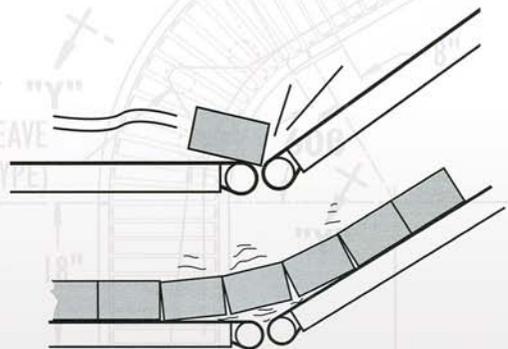
Additional Considerations For Inclines...

A. Small boxes may tumble at the transfer point of a feeder.

B. It is easy to drive the feeder at a different speed than the incline by using a different size sprocket. This may be done to help pull a gap in the line of boxes, or prevent them from bridging or being staggered

C. Boxes should not be wider than the conveyor.

D. Some decline conveyors will drift after they are stopped. This depends on the load and speed of the conveyor. Brake motors are required on all incline & decline conveyors.



Incline / Decline Belt - Comparison Chart

	 SBI	 RBI	 BA
Comparative Pricing for Typical Configuration			
Type	Incline/Decline Belt sliding on steel pan insert in channel frame	Incline/Decline Belt sliding on rollers in the channel frame	Portable Folding Booster Belt Conveyor
Ball Park Cost / Foot	\$170	\$170	\$315
Application	Medium Duty	Heavy Duty	Medium Duty
Lead Time	24 Hour	24 Hour	1 Week
Specifications			
Lengths	13'-10" Minimum, 43'-10" Maximum (2' Increments)		10', 12', 14', 16', 20', 22'
Widths	18", 24", 30"		20"
Capacity	100 lbs. / ft.	225 lbs. / ft.	300 lbs. total
Frame	Steel Slider Bed	Steel Slider Bed	Steel Slider Bed
Conveying Surface	Rough Top Belt	Rough Top Belt	Rough Top Belt
Accessories			
Floor Supports	Optional	Optional	—
Ceiling Supports	Optional	Optional	—
Guard Rails	Optional	Optional	—

Estimates based on nicely equipped conveyor: 24" wide x 50' long

Related Items

Horizontal Belt



- » Horizontal belts for infeed or discharge of inclines
- » Many Lengths Widths and types available
- » Drive options allow for reversing applications

See Page 10

Portables



- » Portable units can be stored when not in use
- » Convey packages, parts and small objects
- » Use one conveyor for many applications

See Page 18

Ceiling Hanger



- » Save space by hanging conveyors overhead
- » Adjustable with fully threaded rods
- » Available for most conveyors

See Page 19

Belting



- » Many belts for specific applications
- » High grip, low grip, cleanable, sanitary
- » Many widths available on most belt conveyors

See Page 22

Electrical Controls



- » Start/stop, forward/reverse push button stations
- » Variable speed controls
- » Magnetic starters with overload protection

See Page 21

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Live Roller - Application

For: powered transportation, many products, side loading, merge on and off

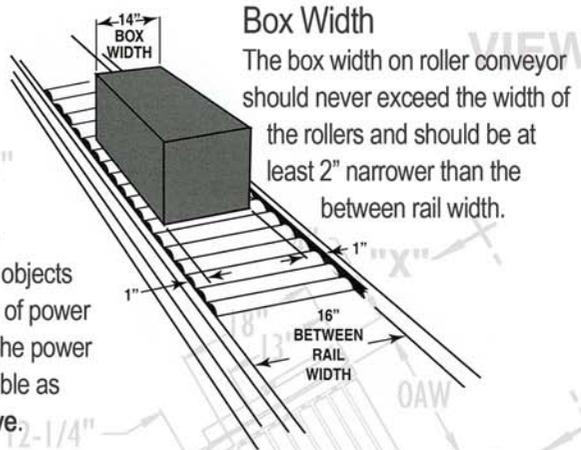


It is possible to stop or hold a box momentarily on a live roller conveyor. More than one or two boxes cannot be accumulated due to the excessive drive pressure. To accumulate boxes, an Accumulating Conveyor is needed.



Live Roller Conveyor -

A series of rollers over which objects are moved by the application of power to all or some of the rollers. The power transmitting medium is available as Belting, Chain, or Shaft Drive.



Box Width

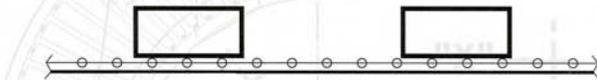
The box width on roller conveyor should never exceed the width of the rollers and should be at least 2" narrower than the between rail width.

Roller Centers...

Rollers may be placed in a frame at various centers.

However, there should always be at least three rollers under a box.

Determine the roller centers needed by measuring the smallest box to be placed on the conveyor.



Boxes will not tumble when three rollers are under the box at all times.



Less than three roller . . . boxes tumble

Live Roller - Comparison Chart

HYTROL STOCKYARD CONVEYOR		 138-NSP	 190-NSP	 190-LR	 25-CRR
Key Indicators for Typical Configuration					
Type	Line Shaft / Spool Driven Live Roller	Line Shaft / Spool Driven Live Roller	Flat Belt Driven Live Roller	Roll to Roll Chain Driven Roller	
Ball Park Cost / Foot	\$110	\$130	\$140	\$270	
Application	Light Duty	Medium Duty	Medium Duty	Heavy Duty	
Lead Time	24 Hour / 1 Week	24 Hour	24 Hour / 1 Week	1 Week	
Specifications					
Lengths	5' Minimum, 100' Maximum (5' increments)		10' Minimum, 100' Maximum (5' increments)	5' Minimum, 100' Maximum (1' increments)	
Widths	12", 15", 18", 24"	18", 24", 30"	16", 18", 20", 22", 24", 26", 28", 30", 34", 36", 40", 42"	22-1/4", 30-1/4", 50-1/4", 54-1/4", 58-1/4"	
Capacity	10' ctr.	10 lbs. / roller	15 lbs. / roller	200 lbs. / ft.	300 lbs. / ft.
	5' ctr.				1000 lbs. / ft.
Frame	Steel Roller Bed	Steel Roller Bed	Steel Roller Bed	Steel Roller Bed	
Roller	1-3/8" dia.	1.9" dia.	1.9" dia.	2-1/2" dia.	
Conveying Surface	Galvanized Steel Rollers	Galvanized Steel Rollers	Galvanized Steel Rollers	Unplated Steel Rollers	
Accessories					
Floor Supports	Optional	Optional	Optional	Optional	
Multi-Level Supports	Optional	Optional	Optional	Optional	
Ceiling Supports	Optional	Optional	Optional	Optional	
Guard Rails	Optional	Optional	Optional	Optional	
Casters	Optional	Optional	Optional	Optional	
End Stops	Optional	Optional	Optional	Optional	

Estimates based on nicely equipped conveyor: 24" wide x 50' long

Related Items

Curves



- » Powered or slave driven curves
- » Minimum pitch required for unassisted flow
- » Configure the conveyor for the space you have

See Page 21

Stops



- » Fixed position or actuated styles available
- » Use stops at the end or intermediate points
- » Normally up position or normally down position

See Page 20

Guard Rail



- » Keep product contained within conveyor surface
- » Adjustable or fixed positions available
- » Straight and curve guards available

See Page 20

Ceiling Hanger



- » Save space by hanging conveyors overhead
- » Adjustable with fully threaded rods
- » Available for most conveyors

See Page 19

Controls



- » Start/stop, forward/reverse push button stations
- » Variable speed controls
- » Magnetic starters with overload protection

See Page 21

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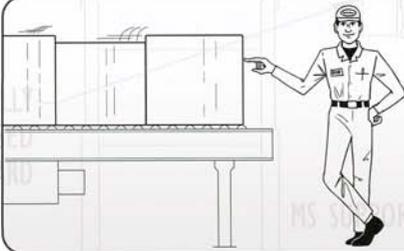
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Accumulating - Application

For: powered accumulation and/or transportation, automation, intermediate stop points



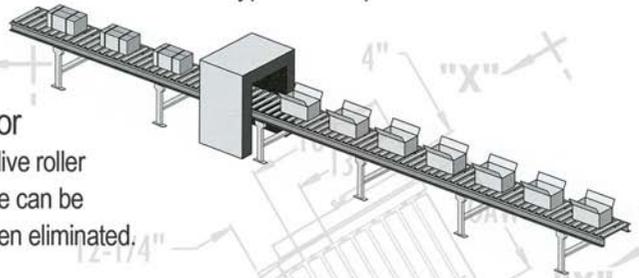
Many factors affect the proper operations of accumulating conveyors such as speed, box weight, and box size. Zero pressure conveyors may be either mechanically, pneumatically or electronically operated. Electronically operated units have no minimum weight requirement and use no sensing rollers.



Accumulating Conveyor

This conveyor is similar to a live roller except that the drive pressure can be adjusted to a minimum or even eliminated.

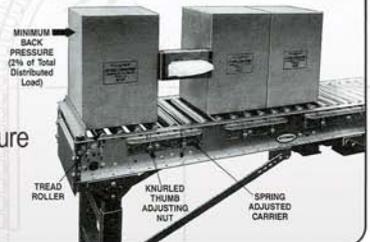
Many times it is necessary to accumulate a long line of boxes to be fed into a loading, sorting, strapping, palletizing, staging, etc. type of an operation...



Two Types Of Accumulating Conveyors...

A. Minimum Pressure - Has enough drive to the tread rollers to move the package. The amount of back pressure on this type of conveyor allows a minimum of 2% of the total live load on the conveyor.

B. Zero Pressure - Used to accumulate products with no products touching. This is done by using various methods to completely remove all driven pressure in select zones on the conveyor. These zones vary in length according to the product being conveyed.



Accumulating - Comparison Chart

		 138-ACC	 190-ACC	 190-ACZ	 ABEZ
Key Indicators for Typical Configuration					
Type	V-Belt Driven Minimum Pressure	V-Belt Driven Minimum Pressure Accumulation	Flat Belt Driven Minimum Pressure	Flat Belt Driven Zero Pressure	Flat Belt Driven Zero Pressure
Ball Park Cost / Foot	\$120	\$150	\$160	\$215	\$215
Application	Light Duty	Medium Duty	Medium Duty	Medium Duty	Medium Duty
Lead Time	24 Hour / 1 Week	24 Hour / 1 Week	24 Hour	24 Hour	1 Week
Specifications					
Lengths	5' Minimum, 100' Maximum (5' increments)		10' Minimum, 100' Maximum (5' increments)	10' Minimum, 100' Maximum (24" or 30" zone length increments)	
Widths	12", 15", 18", 24"	16", 18", 20", 22", 24", 26", 28", 30", 34", 36", 40", 42"	18", 24"	18", 24"	
Capacity	50 lbs. / ft.	150 lbs. / ft.	200 lbs. / ft.	150 lbs. / ft.	
Frame	Steel Roller Bed	Steel Roller Bed	Steel Roller Bed	Steel Roller Bed	
Roller	1-3/8" dia.	1.9" dia.	1.9" dia.	1.9" dia.	
Conveying Surface	Galvanized Steel Rollers	Galvanized Steel Rollers	Galvanized Steel Rollers	Galvanized Steel Rollers	
Accessories					
Floor Supports	Optional	Optional	Optional	Optional	
Multi-Level Supports	Optional	Optional	Optional	Optional	
Ceiling Supports	Optional	Optional	Optional	Optional	
Guard Rails	Optional	Optional	Optional	Optional	
Casters	Optional	Optional	Optional	Optional	
End Stops	Optional	Optional	Optional	Optional	

Estimates based on nicely equipped conveyor: 24" wide x 50' long

Related Items

<p>Curves</p>  <ul style="list-style-type: none"> » Powered or slave driven curves » Minimum pitch required for unassisted flow » Configure the conveyor for the space you have <p>See Page 21</p>	<p>Stops</p>  <ul style="list-style-type: none"> » Fixed position or actuated styles available » Use stops at the end or intermediate points » Normally up position or normally down position <p>See Page 20</p>	<p>Guard Rail</p>  <ul style="list-style-type: none"> » Keep product contained within conveyor surface » Adjustable or fixed positions available » Straight and curve guards available <p>See Page 20</p>	<p>Ceiling Hanger</p>  <ul style="list-style-type: none"> » Save space by hanging conveyors overhead » Adjustable with fully threaded rods » Available for most conveyors <p>See Page 19</p>	<p>Controls</p>  <ul style="list-style-type: none"> » Start/stop, forward/reverse push button stations » Variable speed controls » Magnetic starters with overload protection <p>See Page 21</p>
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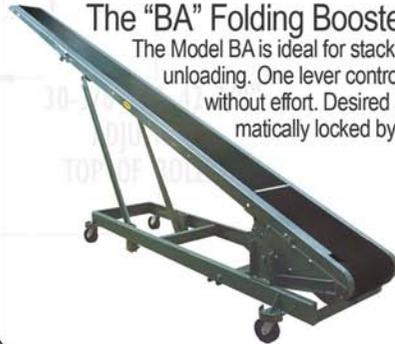
Portable - Application

For: portable applications, variety of products, one conveyor multiple operations



The "PC" Parts Conveyor

Can be used as a portable or permanent parts conveyor. Side guards and cleated belt easily catch small stampings, plastic parts, etc., and carry them to hoppers or drums. Flapper guard prevents parts from falling through conveyor.



The "BA" Folding Booster Belt

The Model BA is ideal for stacking, loading and unloading. One lever control adjusts angle without effort. Desired angle automatically locked by power screw.

The "B" Folding Cleated

The Model B is ideal for stacking, loading, and unloading at lengths of 10', 12', 14' & 16'. Hardwood cleats permit use at steeper inclines up to 45°. The conveyor folds onto its own portable base for storage.



The "BL" Folding Booster Belt

The Model BL is ideal for stacking, loading, and unloading. Hardwood cleats permit use at steeper inclines up to 45°. It can be used to convey material from one floor to another or to a mezzanine.



The "R" Aluminum Folding Belt

The Model R besides being extremely convenient (can be folded in half), is also very versatile. Examples of conveying uses include: truck, loft, or freight car, floor-to-floor, stairway, and as a portable booster with a wheel or roller conveyor. It is also suitable for bag handling, bag and carton stacking and moving cartons, cases, and boxes.



The "A" Aluminum Narrow Conveyor

The Model A with its Roughtop belt easily moves boxes, cases, and cartons up inclines. Its narrow width allows it to be used in a stairway for floor-to-floor conveying. It can be propped on a shelf for stacking or order picking. The Model A can be stored on its end in a minimum amount of space.



Portable - Comparison Chart

							
Key Indicators for Typical Configuration							
Type	Troughed Portable Parts Conveyor w/cleated belt	Portable Folding Booster Belt Conveyor	Portable Folding Booster Conveyor w/cleated belt	Long Portable Folding Booster Conveyor w/cleated belt	Aluminum Portable Folding Belt	Aluminum Portable Narrow Belt	
Ball Park Cost / Foot	\$270	\$315	\$320	\$245	\$205	\$220	
Application	Light Duty	Medium Duty	Medium Duty	Medium Duty	Light Duty	Light Duty	
Lead Time	24 Hour	1 Week					
Specifications							
Lengths	5', 7', 9', 11'	10', 12', 14', 16', 20', 22'	10', 12', 14', 16'	20', 22'	10', 11'-6", 13', 15', 17', 19', 21'	6', 8', 10', 12', 14', 16', 18', 20'	
Widths	12", 16", 22"	20"	20"	20"	18"	12"	
Capacity	300 lbs. total	300 lbs. total	300 lbs. total	300 lbs. total	300 lbs. total	200 lbs. total	
Frame	Steel Slider Bed	Steel Slider Bed	Steel Slider Bed	Steel Slider Bed	Aluminum Slider Bed	Aluminum Slider Bed	
Conveying Surface	Belt w/molded cleats on 12" centers	Rough Top Belt	Belt with 2 round cleats on 60" centers	Belt with 2 round cleats on 60" centers	Rough Top Belt	Rough Top Belt	
Accessories							
Floor Supports	Optional	Standard	Standard	Standard	Optional	Optional	
Portable Supports	Standard	Standard	Standard	Standard	Optional	Optional	
Guard Rails	Standard	Standard	Standard	Standard	Standard	Standard	
Casters	Standard	Standard	Standard	Standard	Optional	Optional	
Reversing Drum Switch	Optional	Standard	Standard	Standard	Standard	Standard	

Horizontal Belt



- » Horizontal belts for infeed or discharge of inclines
- » Many Lengths Widths and types available
- » Drive options allow for reversing applications

See Page 10

Inclines / Declines



- » Configured with rough top belt and transition to horizontal
- » Use with mezzanines or overhead lines
- » Reversing for use as an incline or decline

See Page 12

Floor Supports



- » Easy to install "H" type supports for permanent applications
- » Many adjustable height ranges available
- » Available with casters for portable conveyor sections

See Page 19

Push Buttons



- » Start/stop, forward/reverse push button stations
- » Variable speed controls
- » Magnetic starters with overload protection

See Page 21

Magnetic Starter



- » Reversing & Non-Reversing
- » Standard, Easy Clean
- » Energy Efficient Motor Duty

See Page 21



Conveyor Supports & Casters - Comparison Chart

		 LS	 MS	 HS	 Casters
Key Indicators for Typical Configuration					
Type	Adjustable floor support for permanent installation	Adjustable floor support for permanent installation	Adjustable floor support for permanent installation	Permanent supports can be configured to accept casters	
Ball Park Cost	\$45	\$45	\$70	4" dia. \$110	6" dia. \$160
Application	Light Duty	Medium Duty	Heavy Duty	Portable	
Lead Time	24 Hour / 1 Week	24 Hour / 1 Week	24 Hour / 1 Week	24 Hour	
Specifications					
For Use With	Fits light duty gravity & powered conveyors	Fits medium duty gravity & powered conveyors	Fits heavy duty gravity & powered conveyors	4" or 6" dia., rigid or swivel, steel or rubber, wheel brakes	
Heights	Min.	4-13/16"	5-3/4"	4-3/8"	4" dia. / 5-7/8"
	Max.	106-11/16"	107-11/16"	174"	6" dia. / 7-1/2"
Capacity	1500 lbs. Max.	1500 lbs. Max.	4000 lbs. Max.		

		 TS	 PT	 CH
Key Indicators for Typical Configuration				
Type	Adjustable floor support for temporary installation. No tools required	Adjustable floor support for permanent installation of multi-level system.	Adjustable support for overhead installations	
Ball Park Cost	\$40	2 Tier \$110 3 Tier \$130	\$50	
Application	Temporary	Multi-Level	Ceiling Hangers	
Lead Time	24 Hour / 1 Week	24 Hour	24 Hour / 1 Week	
Specifications				
For Use With	Light Duty models	Most models	Most models	
Heights	Min.	12"	48", 60", 72"	
	Max.	110"	Uprights 96", 120", 144"	
Capacity	350 lbs.	4500 lbs. / set	1500 lbs. / set	

Guard Rails - Comparison Chart

	 Adjustable Channel	 Type "A" Angle	 Type "B" Angle	 Fixed Channel
Key Indicators for Typical Configuration				
Type	Adjustable channel Guard Rails	Fixed angle guard rails. Vertical surface facing inward.	Fixed angle guard rails. Vertical surface facing outward.	Fixed channel guard rails. Vertical surface facing inward.
Ball Park Cost / Foot	\$10	\$5	\$5	\$10
Application	Medium Duty	Medium Duty	Medium Duty	Medium Duty
Lead Time	24 Hour	24 Hour	24 Hour	24 Hour / 1 Week
Specifications				
For Use With	Most belt & roller conveyors		Most roller conveyors	
Curved Sections	Available	Available	—	Available

Flow Control - Comparison Chart

	 Angle End Stop	 Terminal	 Dead Type Stop	 Air Operated Stop	 Gates	 Turning Wheels
Key Indicators for Typical Configuration						
Type	Fixed angle for placement in many locations along length	Flat plate for placement at the end point	Skid plate for placement in many locations along length	Roller stop for placement in many locations along length	Manual Gate	Non-Powered Wheel
Ball Park Cost	\$20	\$20	\$25	\$700	\$100 (less conveyor)	\$75
Application	Medium Duty	Medium Duty	Light Duty	Medium Duty	For use with all light and medium duty gravity conveyor	For use with all light and medium power conveyor
Lead Time	24 Hour / 1 Week	1 Week	24 Hour	24 Hour	24 Hour	24 Hour
Specifications						
For Use With	All roller models	Many roller models	Light duty roller & skatewheel conveyors	Many gravity roller models. Limited powered roller models	Passageway for personnel and equipment. Hardware kit with handles and locking mechanism	Merging and guiding applications. Wheel assembly and mounting hardware.

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Electrical Controls - Comparison Chart

	 Push Button Stations	 Disconnect	 Motors	 Magnetic Starter	 Variable Speed Drive
Key Indicators for Typical Configuration					
Type	Push Button Stations	Safety Disconnect	Electrical Motors UPGRADE	Magnetic Starter	AC Variable Speed Drives
Ball Park Cost	\$100	\$100	\$150	\$550	\$1,100
Application	Start-Stop, Fwd-Rev-Stop, Up-Down-Stop	30 AMP, 3 Pole Disconnect	AC Motors w/ C-Face	Overload Protection Device	Programmable Electronic Speed Controller
Lead Time	24 Hour	24 Hour	24 Hour	24 Hour	24 Hour
Specifications					
Conveyor Models	All Powered Conveyors				
For Use With	110 V Control Voltage	Single or 3 Phase	110V, 200V, 208V, 230V, 460V, 575V	Single or 3 Phase	For use with 3 Phase Motors, Single or 3 Phase Controller Input
H.P.	—	—	1/2 thru 2	1/2 thru 2	1/2 thru 2

Curves - Comparison Chart

	 Roller Curve	 Skatewheel Curve	 V-Belt Curve	 Line Shaft Curve
Key Indicators for Typical Configuration				
Type	Non-powered gravity roller curve	Non-powered gravity skatewheel curve	V-Belt driven live roller curve	Line shaft driven live roller curve
Ball Park Cost	\$400	\$250	\$2,300	\$1,500
Application	Medium Duty	Light Duty	Medium Duty	Medium Duty
Lead Time	24 Hour / 1 Week	24 Hour / 1 Week	24 Hour / 1 Week	24 Hour
Specifications				
For Use With	Most conveyors	Most Light Duty conveyors	Most Powered conveyors	Line Shaft Driven conveyors (no drive included)
Degree Of Curve	90°, 60°, 45°, 30°	90°, 60°, 45°, 30°	90°	90°
Rollers / Wheels	Straight or Tapered Rollers	Skatewheels	Straight or Tapered Rollers	Straight or Tapered Rollers
Conveying Surface	Steel or Aluminum Rollers	Steel or Aluminum Rollers	Galvanized Steel Rollers	Galvanized Steel Rollers

Drive Configuration Options - Comparison Chart

						
Key Indicators for Typical Configuration						
Type	Power train mounted in the center of the conveyor length.	Power train mounted on the side of the conveyor.	Power train mounted above the conveyor surface.	Horizontal transition conveyor for Inclines/declines	Auxiliary belt take-up	Replaces power train with connection
Ball Park Cost	\$650	\$250	\$350	\$1,000	\$400	\$450
Application	Alternate to power trains located at the end of a conveyor	Alternate to power trains located beneath conveyor	Alternate to power trains located beneath conveyor	Transition conveyor for use with inclines and declines	Provides additional belt take-up on for longer belt conveyors	Allows one conveyor to share the power train of another.
Lead Time	24 Hour	1 Week	1 Week	24 Hour	1 Week	24 Hour / 1 Week
Specifications						
For Use With	Most Belt Conveyors	Most Powered Conveyors	Most Powered Conveyors	Most Belt Conveyors	Most Belt Conveyors	Most Belt Conveyors

Belting - Comparison Chart

						
Key Indicators for Typical Configuration						
Type	Ultimate 140 BOS Belt	Black Trackmate 533 COS-PVC	White Polymate 100 RMP-COS	Black Trackmate 120 COS-PVC	Brown Polymate Roughtop W/Nitrile Cover	Tan Glide Top Belt
Ball Park Cost	\$0/ft. add on	\$5/ft. add on	\$15/ft. add on	\$10/ft. add on	\$30/ft. add on	\$45/ft. add on
Application	General Purpose Package Handling	Applications where belt tracking may be difficult.	Meets FDA requirements and USDA acceptance	General purpose incline belt with gripping surface	High grip incline belts for harsh applications	Use when diverting products on and off the conveyor is required
Lead Time	24 Hour	24 Hour	24 Hour	24 Hour	24 Hour	24 Hour
Specifications						
For Use With	Standard on most horizontal slider bed and roller bed conveyors.	Most horizontal belt conveyors. Good resistance against abrasion and abuse.	Most horizontal belt conveyors. General food applications like canning or packing lines	Standard on most incline and decline conveyors.	Most incline/decline conveyors where angle is great or product is wet	Most horizontal belt conveyors. Nylon top is low friction, abrasive resistant surface.

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