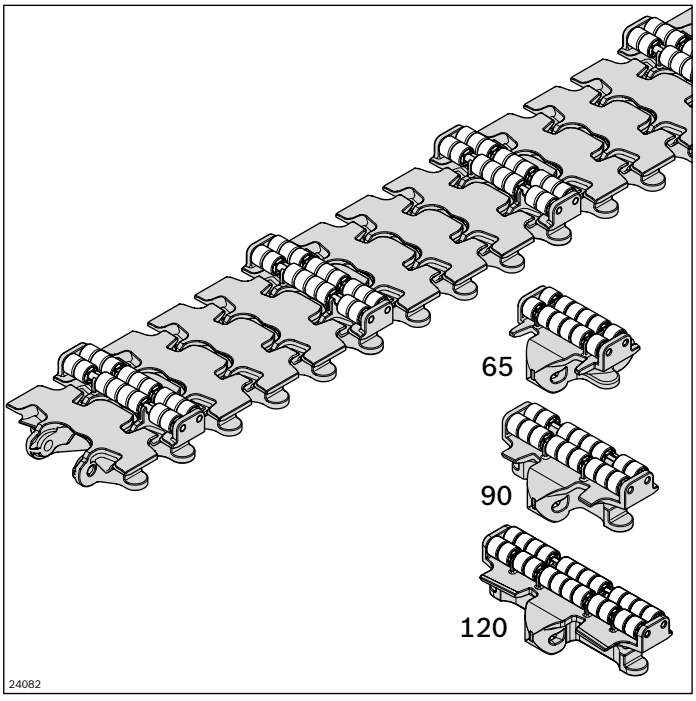
Accumulation roller chain D11, Roller cleat chain D11



The accumulation roller chain D11 (AZ = 1) enables the surface-protecting and exclusively horizontal transport of sensitive products, even in accumulation operation.
Its use as a roller cleat chain (AZ ≥ 2) enables the vertical transport of small products. See also “Layout instructions for roller cleat chains”, on page 34

- The maximum gradient when using cleats depends on the product geometry (test required)
- Accumulation operation permitted when used as an accumulation roller chain (AZ = 1)
  Accumulation operation not permitted when used as a roller cleat chain (AZ ≥ 2)
- Maximum chain tensile force: 1250 N
- AZ ≥ 2: Roller cleat chain supplemented with flat chain links (AZ = spacing distance) AZ = 1: continuous accumulation roller chain
- Product length for use with the accumulation roller chain: ≧ 70 mm

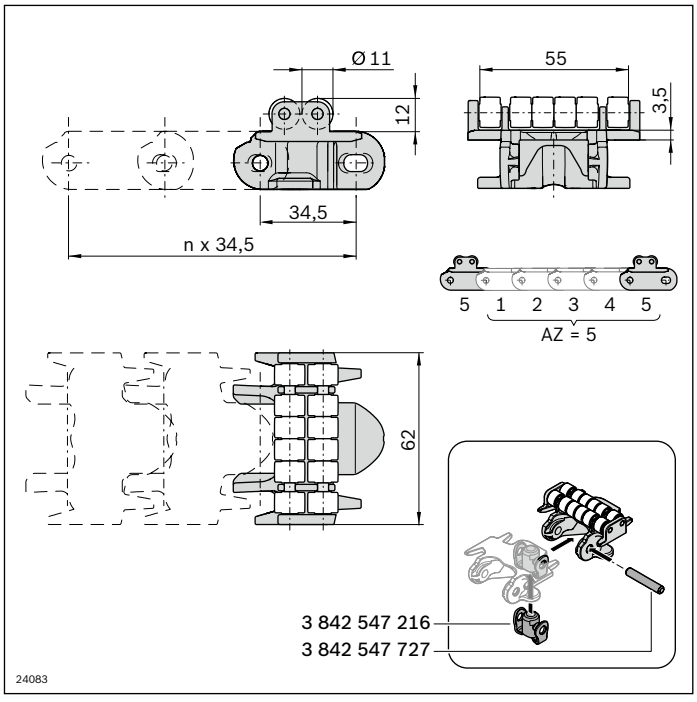
- ▶ Extremely quiet chain running thanks to the patented chain design
- ▶ Materials meet the requirements of EU 10/2011 and FDA CFR 21

Required accessories for individual chain links:
Chain pin and jointed bolts, see page 28

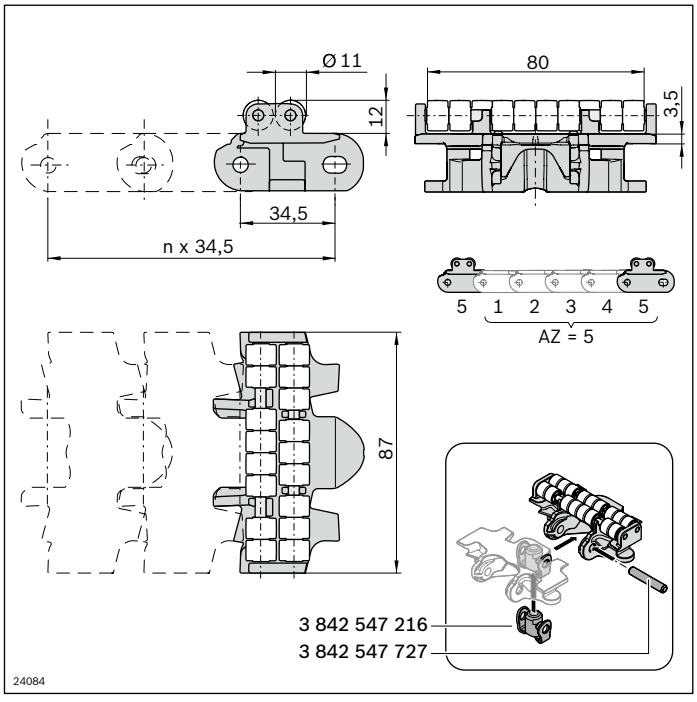
Scope of delivery:
Chain: Complete, incl. chain pin and jointed bolts

Condition on delivery:
Chain: Fully assembled

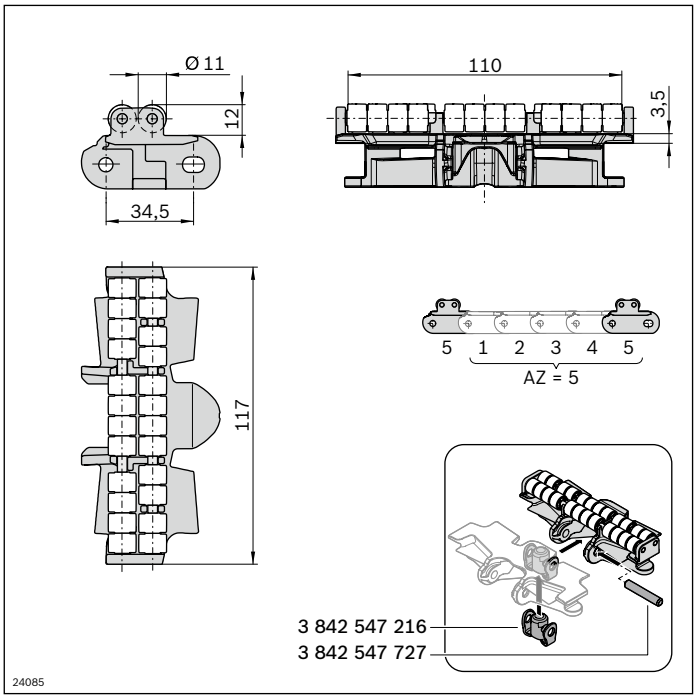
Material:
- Chain link: POM
- Roller: POM
- Chain pin: Stainless steel, 1.4301
- Jointed bolts: PA66



Accumulation roller chain D11 VF*plus* 65	**L** (mm)		**No.**
Conveyor chain; AZ = 1	2898	1	**3 842 546 083**
Conveyor chain; AZ = 2 ... 84	2898	1	**3 842 998 717/AZ**
Chain link		10	**3 842 546 017**
Chain pin		100	**3 842 547 727**
Swivel pin		100	**3 842 547 216**



Accumulation roller chain D11 VF*plus* 90	**L** (mm)		**No.**
Conveyor chain; AZ = 1	2898	1	**3 842 546 084**
Conveyor chain; AZ = 2 ... 84	2898	1	**3 842 998 718/AZ**
Chain link		10	**3 842 546 018**
Chain pin		100	**3 842 547 727**
Swivel pin		100	**3 842 547 216**



Accumulation roller chain D11 VF*plus* 120	**L** (mm)		**No.**
Conveyor chain; AZ = 1	2898	1	**3 842 546 085**
Conveyor chain; AZ = 2 ... 84	2898	1	**3 842 998 719/AZ**
Chain link		10	**3 842 546 019**
Chain pin		100	**3 842 547 727**
Swivel pin		100	**3 842 547 216**

Layout instructions for roller cleat chains

Fig. A

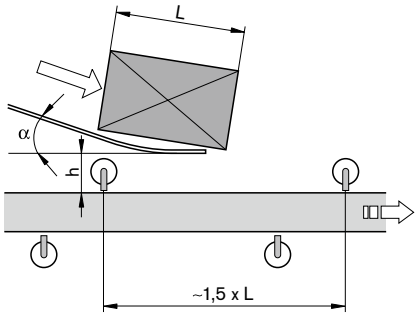


Fig. B

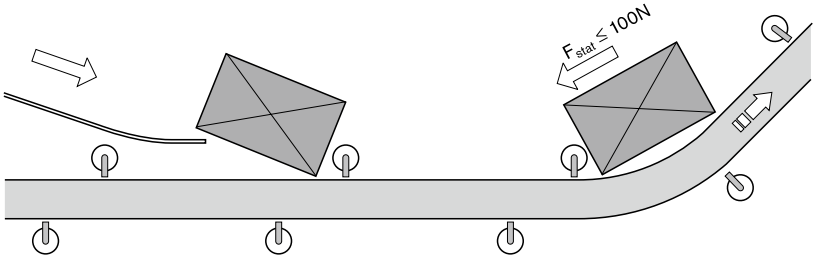


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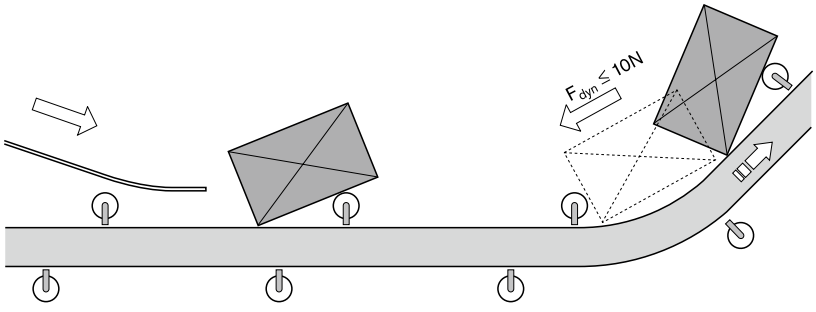
Fig. C



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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.