



Re-Flow Accumulation Table Specifications

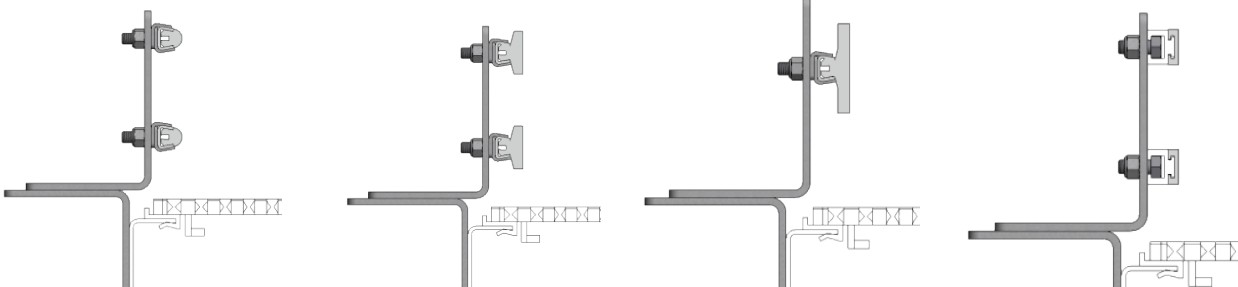
Complete Conveyor Systems and Equipment

Standard Equipment Specifications

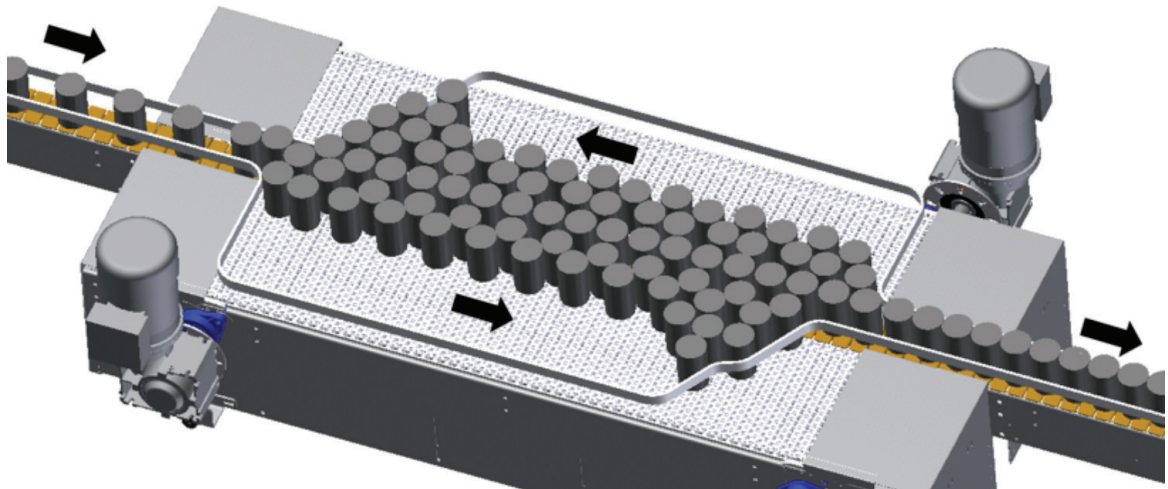
| Frame | Material | Material Thickness | Finish |
|-------|-----------------|--------------------|-------------------------------------|
| | Mild Steel | 12 GA | "Stardust Silver" powder coat paint |
| | Stainless Steel | 12 GA | #4 polish finish |

| Standard Modules | Parts |
|------------------|--|
| | <ul style="list-style-type: none"> • 30" Drive end <ul style="list-style-type: none"> ▶ Shaft mount ▶ Below mount • Intermediates <ul style="list-style-type: none"> ▶ 12", 36", 60" long |

| Product | Types | Product Rate |
|---------|---|----------------------|
| | <ul style="list-style-type: none"> • Bottles • Jars • Pucks • Cans • PET | Maximum rate: 175ppm |

| Guide Rail | Standard Configurations (Illustrated below) | Optional Configurations |
|---|--|--|
| | <ul style="list-style-type: none"> • Single high • Double high | <ul style="list-style-type: none"> • Sheet rail • UHMW |
|  | | |
| <p>VG-SSR Round Face VG-SST 1.25" T- Face VG-SST 2.25" T- Face Aluminum Channel w/UHMW Cover</p> | | |

| Motor/Reducer | Brand/Style | Voltage | Body Frame | Mounting | Options |
|---------------|--|-----------|---------------|--------------------------------|--------------------|
| | Marathon <ul style="list-style-type: none"> • Inverter duty • IP43 rated | 230/460-3 | Painted steel | "C" face | Washdown - painted |
| | Grove <ul style="list-style-type: none"> • Hollow bore reducer | N/A | Painted cast | Vertical shaft with torque arm | Washdown duty |



Standard Equipment Specifications

| Speed | Standard Nominal (FPM) | Minimum | Maximum |
|----------|--|--|--|
| | <ul style="list-style-type: none"> • 40 • 125 • 60 • 170 • 95 | 8 FPM* | 250 FPM* |
| | | *Speed obtained using a VFD (12Hz to 75Hz) | *Speed obtained using a VFD (12Hz to 75Hz) |
| Chain | Types | Width | Features |
| | Outside <ul style="list-style-type: none"> • Rexnord 8505 PSX | <ul style="list-style-type: none"> • 18" • 24" • 30" | <ul style="list-style-type: none"> • PSX material offers consistent low co-efficient of friction • High strength |
| | Center <ul style="list-style-type: none"> • Rexnord 879 tab PSX | <ul style="list-style-type: none"> • 3¼" • 4½" | <ul style="list-style-type: none"> • PSX material offers consistent low co-efficient of friction • High strength |
| Supports | Standard Configuration | | Optional |
| | 2" x 2" formed angle with bolt pad base <ul style="list-style-type: none"> • 22" - 50" elevation | | <ul style="list-style-type: none"> • 3" Heavy duty channel • Square tube supports |
| Bearings | Construction | Finish | Options |
| | 2 Hole | <ul style="list-style-type: none"> • Painted • Sealed for life • Food grad lube | <ul style="list-style-type: none"> • Polymer housing with stainless steel inserts • Safety covers |

Maintenance Information

1. Pre-Start Checklist

- Fasteners - Some may have loosened during shipment. Re-tighten as required
- Inspect all splice points for proper alignment
- Verify motor rotation and chain direction is correct
- Check for proper product clearance prior to operation
- Roller transfers decline ½" in direction of flow to self clear

2. Start-up/Break-in

- Monitor the following daily during the first 250 hours of operation
 - ▶ Initial chain stretch - Assess chain length and remove excess links

3. Control Basics

- Variable Frequency Drive (VFD) required for a "soft" start (5 second ramp)

4. Maintenance

- Replace chain when 80 links > 123" or 40 links > 61.5"
 - ▶ Be sure to release chain tension in take-ups when removed links
 - ▶ Chain must be disconnected at either a drive or idle sprocket area
- Look for excessive wear or hooked teeth in sprocket
- Check for leaking seals in bearings and reducers
- Examine wearstrip for disproportionate wear
- Chain surging (slip \ stick) is a hard to predict phenomenon that depends on speed, load, construction, and lubrication
 - ▶ Poses no operational concerns unless it causes product tipping
 - ▶ Look for chain binding at turns in both carryway and return
- Motor hop & wobble is natural and desirable
 - ▶ Poses no operation concerns for conveyor or reducer
 - ▶ Wobble releases stress build up due to normal machining tolerances in rotating shaft
 - ▶ Increases equipment longevity compared to rigidly mounted reducers where misalignments are trapped

NERCON WARRANTY

NERCON will repair or replace any products that have failed under normal use due to faulty material or defective workmanship for 1 year. Motors and chain carry the manufacturer's warranty. No other warranty is expressed or implied unless otherwise set forth in writing and approved by representative duly authorized to extend such approval by NERCON. All rights of design and invention are reserved.

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