

Chain Conveyors



Contents chain conveyors



Selecting the conveyor system **170**



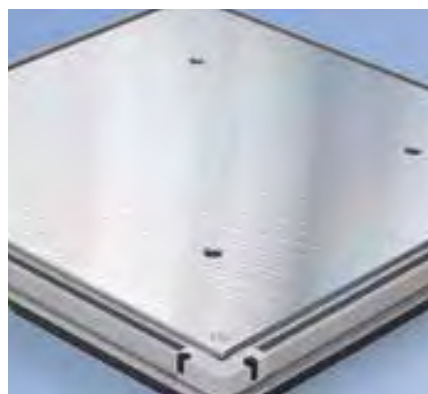
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Chain Conveyors

Selecting the conveyor system

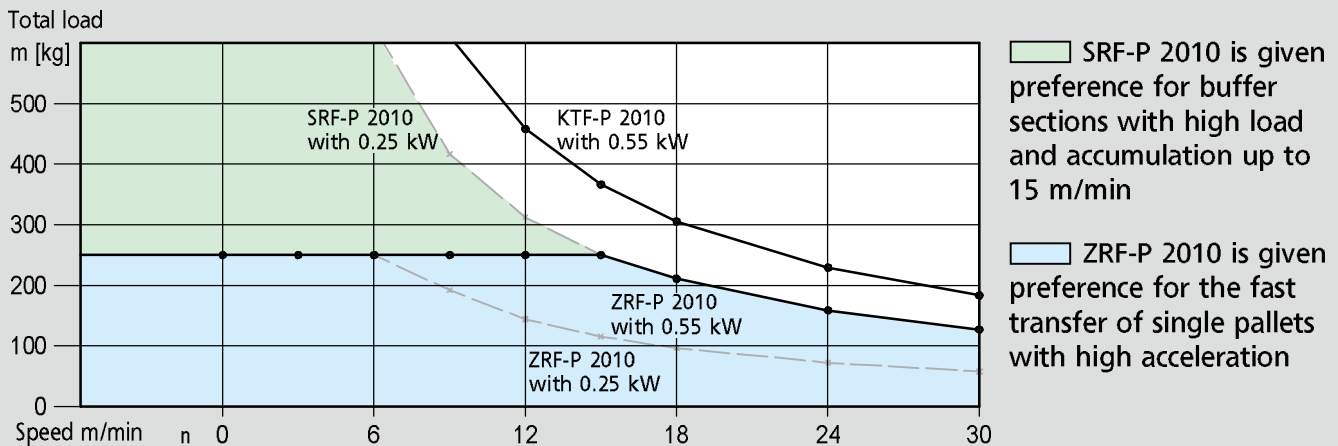
Dimensions – technical information

Conveyor system	Conveyor width [mm]	Conveyor length [mm]	Total load* usually to [kg]	Speed to [m/min]	Tail ø [mm]	Reversing operation	Accumulated operation	Cycle operation
Chain conveyors								
KTF-P 2010	200-2000	500-10000	1000	30	app. 90	•	•	•
Accumulation roller chain conveyors								
SRF-P 2010	200-2000	500-10000	750	30	app. 90	•	•	•
SRF-P 2012	200-2000	1000-10000	1000	30	app. 90	•	•	•

*Maximum load that is transported by the respective system with a usual configuration and for a usual application. The permissible load depends on the width, chain type, as well as load distribution, operating mode, and environmental influences.

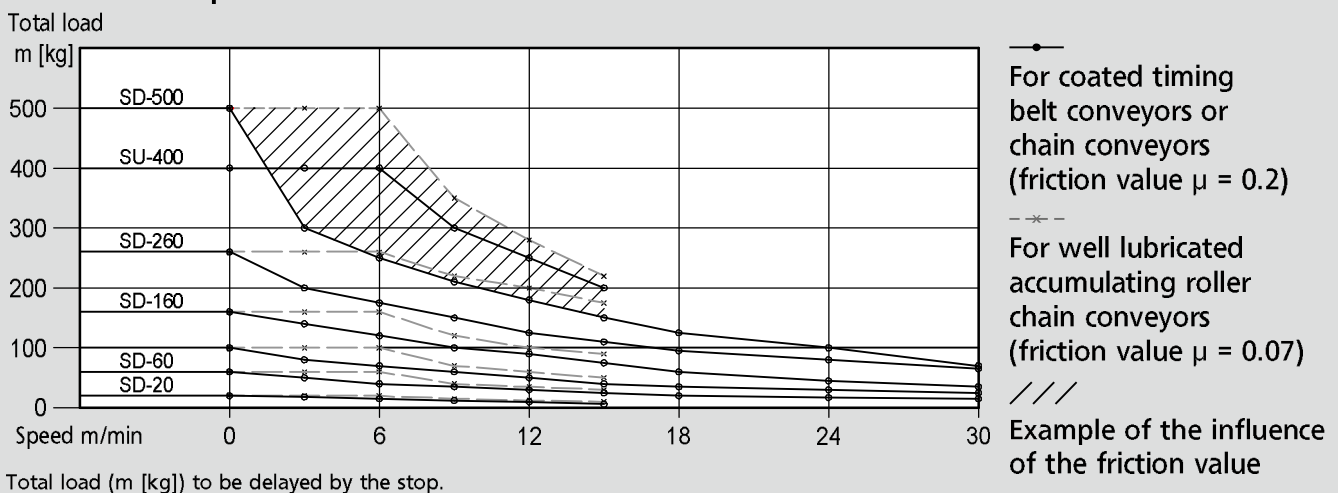
Selection of the dual-strand conveyor based on load and speed

The diagram shows dual-strand conveyor systems depending on load and speed. The comparison shows timing belt conveyors (ZRF), chain conveyors (KTF), and accumulation roller chain conveyors (SRF).



Total load m [kg] per conveyor section, per drive in continuous operation (accumulated operation $m_{Acc} = 2 \times m_{Cont}$)

Selection of stops



Total load (m [kg]) to be delayed by the stop.

Application areas

Chain conveyors are ideally suited for indexed transportation of products. Available with different drive options, they are often used for setting up complex interlinked solutions. Typical applications are the transfer of pallets in two-strand applications for high loads at moderate speeds. For high speeds or positioning tasks, low maintenance, and low-noise timing belt conveyors are used, (see the graphic on the left and the previous chapter). Various chains, in conjunction with our robust and solidly designed wear strips, allow for conveyor systems to be ideally matched to the application.

The **KTF-P 2010 chain conveyor** is primarily used as the basic element for setting up transfer sections. The system is available as a single-strand, dual-strand, or multiple-strand system, with a single roller chain or with duplex roller chain for greater load capacity and more support area.

The **SRF-P 2010 accumulating roller chain conveyor** is also constructed from the mk 2010 profile and is suitable for accumulated operation. Thus the conveyor is ideal for buffering between workstations. Additionally, like all chain conveyors, the system can be equipped with a tensioning station and a continuous lubrication station.

Our **SRF-P 2012 accumulating roller chain conveyor** is for a higher load range (up to 1000 kg) and is designed so that even in accumulated operation the conveyor runs very quietly. The accumulation force is kept to a minimum. Typical applications are the integration of workstations, or buffering between workstations and assembly stations.

Chains

The chains used (see from page 202) are available in different versions to ensure optimal performance in accordance with the customer requirement. In the standard product range, a single roller chain and a duplex roller chain are included. The duplex chain can convey higher loads and offers a larger support surface.

For accumulated operation, accumulating roller chains are available with either plastic rollers or steel rollers. Plastic rollers are quieter and require less maintenance than do steel rollers, however they are not suitable for environments with continuous temperatures above 60°C, or for paint shop or Atex applications. When using steel rollers, it must be ensured that for the pallets to be conveyed, plastic slide strips (PE or POM) are attached on the contact surfaces.

The accumulating roller chain is available with the rollers inline, one behind the other (more robust and with higher fracture strength) or with accumulating rollers offset. The offset rollers offer more contact points and thus quieter operation, and a higher maximum section load. Optionally these chains can be provided with finger-guards.

Unlike the timing belt, chains always require good lubrication. They can be used to 60°C, or to 140°F. Higher temperatures are available upon request. Low-maintenance chains are available as an option.

Chain Conveyors KTF-P 2010



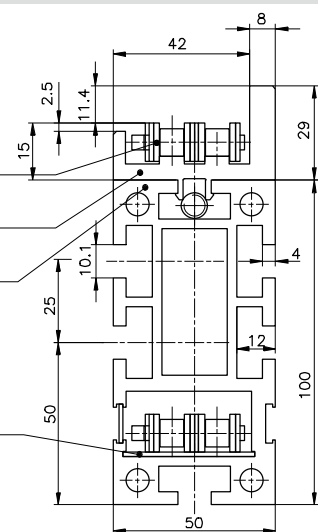
Conveyor frame cross-section

Chain K11416

Wear strip mk 1034

Profile for conveyor frame mk 2010

Wear strip mk 1014





Chain Conveyor System KTF-P 2010 is designed for the transport of heavy pallets. The different chain and wear strip options make for an extremely low-maintenance and robust conveyor. The wear strips have a low coefficient of friction, and provide good wear

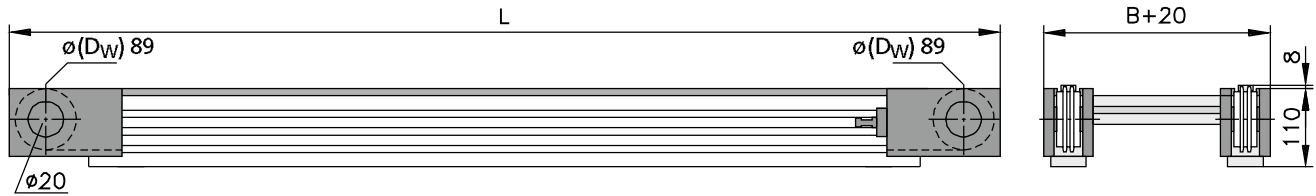
resistance over a broad temperature range (continuous to 65° C, or 149° F). Another design feature is the chain return, which occurs within the frame profile itself. T-slots are accessible on three sides on the profile frame for the attachment of stands, side rails, sensors and

stops (10 mm opening). In combination with the wide and varied drive options, System KTF-P 2010 serves as a key element for the manufacture of larger automation and material handling systems.

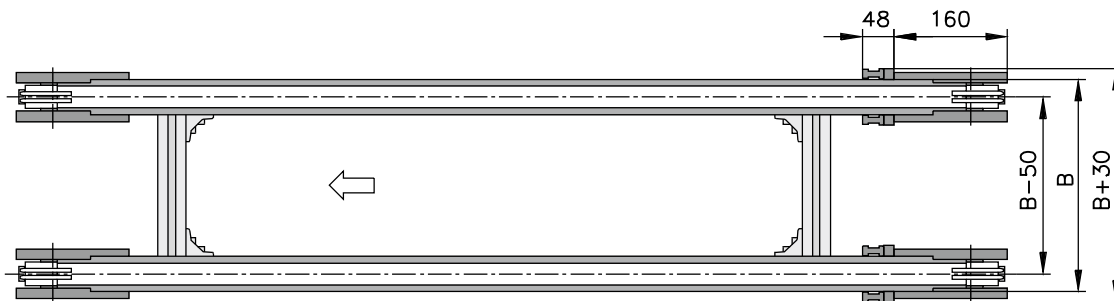
KTF-P 2010 AA

Chain conveyor with head drive without motor

B20.10.450



Wear strip options see page 181



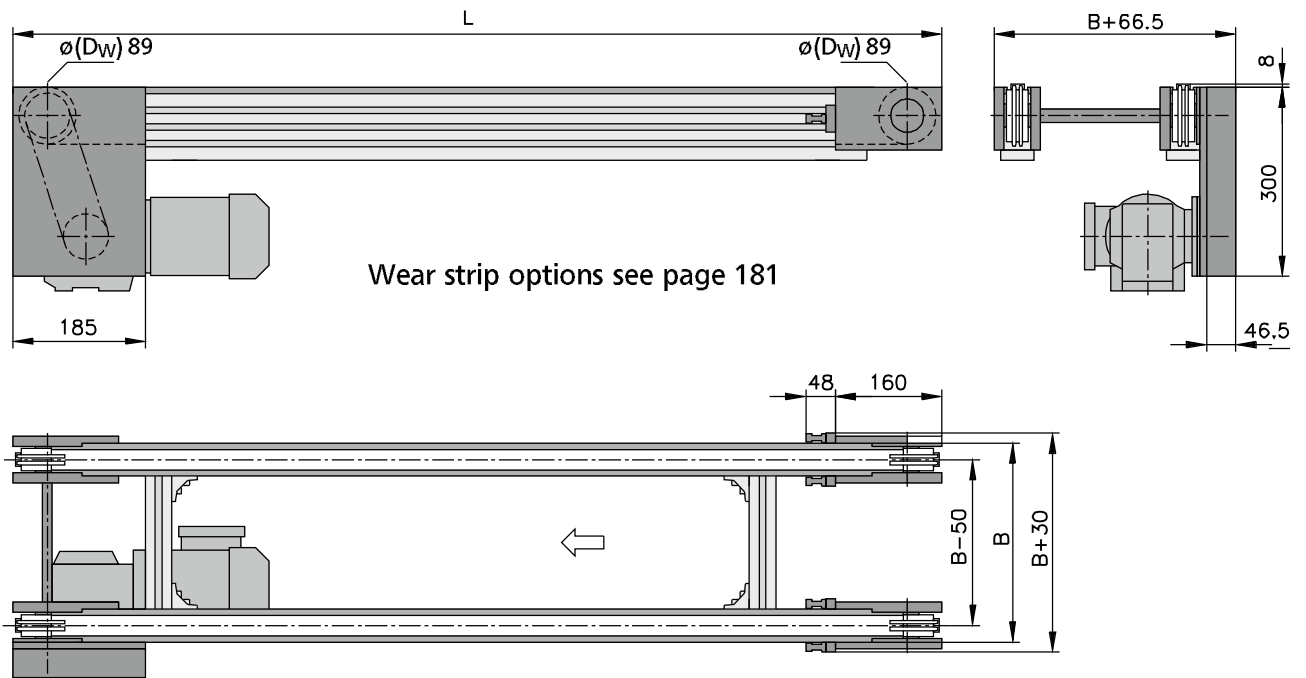
Drive option AA, offers the advantage of operating multiple conveyor strands in parallel or in series with one drive. Depending on the requirement, the conveyor is designed either with a hollow shaft or with a connecting shaft with shaft journal ($\phi 20$ mm, usable length 34 mm, incl. feather key DIN 6885) Use of attachment chain is not possible with this drive version.

	Dimensions – technical information	Notes
Conveyor length L	between 500-10000 mm	any increment possible
Conveyor width B	200 to 2000 mm	
Chain	1/2" single or dual strand	see from page 202
Drive location	discharge side left/right	
Drive and speed	to 30 m/min (100 ft/min)	see chart on page 12
Stands and side rails		see from page 262
Load capacity	total load to 1000 kg (2200 lbs) section load to 150 kg/m (with duplex chain)	higher on request

KTF-P 2010 AC

Chain conveyor with head drive, standard

B20.10.453



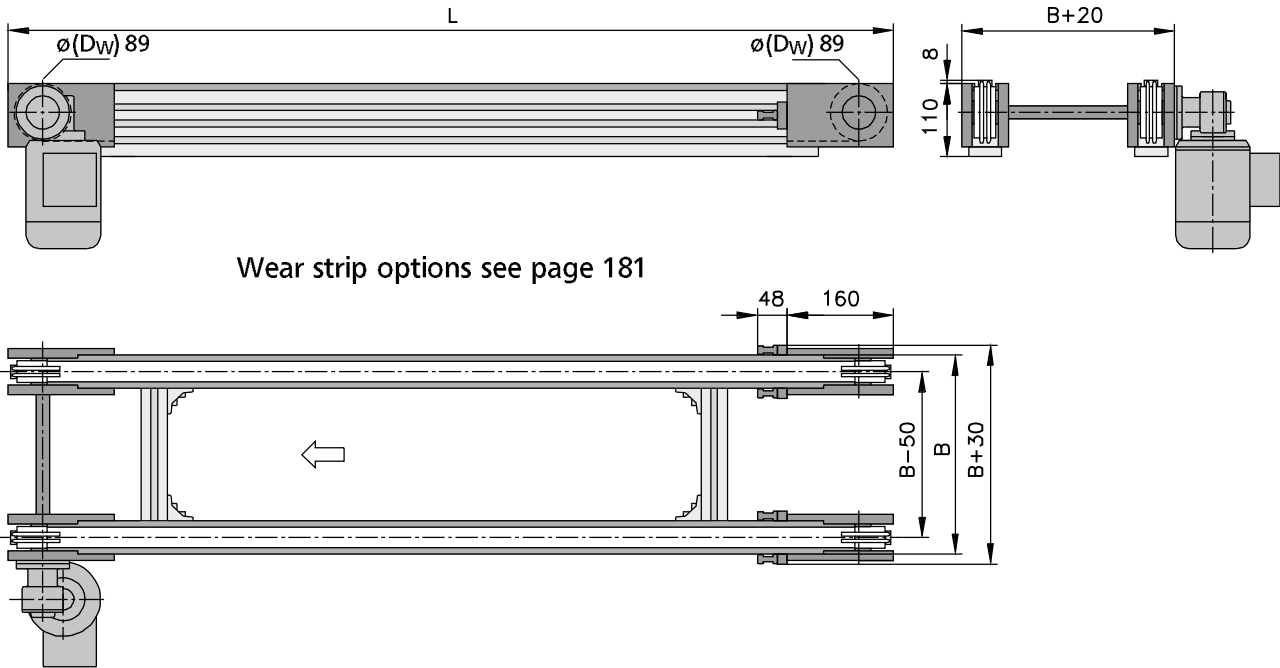
The sprocket ensures outstanding transmission of the motor power. Use of attachment chain is not possible with this drive version.

	Dimensions – technical information	Notes
Conveyor length L	between 500-10000 mm	any increment possible
Conveyor width B	200 to 2000 mm	
Chain	1/2" single or dual strand	see from page 202
Drive location	discharge side left/right below	
Drive and speed	to 30 m/min (100 ft/min)	see chart on page 12
Stands and side rails		see from page 262
Load capacity	total load to 1000 kg (2200 lbs) section load to 150 kg/m (with duplex chain)	higher on request

KTF-P 2010 AF

Chain conveyor with head drive, direct

B20.10.459



Wear strip options see page 181

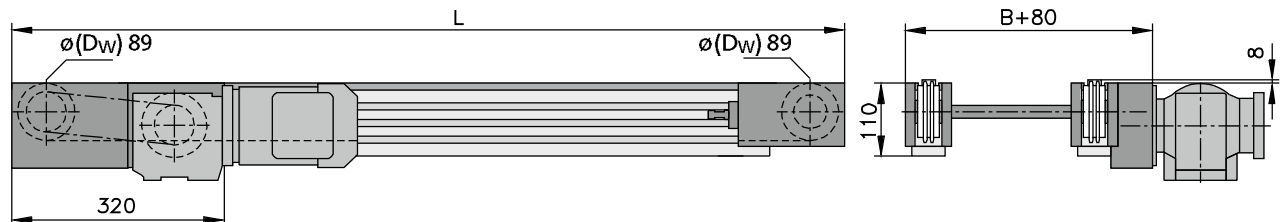
By placing the motor directly onto the drive shaft, this drive version minimizes not only the space required at the drive but also the number of moving parts and maintenance requirements. Use of attachment chain is not possible with this drive version.

	Dimensions – technical information	Notes
Conveyor length L	between 500-10000 mm	any increment possible
Conveyor width B	200 to 2000 mm	
Chain	1/2" single or dual strand	see from page 202
Drive location	discharge side left/right below	
Drive and speed	to 30 m/min (100 ft/min)	see chart on page 12
Stands and side rails		see from page 262
Load capacity	total load to 1000 kg (2200 lbs) section load to 150 kg/m (with duplex chain)	higher on request

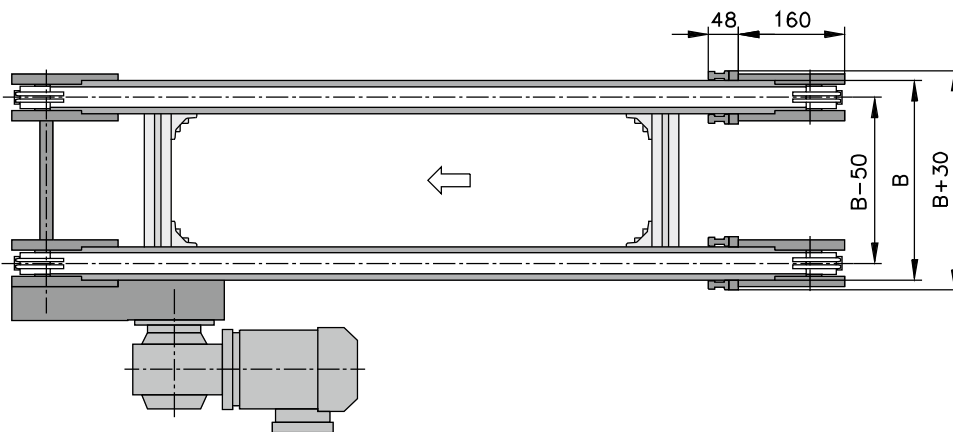
KTF-P 2010 AS

Chain conveyor with head drive, outside

B20.10.457



Wear strip options see page 181



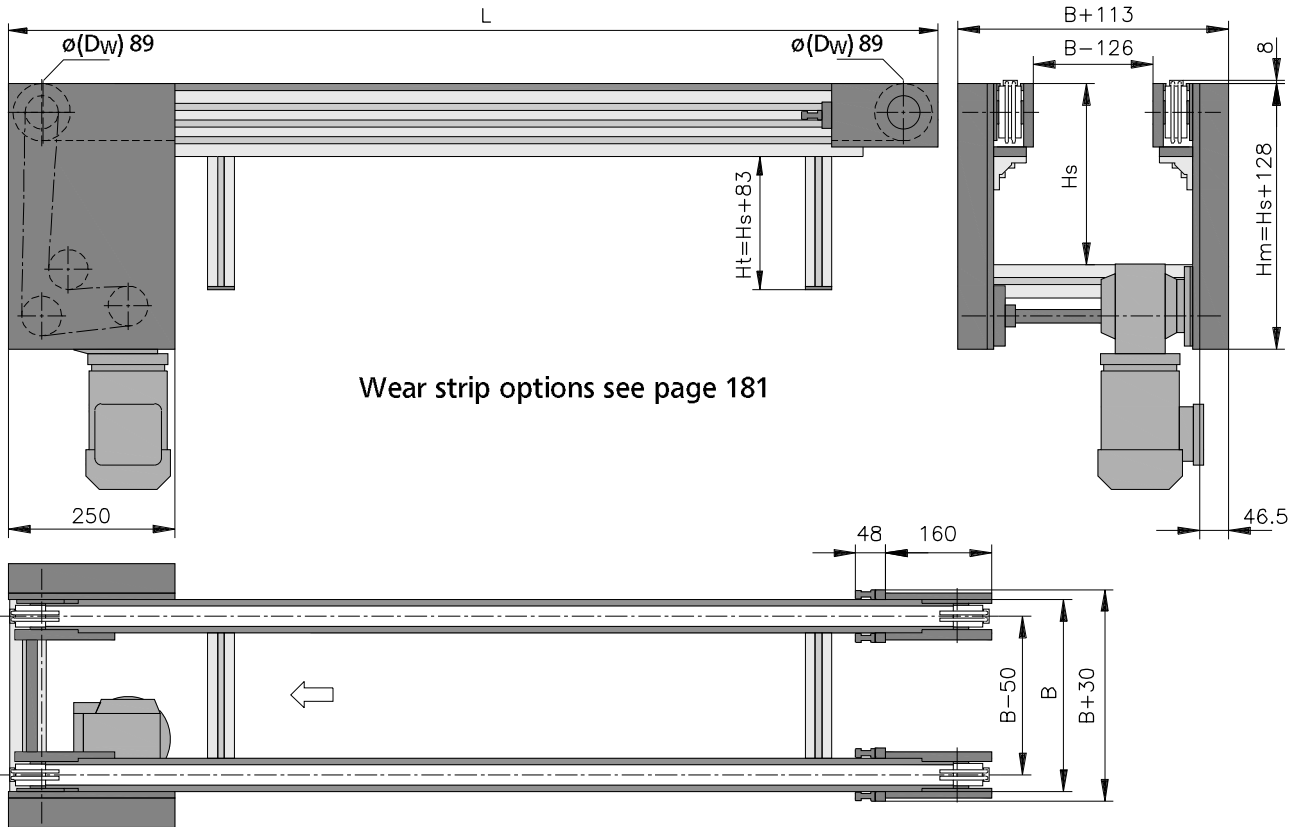
The overall height of the drive assembly is held to an absolute minimum. Use of attachment chain is not possible with this drive version.

	Dimensions – technical information	Notes
Conveyor length L	between 700-10000 mm	any increment possible
Conveyor width B	200 to 2000 mm	
Chain	1/2" single or dual strand	see from page 202
Drive location	discharge side left/right	
Drive and speed	to 30 m/min (100 ft/min)	see chart on page 12
Stands and side rails		see from page 262
Load capacity	total load to 1000 kg (2200 lbs) section load to 150 kg/m (with duplex chain)	higher on request

KTF-P 2010 AQ

Chain Conveyor with head drive, dual-strand

B20.10.456



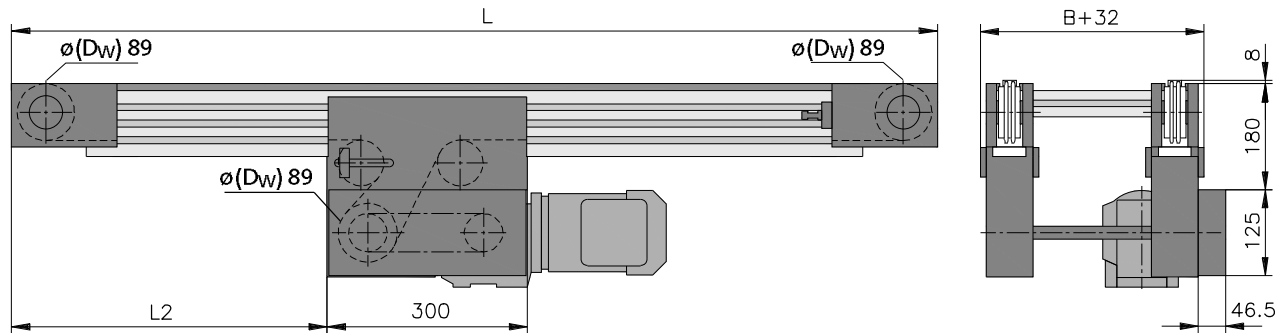
In principle, the drive concept of the AQ version is the same as for the AC version. However, this drive is used when the goods to be transported, or the pallets, require a free space between the conveyor lanes. Use of attachment chain is not possible with this drive version.

	Dimensions – technical information	Notes
Conveyor length L	between 500-10000 mm	any increment possible
Conveyor width B	200 to 2000 mm	
Chain	1/2" single or dual strand	see from page 202
Drive location	discharge side left/right below	
Drive and speed	to 30 m/min (100 ft/min)	see chart on page 12
Stands and side rails		see from page 262
Load capacity	total load to 1000 kg (2200 lbs) section load to 150 kg/m (with duplex chain)	higher on request

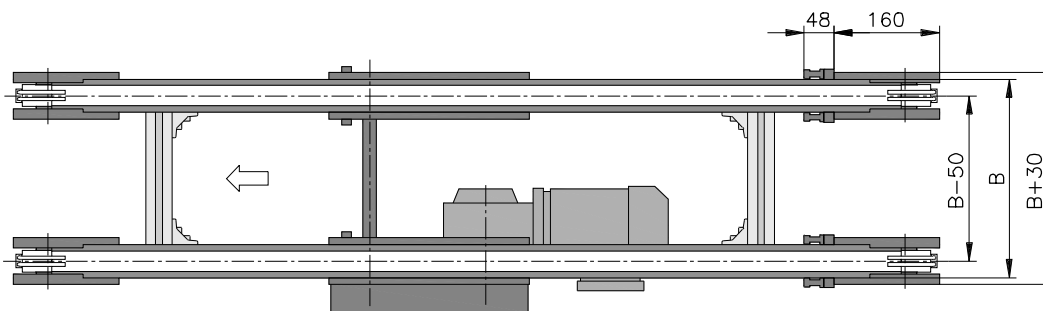
KTF-P 2010 BC

Chain Conveyor with center drive, standard

B20.10.458



Wear strip options see page 181



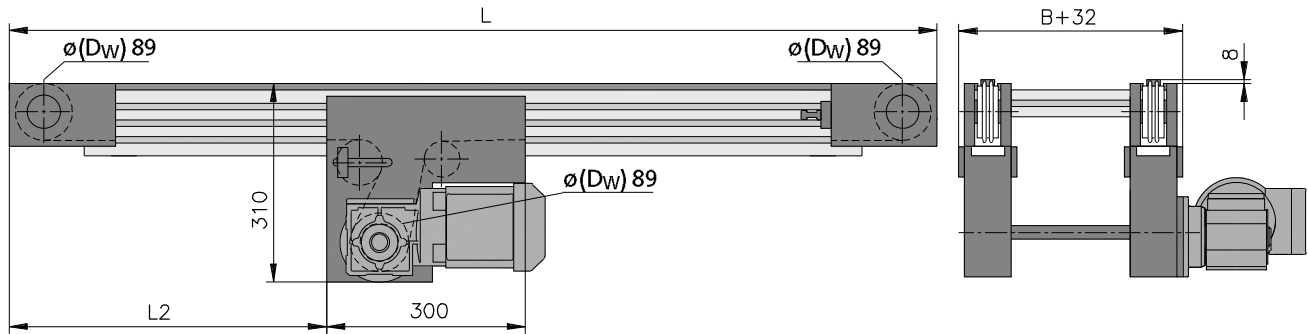
The compact design, and the ability to place the drive location anywhere along the conveyor frame (during manufacture), simplifies the integration of this conveyor into new or existing equipment. Use of attachment chain is not possible with this drive version.

	Dimensions – technical information	Notes
Conveyor length L	between 700-10000 mm	any increment possible
Conveyor width B	200 to 2000 mm	
Chain	1/2" single or dual strand	see from page 202
Drive location	left/right below	
Drive and speed	to 30 m/min (100 ft/min)	see chart on page 12
Stands and side rails		see from page 262
Load capacity	total load to 1000 kg (2200 lbs) section load to 150 kg/m (with duplex chain)	higher on request

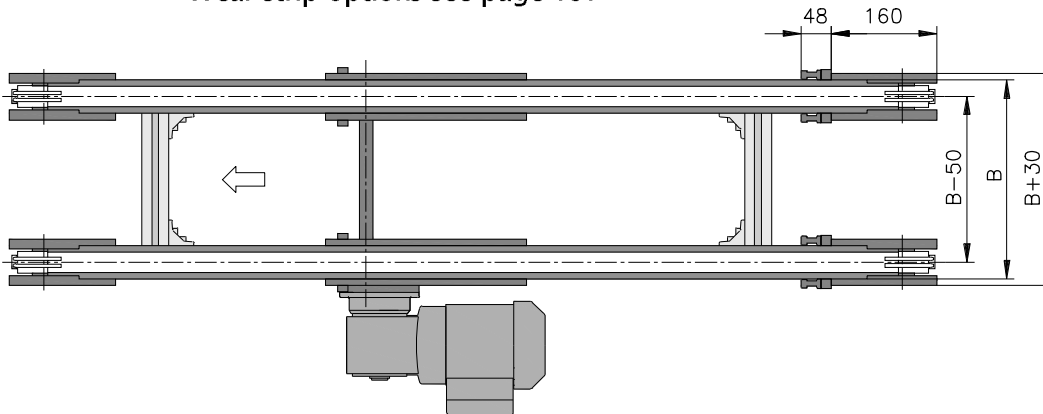
KTF-P 2010 BF

Chain Conveyor with center drive, direct

B20.10.461



Wear strip options see page 181



Thanks to the motor mounted directly on the drive shaft, this drive version keeps spatial requirements and maintenance efforts to a minimum. The compact conveyor frame and the possibility of freely selecting the drive position (during manufacture) over the entire length of the conveyor, facilitates integration of the conveyor in existing systems. The travel direction is reversible. Use of attachment chain is not possible with this drive version.

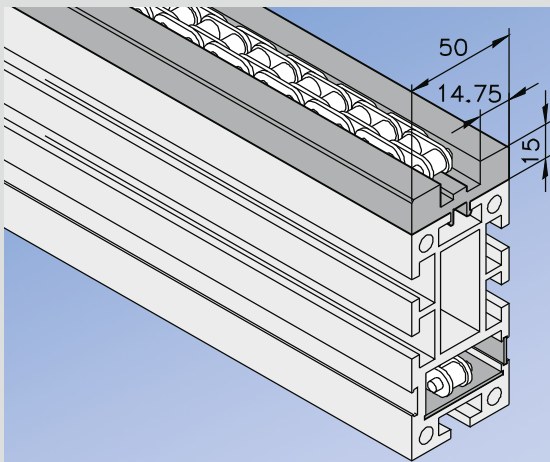
	Dimensions – technical information	Notes
Conveyor length L	between 700-10000 mm	any increment possible
Conveyor width B	200 to 2000 mm	
Chain	1/2" single or dual strand	see from page 202
Drive location	left/right below	
Drive and speed	5; 6,3; 8; 9,5; 11,5; 13,5; 15,2; 19,3; 23; 26; 36,6; 45,7 and 57 m/min	see chart on page 12
Stands and side rails		see from page 262
Load capacity	total load to 1000 kg (2200 lbs) section load to 150 kg/m (with duplex chain)	higher on request

KTF-P 2010

Wear strips

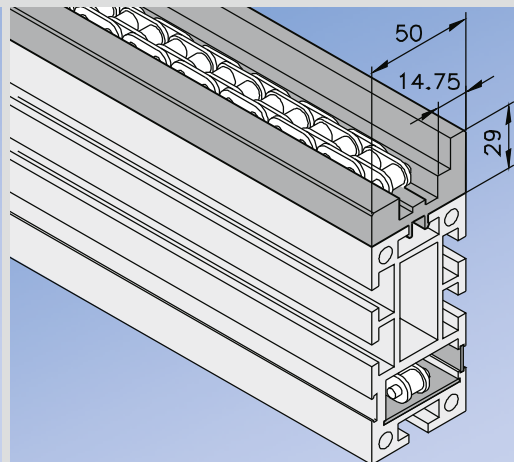
mk guide and wear strips feature low friction and high wear resistance.
The wear strips are made of PE-UHMW (PE-1000). Temperature maximum is 65° C (149° F).

Option A



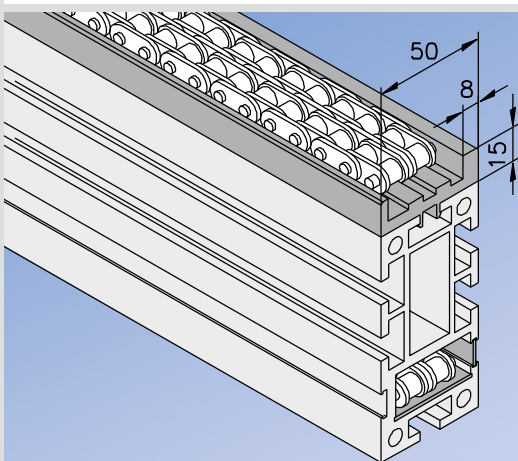
Wear strip above mk 1037, 22.37.2000
Wear strip below 21.14.0001
Closure strip K10230/12

Option B



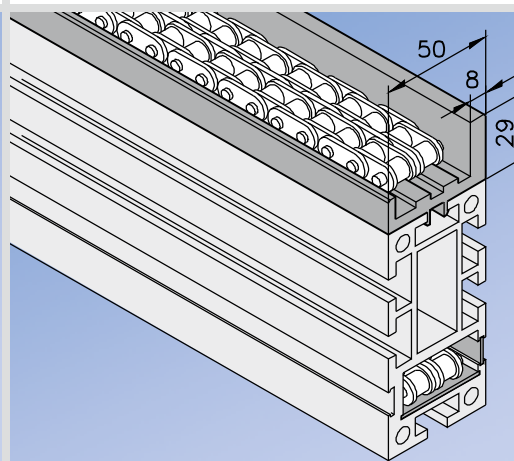
Wear strip above mk 1038, 22.38.2000
Wear strip below 21.14.0001
Closure strip K10230/12

Option C



Wear strip above mk 1033, 22.33.2000
Wear strip below 21.14.0001
Closure strip K10230/12

Option D

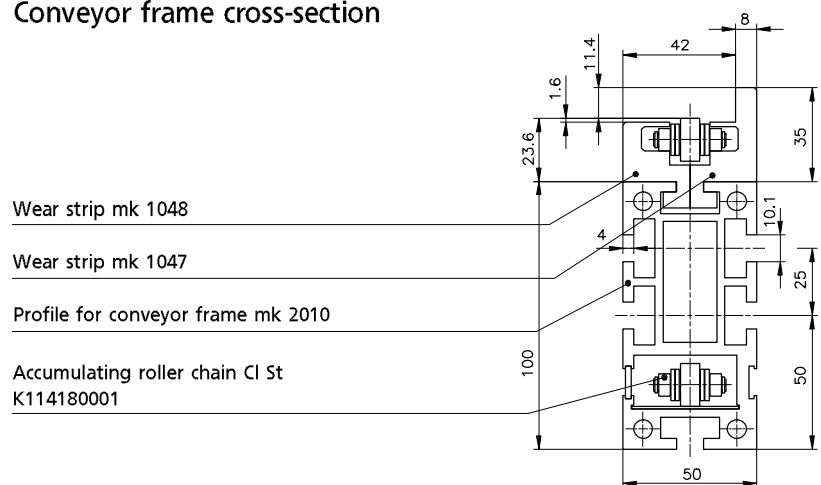


Wear strip above mk 1034, 22.34.2000
Wear strip below 21.14.0001
Closure strip K10230/12

Chain Conveyors SRF-P 2010



Conveyor frame cross-section





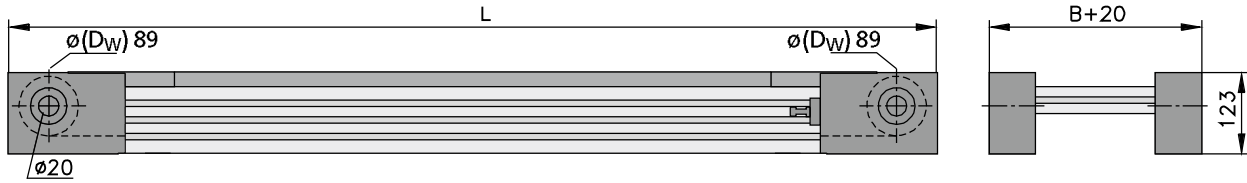
Accumulating roller chain conveyor SRF-P 2010 is designed for the transport and accumulation of loads up to 750 kg (1,650 lbs). As pallets travel on the large idler rollers, the conveyor is very quiet even in accumulation zones. The force required to hold accumulating pallets is minimal. Typical applications include product

transfer between workstation or accumulation of products between processes. Entire handling systems can be designed using this conveyor system. T-slots are accessible on three sides on the profile frame for the attachment of stands, side rails, sensors and stops (10 mm opening).

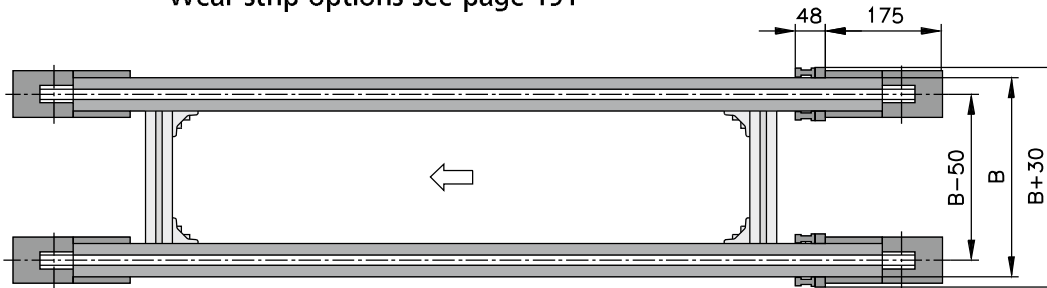
SRF-P 2010 AA

Accumulating roller chain conveyor with head drive, without motor

B20.10.554



Wear strip options see page 191



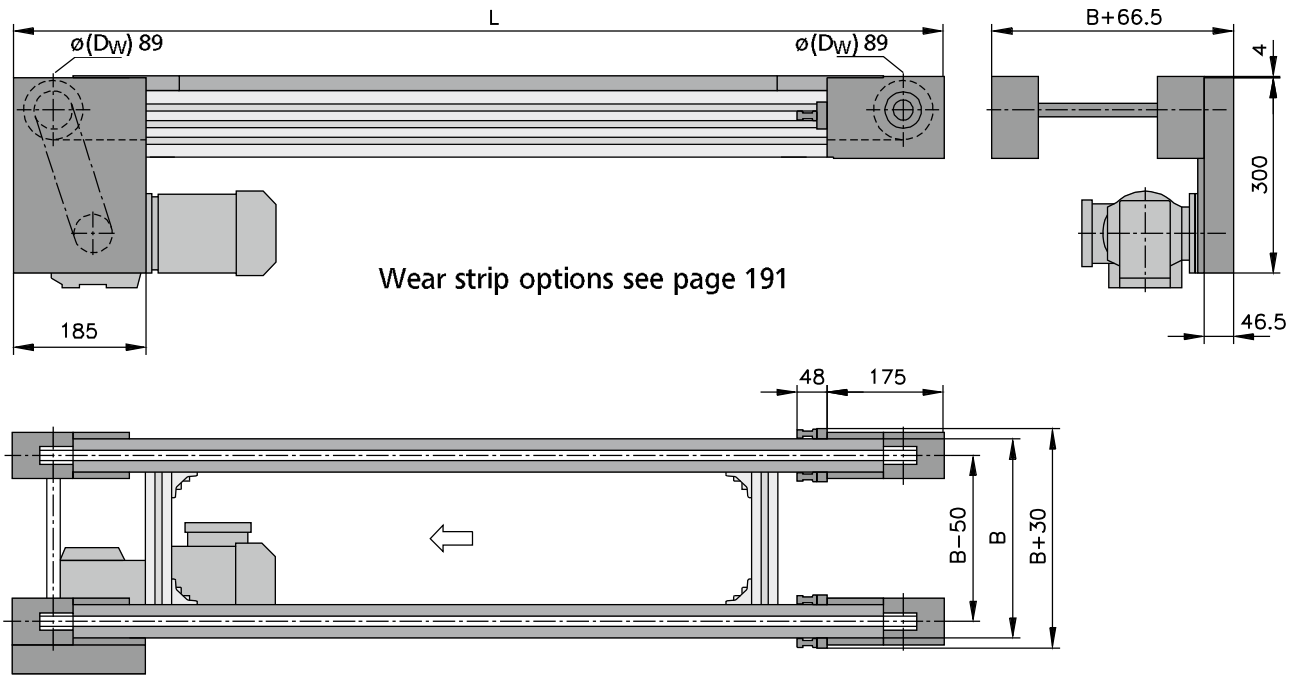
Drive version AA is primarily used where multiple lanes are to be slave driven, either parallel or in-line, using a single drive motor. Depending on the requirement, the conveyor is designed either with a hollow shaft or with a connecting shaft with shaft journal ($\phi 20$ mm, usable length 34 mm, incl. feather key DIN 6885).

	Dimensions – technical information	Notes
Conveyor length L	between 500-10000 mm	any increment possible
Conveyor width B	200 to 2000 mm	
Chain	accumulating roller chain 1/2" with plastic or steel roller	see from page 202
Drive and speed	to 30 m/min (100 ft/min)	see chart on page 12
Stands and side rails		see from page 262
Load capacity	total load to 750 kg (1650 lbs) section load to 100 kg/m (in series) section load to 150 kg/m (offset)	higher on request

SRF-P 2010 AC

Accumulating roller chain conveyor with head drive, standard

B20.10.555



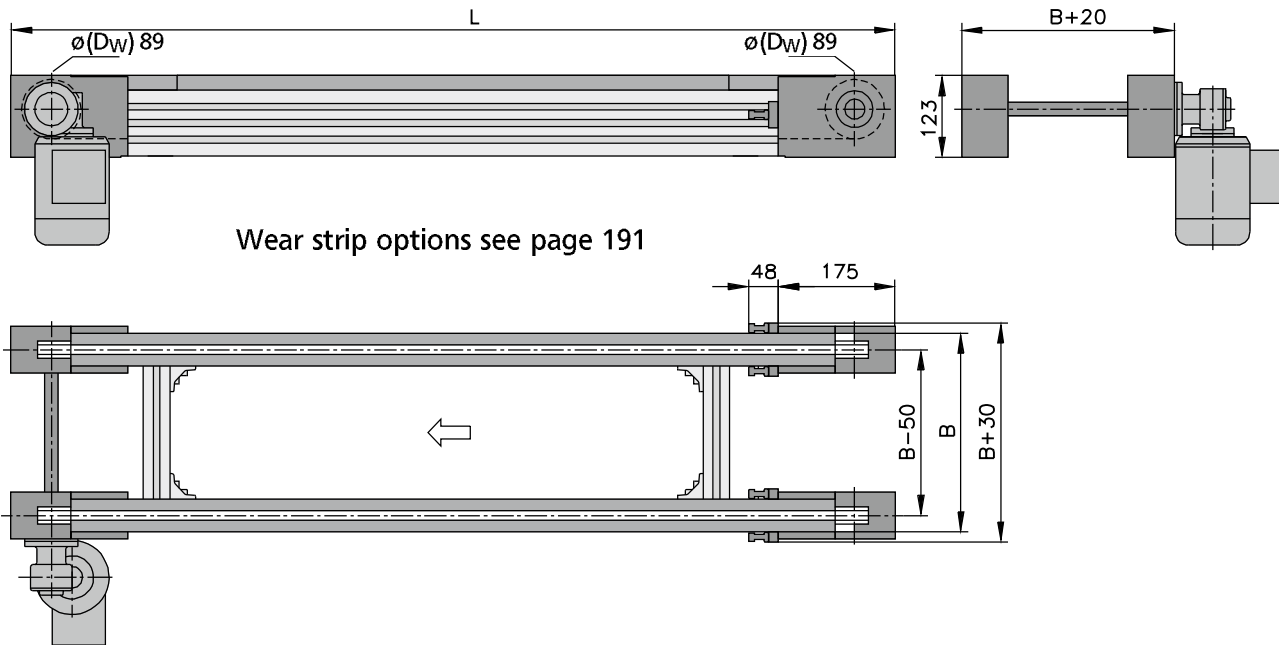
The sprocket ensures outstanding transmission of the motor power.

	Dimensions – technical information	Notes
Conveyor length L	between 500-10000 mm	any increment possible
Conveyor width B	200 to 2000 mm	
Chain	accumulating roller chain 1/2" with plastic or steel roller	see from page 202
Drive location	discharge side left/right	
Drive and speed	to 30 m/min (100 ft/min)	see chart on page 12
Stands and side rails		see from page 262
Load capacity	total load to 750 kg (1650 lbs) section load to 100 kg/m (in series) section load to 150 kg/m (offset)	higher on request

SRF-P 2010 AF

Accumulating roller chain conveyor with head drive, direct

B20.10.561



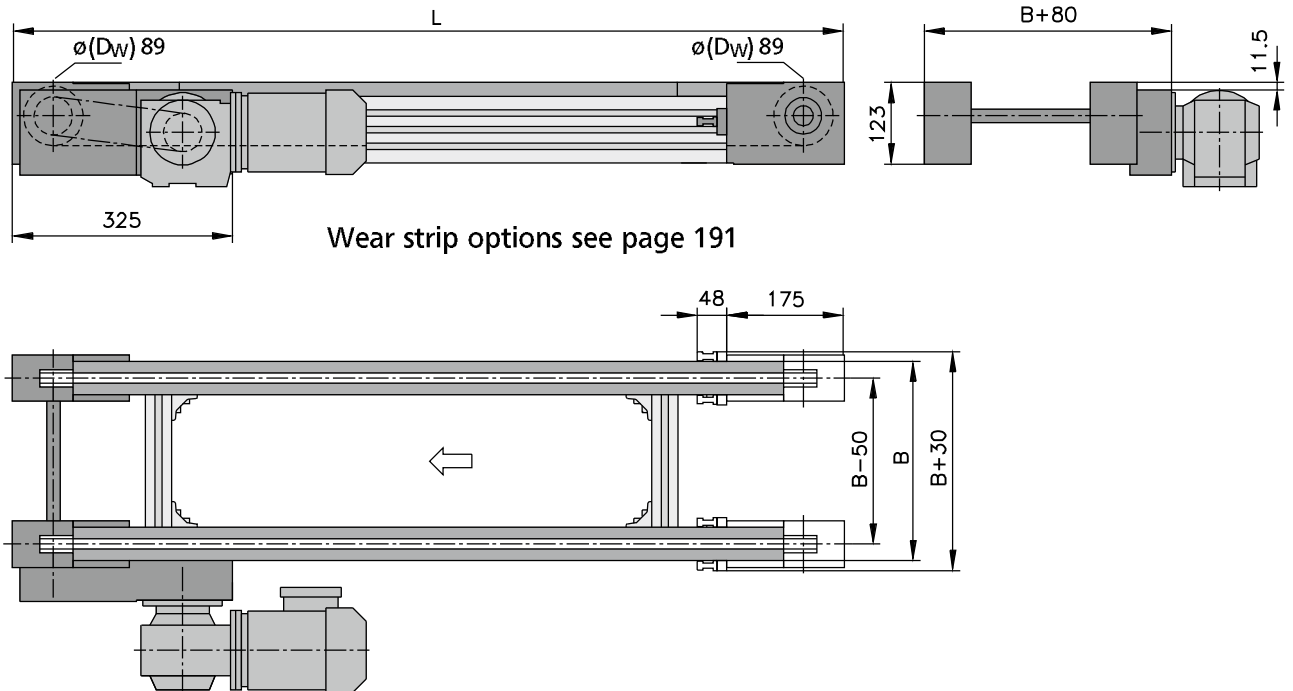
By placing the motor directly onto the drive shaft, this drive version minimizes not only the space required at the drive but also the number of moving parts and maintenance requirements.

	Dimensions – technical information	Notes
Conveyor length L	between 500-10000 mm	any increment possible
Conveyor width B	200 to 2000 mm	
Chain	accumulating roller chain 1/2" with plastic or steel roller	see from page 202
Drive location	discharge side left/right	
Drive and speed	to 30 m/min (100 ft/min)	see chart on page 12
Stands and side rails		see from page 262
Load capacity	total load to 750 kg (1650 lbs) section load to 100 kg/m (in series) section load to 150 kg/m (offset)	higher on request

SRF-P 2010 AS

Accumulating roller chain conveyor with head drive, outside

B20.10.559



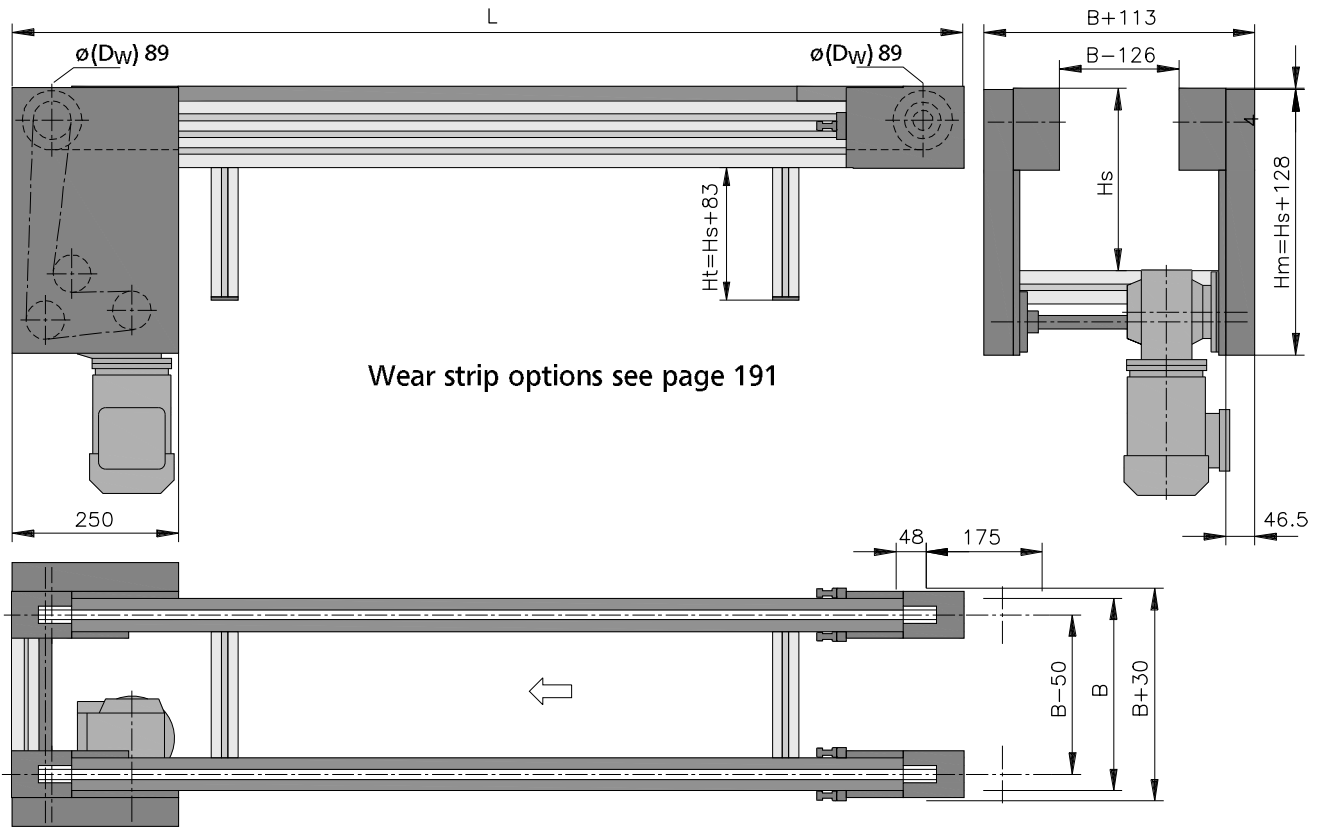
The overall height of the drive assembly is held to an absolute minimum.

	Dimensions – technical information	Notes
Conveyor length L	between 700-10000 mm	any increment possible
Conveyor width B	200 to 2000 mm	
Chain	accumulating roller chain 1/2" with plastic or steel roller	see from page 202
Drive location	discharge side left/right	
Drive and speed	to 30 m/min (100 ft/min)	see chart on page 12
Stands and side rails		see from page 262
Load capacity	total load to 750 kg (1650 lbs) section load to 100 kg/m (in series) section load to 150 kg/m (offset)	higher on request

SRF-P 2010 AQ

Accumulating roller chain conveyor with head drive, dual-strand

B20.10.558



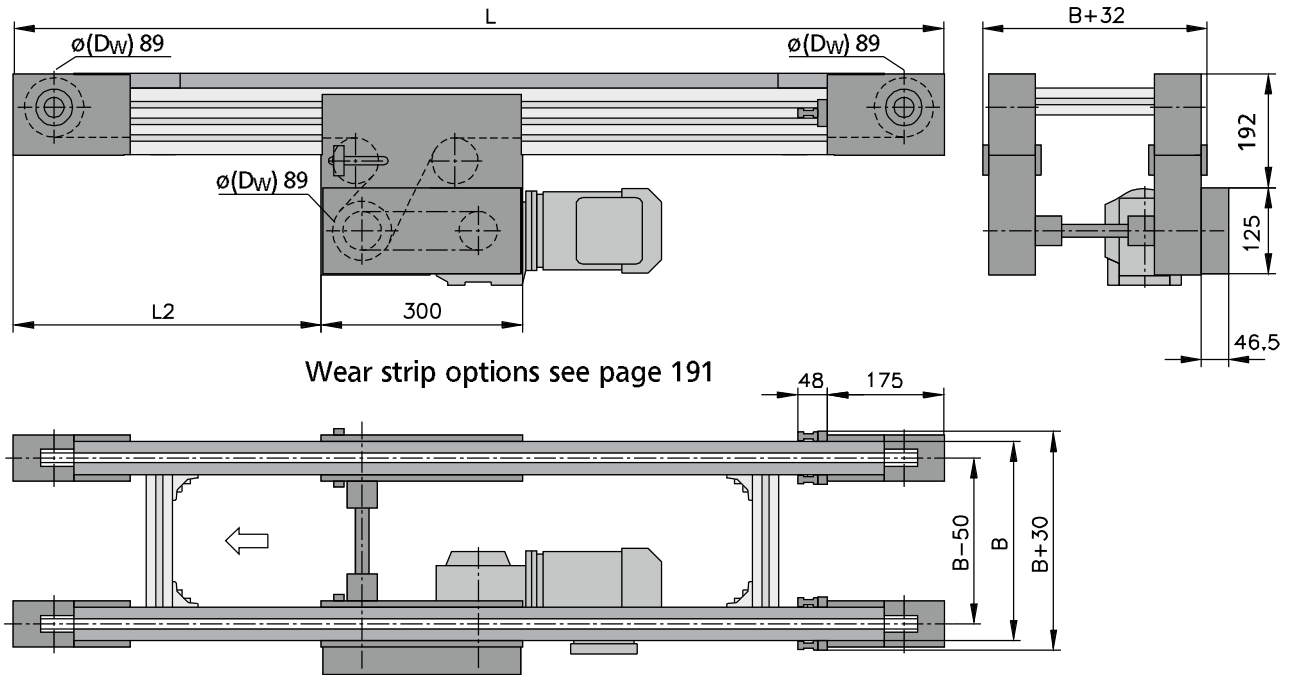
In principle, the drive concept of the AQ version is the same as for the AC version. However, this drive is used when the goods to be transported, or the pallets, require a free space between the conveyor lanes.

	Dimensions – technical information	Notes
Conveyor length L	between 500-10000 mm	any increment possible
Conveyor width B	200 to 2000 mm	
Chain	accumulating roller chain 1/2" with plastic or steel roller	see from page 202
Drive location	discharge side left/right	
Drive and speed	to 30 m/min (100 ft/min)	see chart on page 12
Stands and side rails		see from page 262
Load capacity	total load to 750 kg (1650 lbs) section load to 100 kg/m (in series) section load to 150 kg/m (offset)	higher on request

SRF-P 2010 BC

Accumulating roller chain conveyor with center drive, standard

B20.10.560



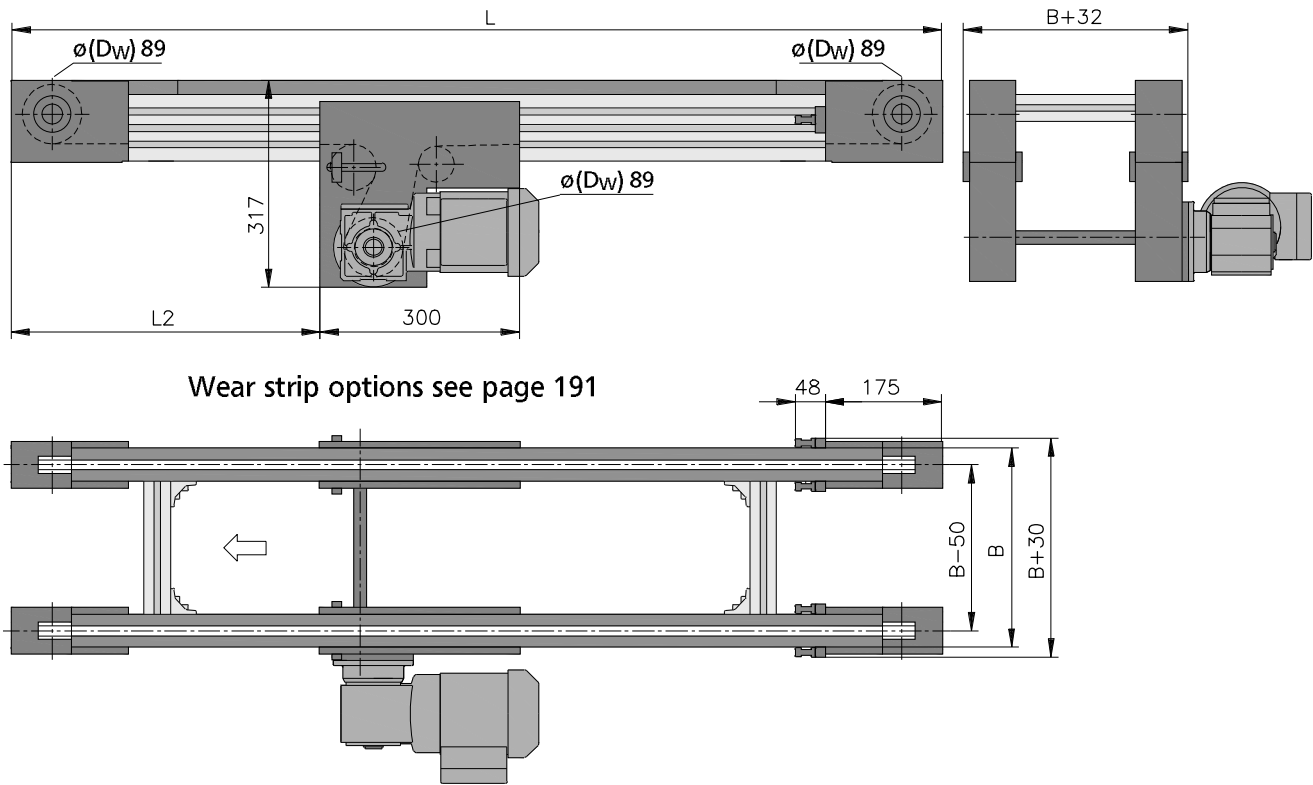
The compact design, and the ability to place the drive location anywhere along the conveyor frame (during manufacture), simplifies the integration of this conveyor into new or existing equipment. The drive sprocket in conjunction with the snub rollers ensures an outstanding transmission of the motor torque.

	Dimensions – technical information	Notes
Conveyor length L	between 700-10000 mm	any increment possible
Conveyor width B	200 to 2000 mm	
Chain	accumulating roller chain 1/2" with plastic or steel roller	see from page 202
Drive location	left/right below	
Drive and speed	to 30 m/min (100 ft/min)	see chart on page 12
Stands and side rails		see from page 262
Load capacity	total load to 750 kg (1650 lbs) section load to 100 kg/m (in series) section load to 150 kg/m (offset)	higher on request

SRF-P 2010 BF

Accumulating roller chain conveyor with center drive, direct

B20.10.563



Thanks to the motor mounted directly on the drive shaft, this drive version keeps spatial requirements and maintenance efforts to a minimum. The compact conveyor frame and the possibility of freely selecting the drive position (during manufacture) over the entire length of the conveyor, facilitates integration of the conveyor in existing systems. The travel direction is reversible. Operation with cleats is not possible with this version.

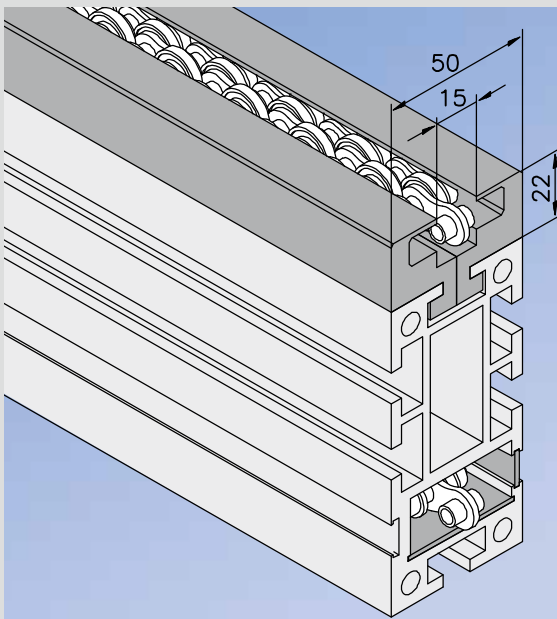
	Dimensions – technical information	Notes
Conveyor length L	between 700-10000 mm	any increment possible
Conveyor width B	200 to 2000 mm	
Chain	accumulating roller chain 1/2" with plastic or steel roller	see from page 202
Drive location	left/right below	
Drive and speed	5; 6,3; 8; 9,5; 11,5; 13,5; 15,2; 19,3; 23; 26; 36,6; 45,7 and 57 m/min	see chart on page 12
Stands and side rails		see from page 262
Load capacity	total load to 750 kg (1650 lbs) section load to 100 kg/m (in series) section load to 150 kg/m (offset)	higher on request

SRF-P 2010

Wear strips

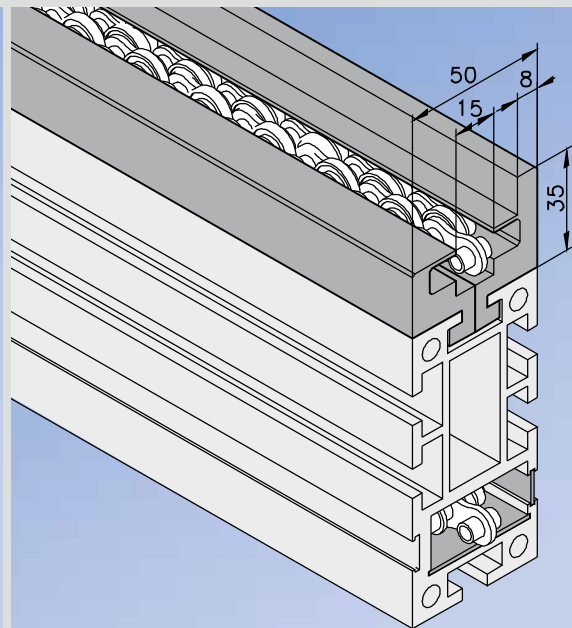
mk guide and wear strips feature low friction and high wear resistance.
The wear strips are made of PE-UHMW (PE-1000). Temperature maximum is 65° C (149° F).

Option A



Wear strip above mk 1048, 22.48.2000
Wear strip below 21.14.0001
Closure strip K10230/12

Option B

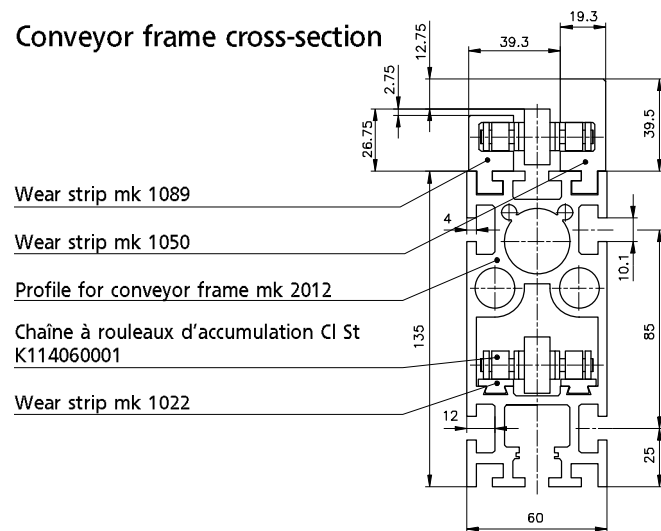


Wear strip above right mk 1047, 22.47.2000
Wear strip above left mk 1048, 22.48.2000
Wear strip below 21.14.0001
Closure strip K10230/12

Chain Conveyors SRF-P 2012



Conveyor frame cross-section





Accumulating roller chain conveyor SRF-P 2012 is designed for the transport and accumulation of loads up to 1000 kg (2,200 lbs). As pallets travel on the large idler rollers, the conveyor is very quiet even in accumulation zones. The force required

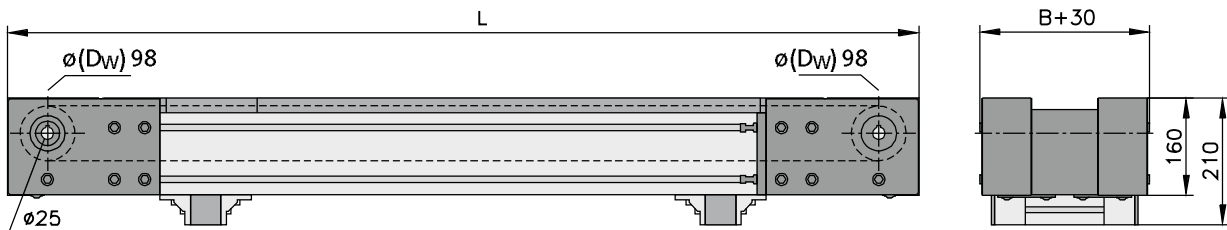
to hold accumulating pallets is minimal. Typical applications include product transfer between workstations or the accumulation of products between processes. Entire handling systems can be designed using this conveyor system. T-slots are accessible on

three sides on the profile frame for the attachment of stands, side rails, sensors and stops (10 mm opening). mk offers a low-maintenance design for extending time between service intervals.

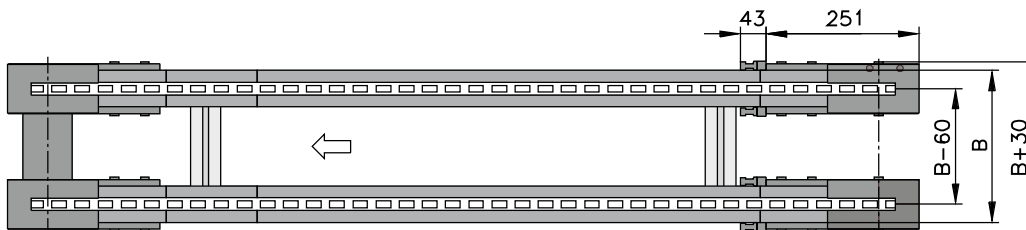
SRF-P 2012 AA

Accumulating roller chain conveyor with head drive without motor

B20.12.008



Wear strip options see page 199



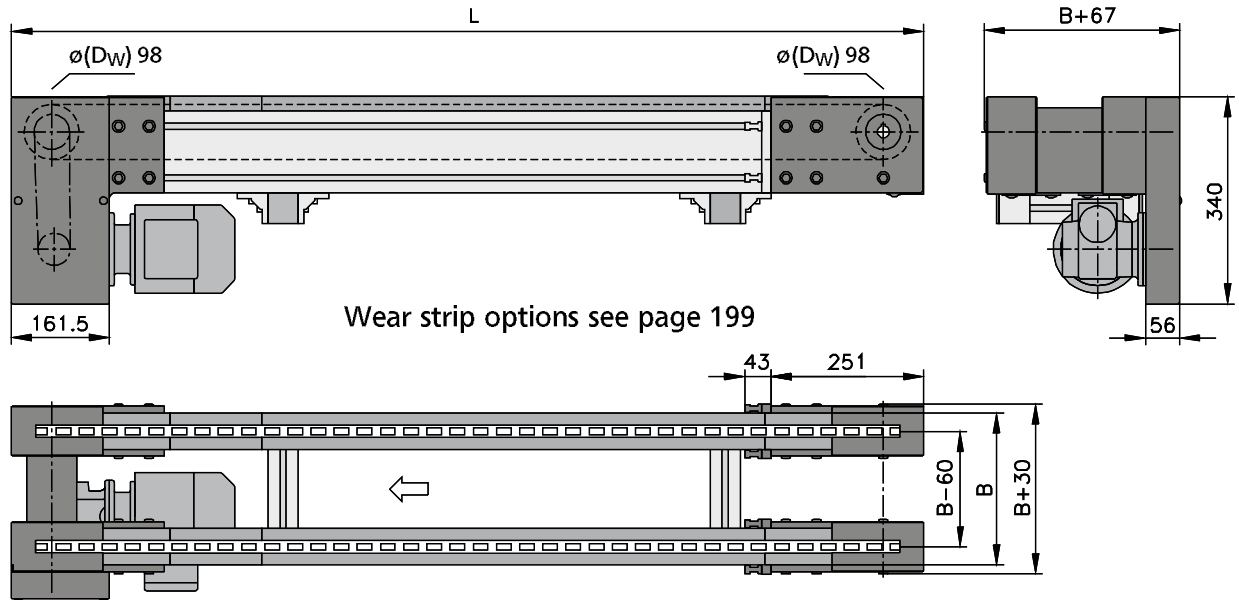
Drive version AA is primarily used where multiple lanes are to be slave driven, either parallel or in-line using a single drive motor. Depending on the requirement, the conveyor is designed either with hollow shaft or with a connecting shaft with shaft journal ($\phi 20/25$ mm, usable length 40 mm, incl. feather key DIN 6885).

	Dimensions – technical information	Notes
Conveyor length L	between 1000-10000 mm	any increment possible depending on chain pitch
Conveyor width B	200 to 2000 mm	
Chain	accumulating roller chain 3/4" with plastic or steel roller	see from page 202
Drive and speed	to 30 m/min (100 ft/min)	see chart on page 12
Stands and side rails		see from page 262
Load capacity	total load to 1000 kg (2200 lbs) section load to 150 kg (330 lbs) /m	higher on request

SRF-P 2012 AC

Accumulating roller chain conveyor with head drive, standard

B20.12.007



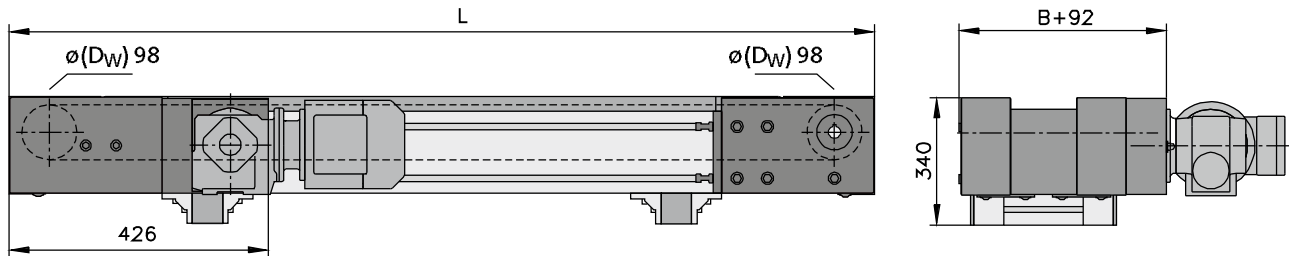
The sprocket ensures outstanding transmission of the motor power.

	Dimensions – technical information	Notes
Conveyor length L	between 1000-10000 mm	any increment possible depending on chain pitch
Conveyor width B	200 to 2000 mm	
Chain	accumulating roller chain 3/4" with plastic or steel roller	see from page 202
Drive location	discharge side left/right below	
Drive and speed	to 30 m/min (100 ft/min)	see chart on page 12
Stands and side rails		see from page 262
Load capacity	total load to 1000 kg (2200 lbs) section load to 150 kg (330 lbs) /m	higher on request

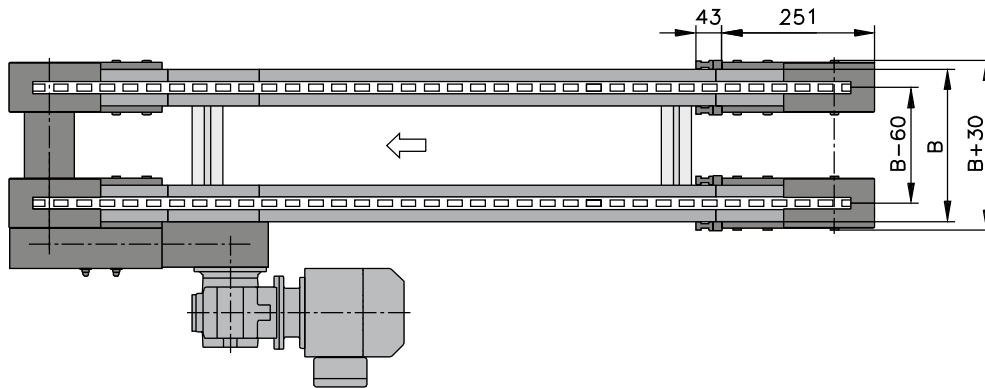
SRF-P 2012 AS

Accumulating roller chain conveyor with head drive, outside

B20.12.009



Wear strip options see page 199



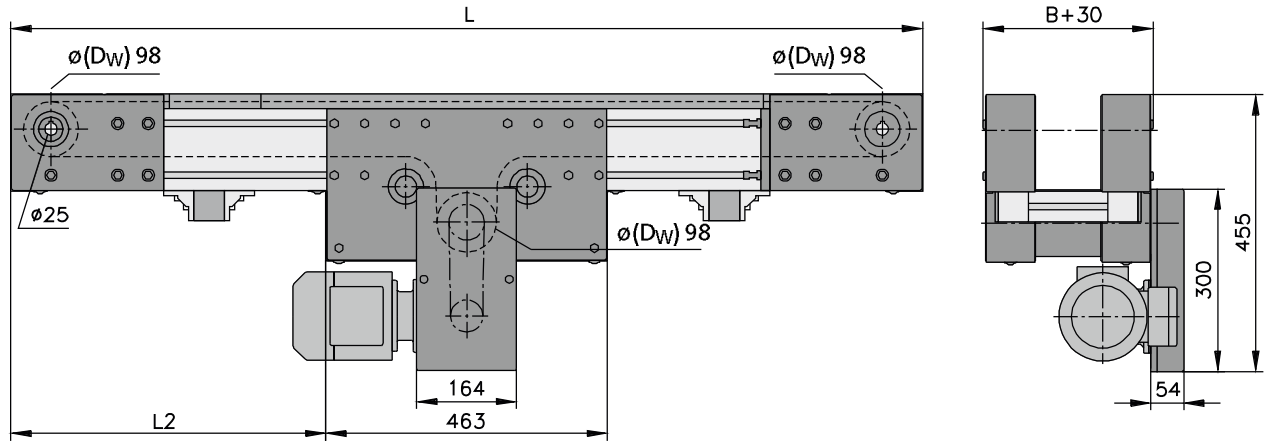
The overall height of the drive assembly is held to an absolute minimum.

	Dimensions – technical information	Notes
Conveyor length L	between 1000-10000 mm	any increment possible depending on chain pitch
Conveyor width B	200 to 2000 mm	
Chain	accumulating roller chain 3/4" with plastic or steel roller	see from page 202
Drive location	discharge side left/right	
Drive and speed	to 30 m/min (100 ft/min)	see chart on page 12
Stands and side rails		see from page 262
Load capacity	total load to 1000 kg (2200 lbs) section load to 150 kg (330 lbs) /m	higher on request

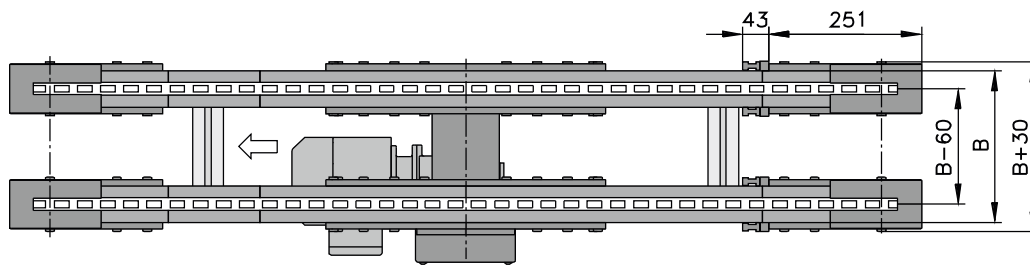
SRF-P 2012 BC

Accumulating roller chain conveyor with center drive, standard

B20.12.010



Wear strip options see page 199



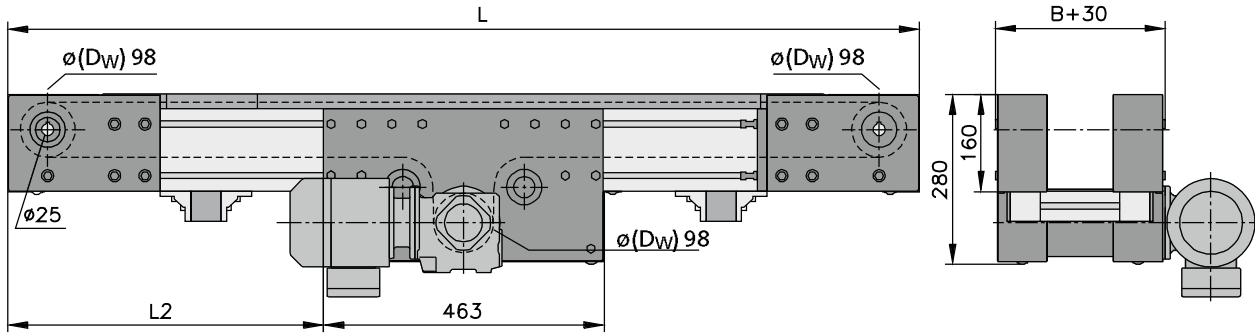
The compact design, and the ability to move the drive location anywhere along the conveyor frame, simplifies the integration of this conveyor into new or existing equipment.

	Dimensions – technical information	Notes
Conveyor length L	between 1000-10000 mm	any increment possible depending on chain pitch
Conveyor width B	200 to 2000 mm	
Chain	accumulating roller chain 3/4" with plastic or steel roller	see from page 202
Drive location	left/right below	
Drive and speed	to 30 m/min (100 ft/min)	see chart on page 12
Stands and side rails		see from page 262
Load capacity	total load to 1000 kg (2200 lbs) section load to 150 kg (330 lbs) /m	higher on request

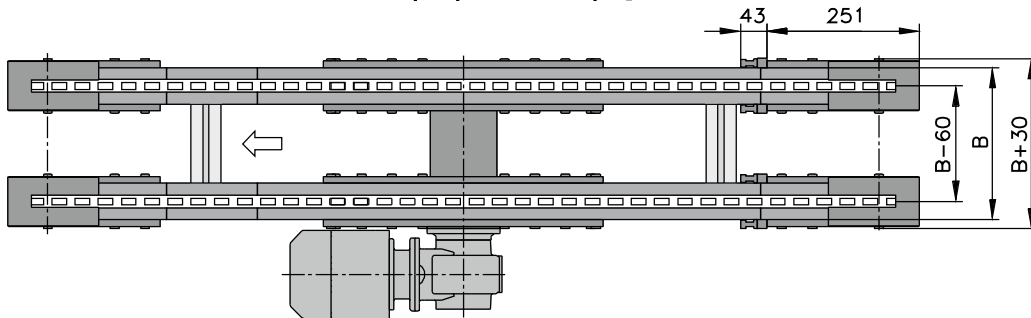
SRF-P 2012 BF

Accumulating roller chain conveyor with center drive, direct

B20.12.011



Wear strip options see page 199



Thanks to the motor mounted directly on the drive shaft, this drive version keeps spatial requirements and maintenance efforts to a minimum. The compact conveyor frame and the possibility of freely selecting the drive position (during manufacture) over the entire length of the conveyor, facilitates integration of the conveyor in existing systems.

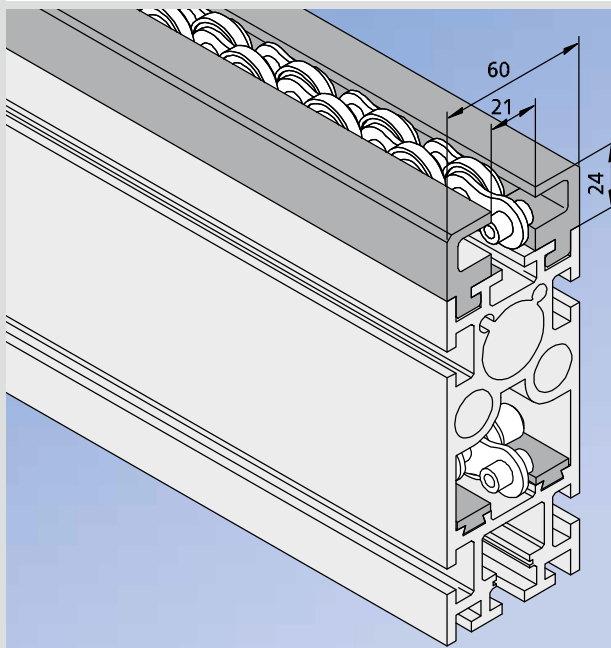
	Dimensions – technical information	Notes
Conveyor length L	between 1000-10000 mm	any increment possible depending on chain pitch
Conveyor width B	200 to 2000 mm	
Chain	accumulating roller chain 3/4" with plastic or steel roller	see from page 202
Drive location	discharge side left/right	
Drive and speed	to 30 m/min (100 ft/min)	see chart on page 12
Stands and side rails		see from page 262
Load capacity	total load to 1000 kg (2200 lbs) section load to 150 kg (330 lbs) /m	higher on request

SRF-P 2012

Wear strips

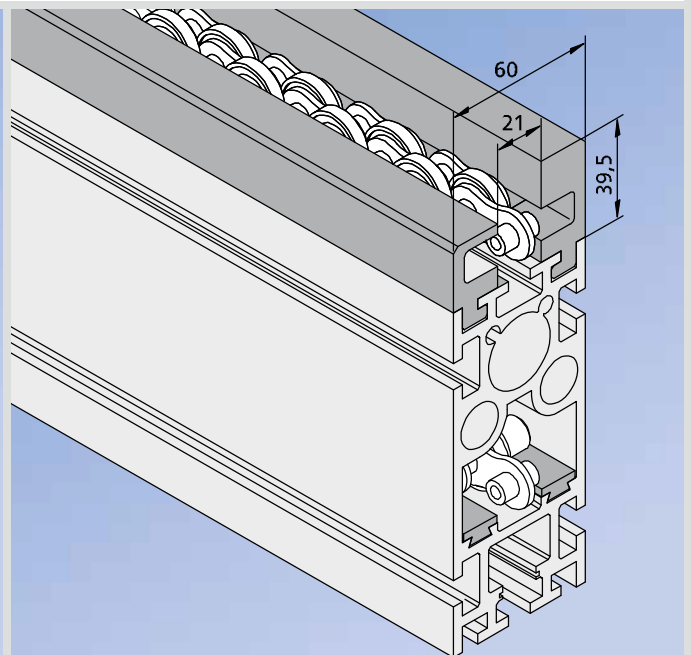
mk guide and wear strips feature low friction and high wear resistance.
The wear strips are made of PE-UHMW (PE-1000). Temperature maximum is 65° C (149° F).

Option A



Wear strips above mk 1089, 22.89.2000
Wear strip below mk 1022, 22.22.2000

Option B



Wear strip above right mk 1050, 22.50.2000
Wear strip above left mk 1089, 22.89.2000
Wear strip below mk 1022, 22.22.2000

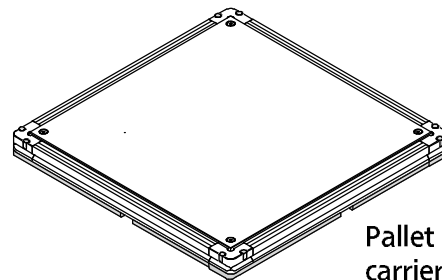
Accessories

Pallets

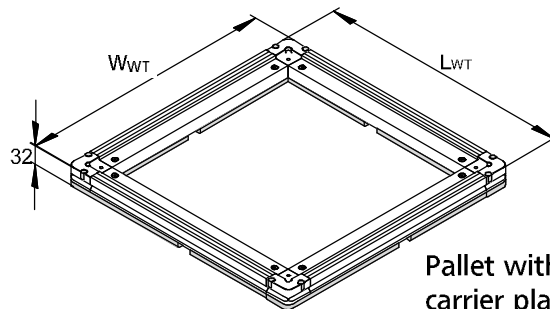
Pallets can be freely configured to meet special requirements; they can be delivered completely pre-assembled or for assembly on a do-it-yourself basis. The max. total weight per pallet is determined based on the allowable total load per meter (100 kg/m) for the system. Please note, that for optimal guidance of the pallets, the clear width of the side rail must be 2-4 mm greater than the width of the pallets.

Individual pallet components:

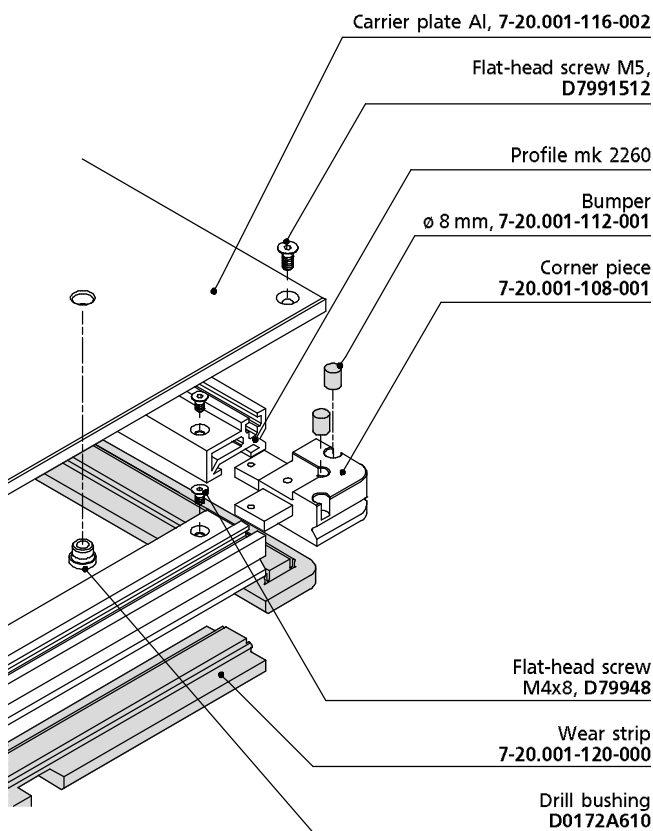
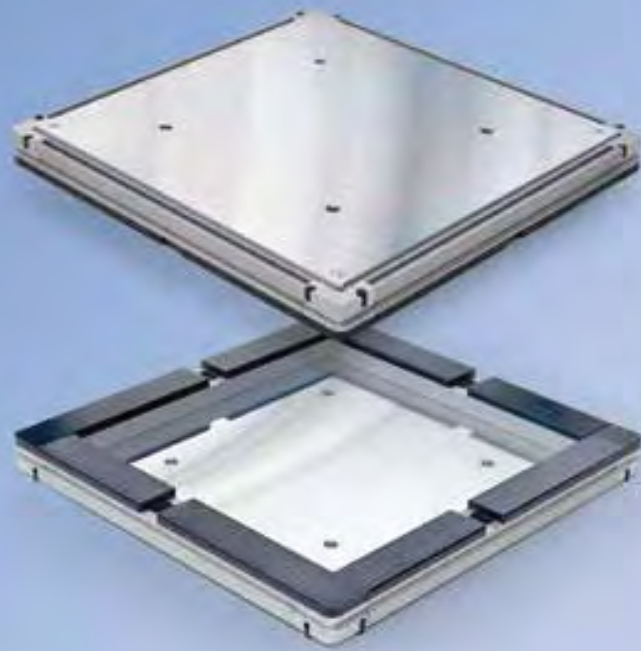
- Aluminum profile frame consisting of the mk 2260 profile and corner pieces
- PE-1000 plastic wear strips underneath the profile frame
- Carrier plates of various plate thicknesses (5, 6, 8, 10 and 12 mm)
- Bumpers/Rubber buffers
- Positioning bushings



Pallet with carrier plate
7-20.001-116-000



Pallet without carrier plate
7-20.001-116-050



W _{WT} mm	L _{WT} mm	Carrier plate mm	Weight _{WT} kg
400	400	8	5
400	600	8	8
600	600	10	14
600	800	10	16
800	800	12	24
800	1000	12	30

[More information from page 157](#)

Maintenance kit

Assembly aid for chain replacement

The accumulating roller chain has to be loosened at the tail of the conveyor in order to replace it. This integrated assembly aids the in facilitation of the chain replacement by a separate removable a piece of the wear strip. The accumulating roller chain has to be moved along until the chain master link, marked by a blue ring, appears at the opened space. The accumulating roller chain can then be separated and replaced.



Service indicator

mk offers an automatic service indicator as an option, which indicates when the chain needs to be shortened. The indicator lights work similar to a traffic light system.

- Green: OK
- Yellow: Shortening not yet required
- Red: Chain has to be shortened, unless the maximum chain extension of 3% has been reached

The chain and sprockets need to be replaced in the case of a 3% chain extension.

Continuous lubrication station

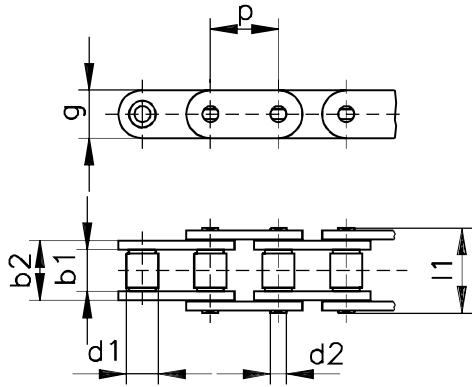
Manual chain lubrication is not required if the lube station (optional) is used. Integrated oil brushes are used for the continuous lubrication of the chain with oil.

This station can easily be retrofitted. Along with a decentralized version with cartridges and a battery-operated drive; also available is a central lubrication station with PLC controlled pulses.

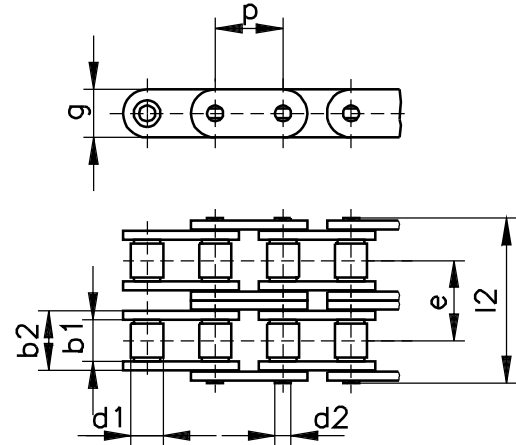


Accessories

Chains



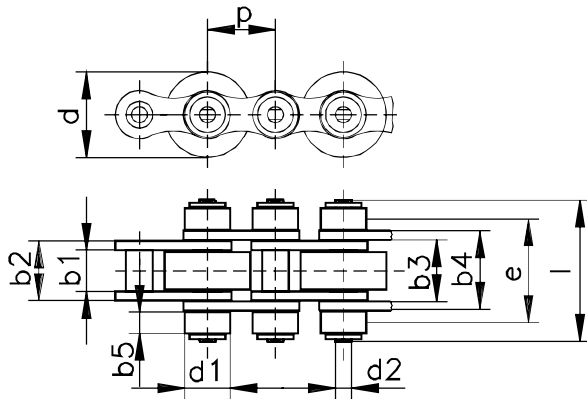
to 60° C/140° F (Specials to 120° C/248° F)



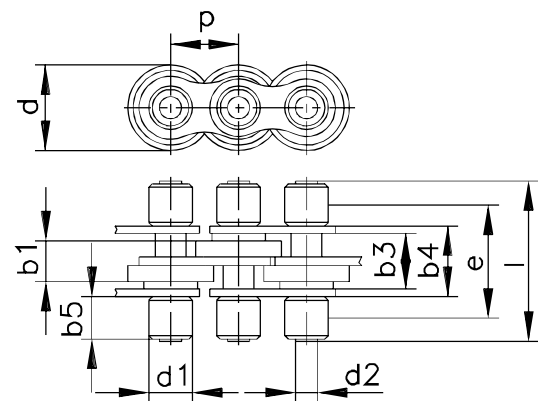
to 60° C/140° F (Specials to 120° C/248° F)

Dimensions	Single-strand roller chain with straight nuts KTF-P 2010 Chain K11402 Connecting link K114020001	Dimensions	Dual-strand roller chain with straight nuts KTF-P 2010 Chain K11416 Connecting link K114160001
p	12.70 (1/2" x 5/16")	p	12.70 (1/2" x 5/16")
b1	7.75	b1	7.75
b2	11.30	b2	11.30
b3	•	b3	•
b4	•	b4	•
d1	8.51	d1	8.51
g	11.50	g	11.80
d2	4.45	d2	4.45
l1	17.00	l1	•
l2	•	l2	31.00
e	•	e	13.92
l	•	l	•
b5	•	b5	•
d	•	d	•

St = Steel roller, PI = Plastic roller, Hg = Hand guard, CI = Connecting link



Accumulation rollers in series
to 60° C/140° F (Specials to 120° C/248° F)



Offset accumulation rollers
to 60° C/140° F (Specials to 120° C/248° F)

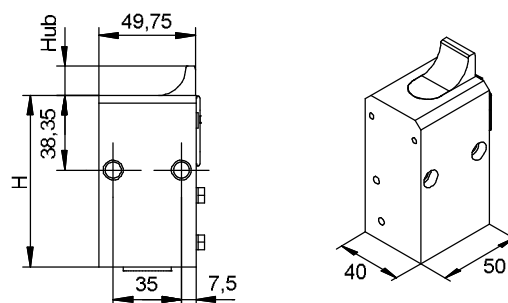
Dimensions	Accumulating roller chain plastic or steel rollers		Dimensions	Accumulating roller chain plastic or steel rollers	
	SRF-P 2010 Chain St K11418 Chain PI K11435 Chain St Hg K11425 Chain PI Hg K11424 CI K114180001	SRF-P 2012 Chain St K11406 Chain PI K11407 CI K114060001		SRF-P 2010 Chain St K11421 Chain PI K11420 CI K114180001	SRF-P 2012 Chain St K11423 Chain PI K11422 CI K114060001
p	12.70 (1/2")	19.05 (3/4")	p	12.70 (1/2")	19.05 (3/4")
b1	7.75	11.68	b1	9.20	11.70
b2	11.15	15.62			
b3	11.40	15.80	b3	11.40	15.80
b4	14.70	20.00	b4	14.50	19.55
d1	8.50	12.00	d1	8.51	12.07
g	•	•	g	•	•
d2	4.45	5.72	d2	4.45	5.72
l1	•	•	l1	•	•
l2	•	•	l2	•	•
e	•	•	e	18.70	31.50
l	27.00	48.00	l	27.00	45.00
b5	4.00	11.50	b5	6.25	12.73
d	16.00	24.00	d	16.00	24.00

Accessories

Stops

Undamped stop (SU)

These stops are used for stopping or separating the pallets. Stop variants are selected according to the pallet weight and conveyor speed. A selection of various stop heights is available, depending on customer requirements.



SU 400 undamped stop

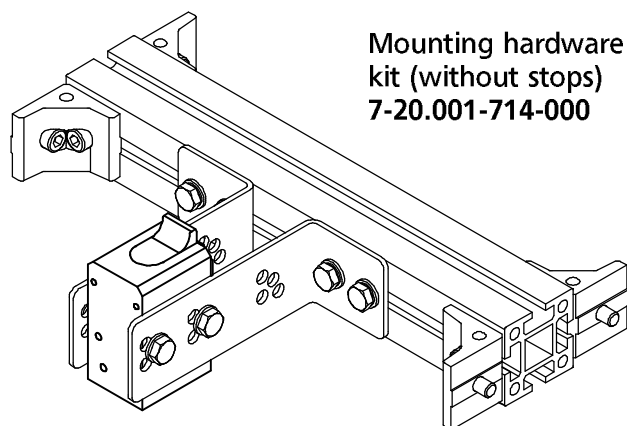
Ident. no.	Stroke (mm)	Stroke v = 6	v = 9	v = 12	v = 18	
		m/min [kg]	m/min [kg]	m/min [kg]	m/min [kg]	
K503011401	EW	9	400	300	250	200
K503012401	DW	9	400	300	250	200

EW = single-acting (= pressureless stop)
 DW = double-acting (= previous stop position is maintained)



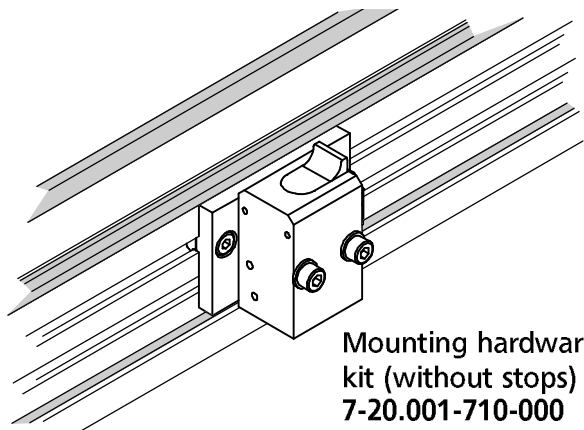
Installation example

Damped or undamped stops can be connected at the center or the sides.



Mounting hardware kit (without stops)
7-20.001-714-000

Installation example: for stopping at the center.



Mounting hardware kit (without stops)
7-20.001-710-000

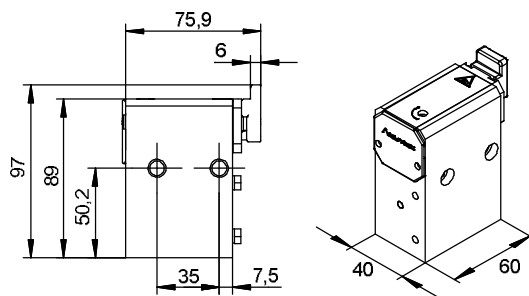
Installation example: for stopping at the side.



Stops

Damped stop (SD)

The damped stopping procedure enables a gentle, delayed stop of the first pallet. The pallet is prevented from shifting due to the damping action. Electric or inductive scanning devices at the stop are available as an option. For correct functioning of the stop, a minimum pallet mass of 3 kg is required.

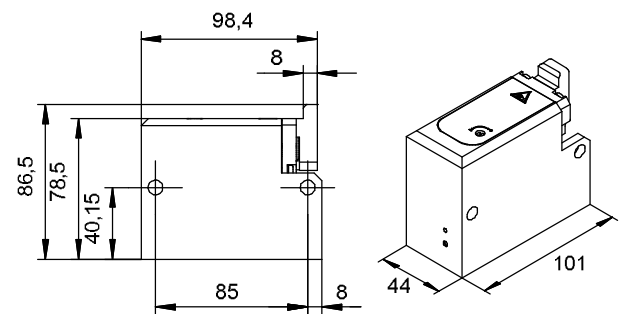


SD 60 damped stop

Ident. no.	Stroke (mm)	Stroke				
		v = 6 m/min [kg]	v = 12 m/min [kg]	v = 24 m/min [kg]	v = 30 m/min [kg]	
K503021061	EW	8	3-60	3-35	3-24	3-18
K503022061	DW	8	3-60	3-35	3-24	3-18

Indicated values are applicable for a friction value of $\mu = 0,07$
Stops for higher loads available upon request

EW = single-acting (= pressureless stop)
DW = double-acting (= previous stop position is maintained)



SD 100 damped stop

Ident. no.	Stroke (mm)	Stroke				
		v = 6 m/min [kg]	v = 12 m/min [kg]	v = 24 m/min [kg]	v = 30 m/min [kg]	
K503021101	EW	8	3-100	3-60	3-40	4-30
K503022101	DW	8	3-100	3-60	3-40	4-30

Indicated values are applicable for a friction value of $\mu = 0,07$
Stops for higher loads available upon request

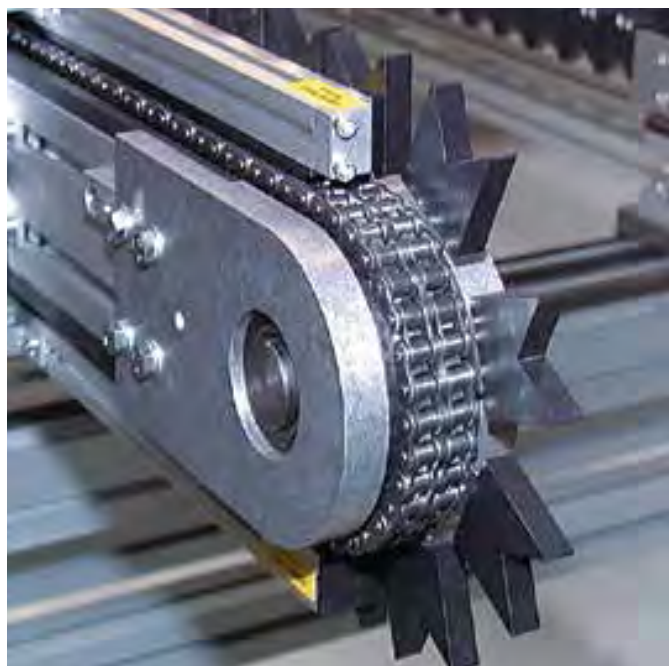
EW = single-acting (= pressureless stop)
DW = double-acting (= previous stop position is maintained)

Chain Conveyors

Application examples



KTF-P 2010 with head drive AC with drip pan and moveable underframe



KTF-P 2010 with prismatic holders



KTF-P 2010 with adjustable side rails and adjustable handles for frequently changing product widths



3-strand conveyor KTF-P 2010



Combination of belt conveyor and chain conveyor with transverse rail for simulation of a floor obstruction



KTF-P 2040 with custom constructions that ensure horizontal mounting of the products to be conveyed for incline transport



Chain conveyor KTF-P 2040 with prisms as pallets

Chain Conveyors

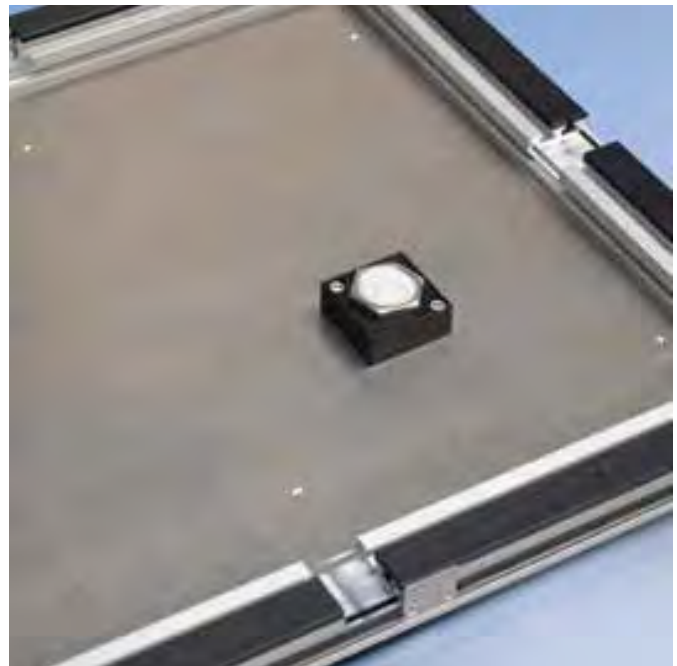
Application examples



Robot unloading position with damped stops, pneumatic lifting with indexing from above, and RFID write/read module



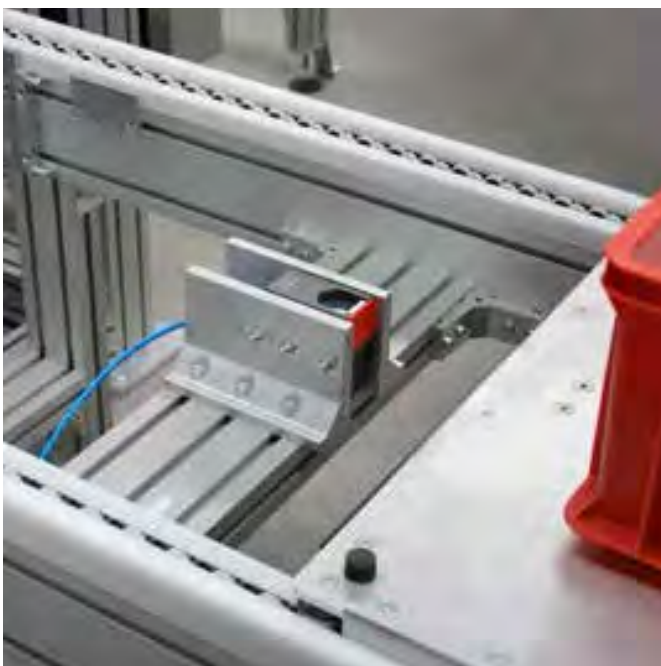
Customer-specific pallet, corrosion-resistant version for a cleaning system



Pallet with optional RFID transponder



Station for 4 removal slots on a pallet with undamped stops and back stop. Accumulated pallets are separated upstream of the station in the process via damped stops on the buffer section.



Heavy-duty version of SRF-P 2012 system with offset accumulating roller chain in POM strips and SU 800 stops



Fail-safe lift and turning station linking production cells in the automotive sector

Chain Conveyors

Application examples



Linking of production cells in automotive sector. Manual feeding of pallets, removal with customer-supplied handling system and robot. Lower return level with lift and shuttle.



Ready-for-use interlink to assembly automation



Lift and storage system for pallets with two chain conveyors running in opposite directions and pallet slots



Pallet circulation system for various transport levels with 3-axis portal



Confusion-proof parts receiving for left-hand and right-hand sided products



Ready-for-use complete system with melting furnace and PLC