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Gravity Conveyor Assembly Guide

Straight, Curve, H-Stand, Ball Transfer Tables, and Accessories

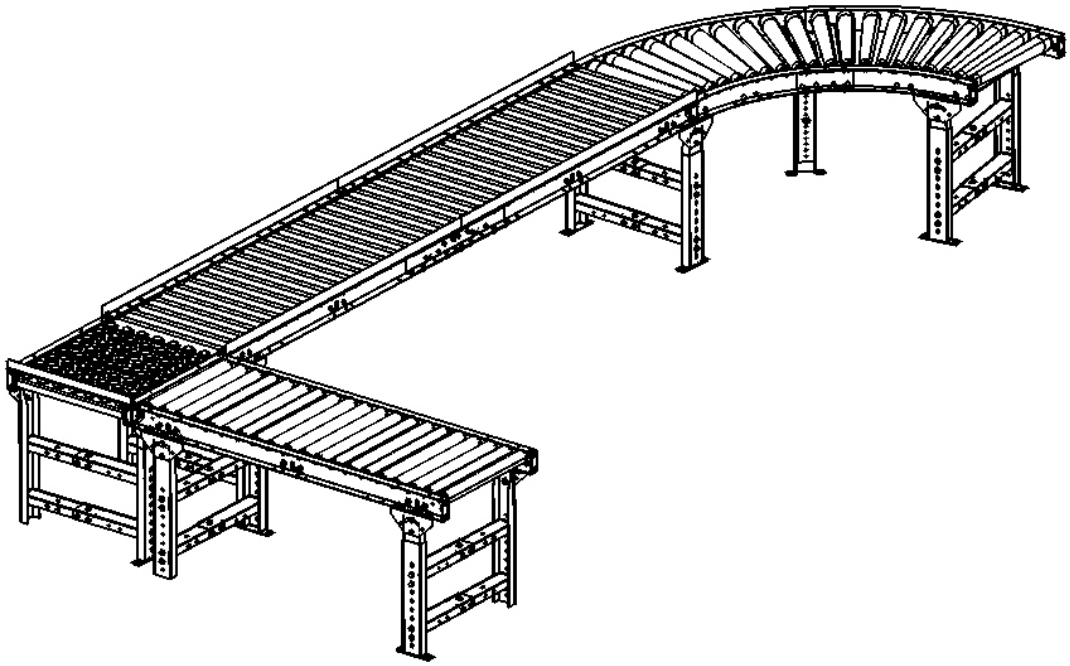


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PATENT PENDING

GENERAL DATA

Please read the instructions completely and save for reference. Upon receiving, inspect the unit for any damage. These products must be handled with caution by trained operators with proper safety gear and equipment. Installation and assembly must be in compliance with ANSI/CEMA Standard No. 401 and local OSHA regulatory codes and requirements. Pay attention to safety warning labels, pinch points and surrounding environment when in use. Failure to comply with instructions could result in serious injury.

SAFETY AND WARNINGS

- Only trained personnel must be permitted to operate a conveyor.
- Keep area around conveyors clear of all obstructions and safety hazards.
- Be aware of all pinch points and warning labels when in use.
- DO NOT SIT, STAND, OR RIDE the conveyor at any time.
- DO NOT OVERLOAD – check capacity chart for maximum weights.
- DO NOT use the conveyor if there is any damage or loose parts.
- DO NOT alter, modify, or tamper with the conveyor under any circumstances.
- Alert all personnel to potential hazards in the rollers such as long hair, jewelry, etc.
- Fully tighten all bolts and ensure unit is fully stable. Check bolts regularly.

MAINTENANCE AND INSPECTION

Maintenance and service must be performed by qualified personnel only. Do not perform any maintenance when a conveyor is in operation. Routine inspections with preventative and corrective maintenance programs should be conducted to ensure the conveyors are maintained and function properly. All personnel should inspect for hazardous conditions at all times and repair/replace worn or damaged parts immediately. Apply lubrication as needed to ensure rollers continuously operate smoothly. Light cleaning may be required at joints and connection points.



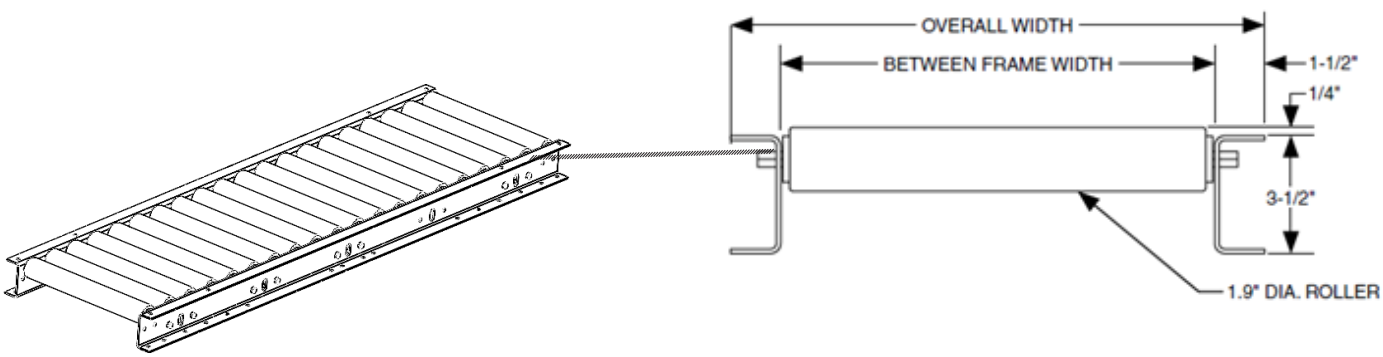
GRAVITY ROLLER CONVEYOR SPECS AND CAPACITIES

Gravity Roller Conveyor systems are fast, simple and effective solutions for handling and transporting products in warehouses, shipping departments, and assembly areas. These conveyors are cost efficient and excellent for both permanent and temporary applications. The gravity roller bed conveyor section includes the conveyor frames and rollers.

FEATURES AND SPECS

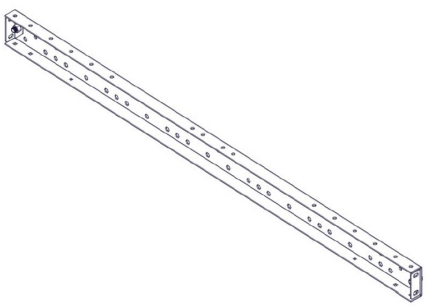
Color – standard conveyor green
Frame – 3 ½ in. deep x 1 ½ in. flange x 10 gauge powder coated steel rails.
Cross Ties – Bolt in cross members. 5' sections (3) cross ties and 10' section includes (4) cross ties.
Length & Width – 5' or 10' straight sections in 18" or 24" overall widths. 10' straight sections include (4) 5' frames that are connected by (2) Steel C-Channels.
Couplings – Butt type for bolting sections together. Each Rail includes (2) couplings.
Rollers – 1.9 in. dia. X 16 ga. Galvanized steel tube, 7/16 in. spring hex retained axle, grease packed ball bearings both ends. Roller Centers are 3 in., 4 ½ in., or 6 in. Capacities shown below.
H-Stands – 12 gauge powder coated steel. Adjustable Height (24"-36") and Width (18" or 24").
Guide Rail – 2"H x 5'L x 12 gauge powder coated steel.
End Stops – 12 gauge powder coated steel.
Ball Transfer Tables – see page 11

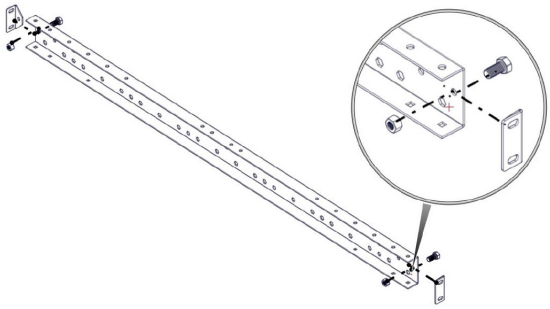
Model no.	Length [Ft]	Overall Width [in.]	Between Frame (In.)	Roller Centers (In.)	# of rollers	# of Cross Ties	Capacity (lbs.)
293193	5'	18"	15"	3"	20	3	3300
293194	5'	18"	15"	4.5"	13	3	2600
293195	5'	18"	15"	6"	10	3	2000
293196	5'	24"	21"	3"	20	3	3300
293197	5'	24"	21"	4.5"	13	3	2600
293198	5'	24"	21"	6"	10	3	2000
293199	10'	18"	15"	3"	40	4	1200
293200	10'	18"	15"	4.5"	26	4	1000
293201	10'	18"	15"	6"	20	4	800
293202	10'	24"	21"	3"	40	4	1200
293203	10'	24"	21"	4.5"	26	4	1000
293204	10'	24"	21"	6"	20	4	800



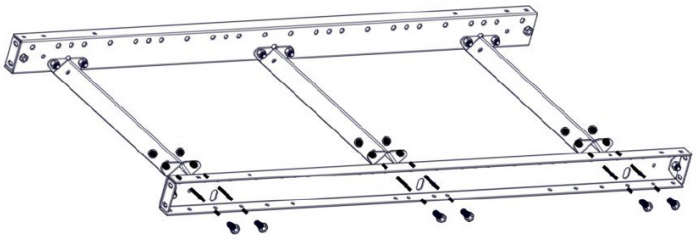
5' CONVEYOR ASSEMBLY

1. For both rails, install the end plates using 1x bolt per plate.
Hardware & qty: H1 x 4 , H3 x 4





2. Install Cross ties at designated locations for each configuration. Use 4x Bolts per cross-tie. *Hardware & qty: H1 x 12, H3 x 12*

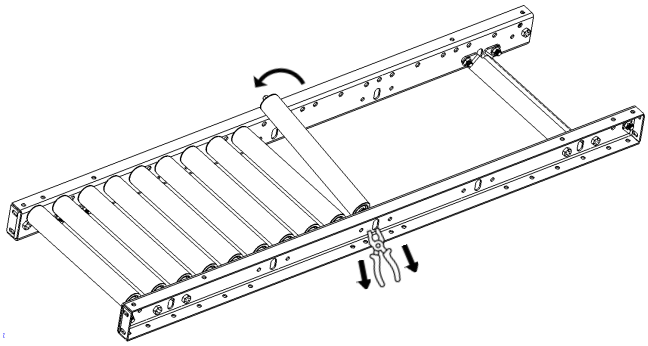


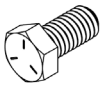
3. Each roller has a rigid and flexible end.

The flexible end can be pressed inward.



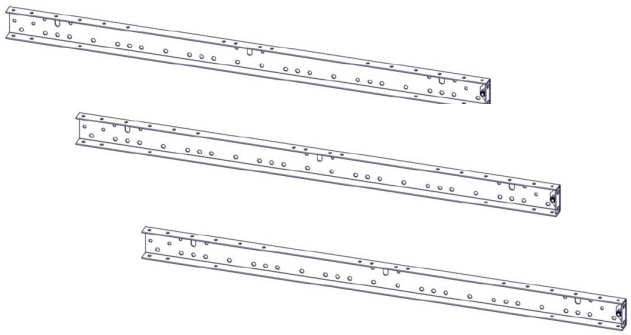
Insert each roller into the frame at the desired spacing. Insert the roller rigid-end first. Once inserted, using pliers, pull the rigid end and rotate the roller into place. Release the end with pliers to lock each roller.

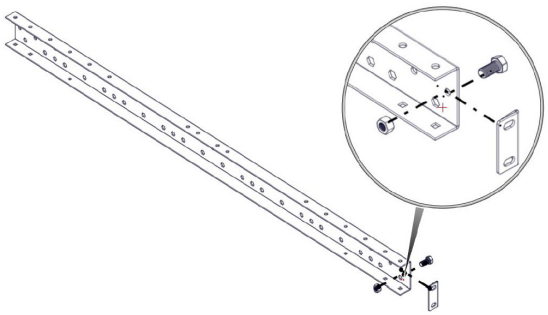


ID	Description	Qty	Image
H1	Hex Head Bolt, 3/8"-16 Thread Size, 3/4" Long	16	
H3	Hex Flange Nut, 3/8"-16 Thread Size	16	

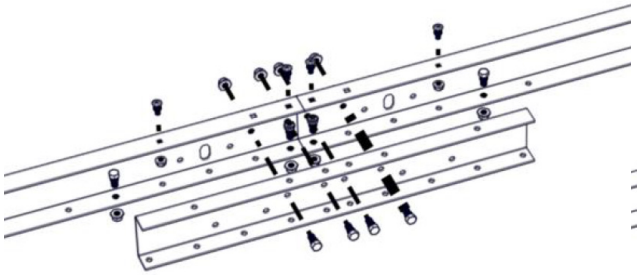
10' CONVEYOR ASSEMBLY

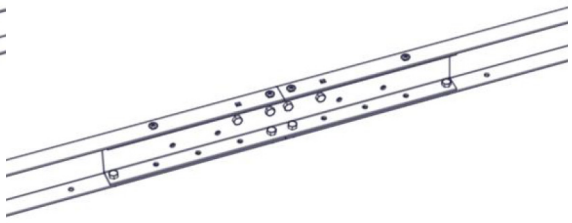
1. Install the end plates using 1x bolt per plate. *Hardware & qty: H1 x 4 , H3 x 4*



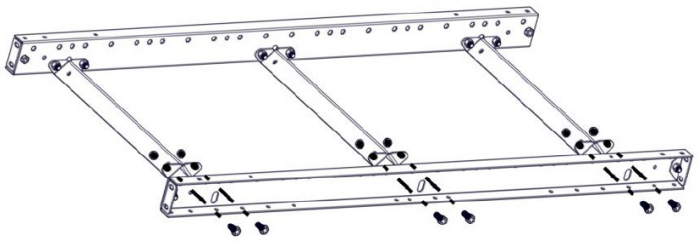


For 10' Rails: Connect two 5' Rails using C Channel connector. Repeat this step to assembled 2x 10' rails. *Hardware & qty: H1 x 8, H3 x 8, H4 x 4, H6 x 4*





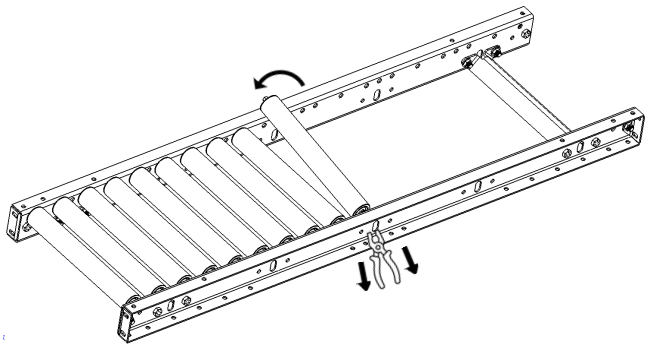
2. Install cross-ties at designated locations for each configuration. Use 4 bolts per cross-tie. *Hardware & qty: H1 x 24, H3 x 24*



3. Each roller has a rigid and flexible end. The flexible end can be pressed inward.

The flexible end can be pressed inward. 

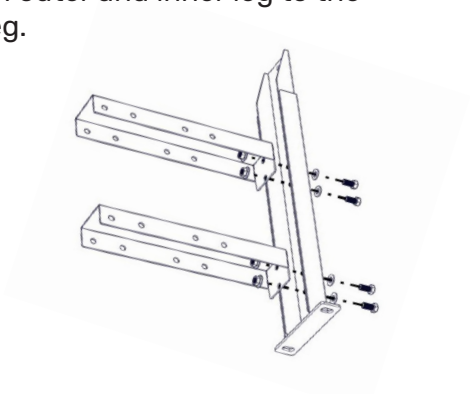
Insert each roller into the frame at the desired spacing. Insert the roller rigid-end first. Once inserted, using pliers, pull the rigid end and rotate the roller into place. Release the end with pliers to lock each roller.



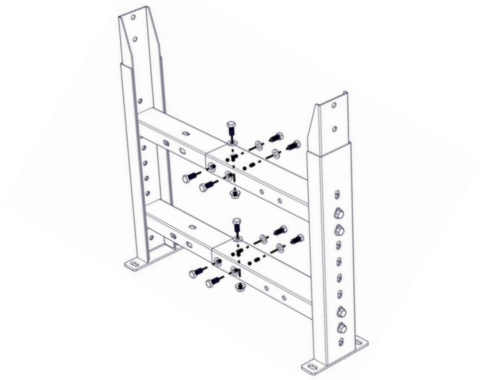
ID	Description	Qty	Image
H1	Hex Head Bolt, 3/8"-16 Thread Size, 3/4" Long	44	
H3	Hex Flange Nut, 3/8"-16 Thread Size	44	
H4	Steel Square-Neck Carriage, M8 x 1.25mm, 20mm Long	8	
H6	Hex flange nut, M8 x 1.25 mm Thread	8	

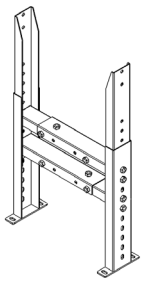
H-STAND ASSEMBLY

1. Select desired height. Place the outer leg over the inner leg and attach two adjustable cross beam pieces to the leg. When possible, bolt both outer and inner leg to the cross-beams. Repeat this step for both sides of the leg.
Hardware & qty: H1 x 8, H3 x 8, H7 x 8

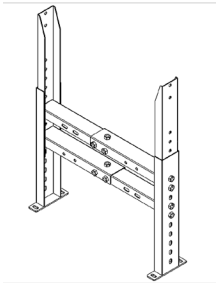


2. Select desired width to match conveyor width. Bolt the cross-beam pieces together. Use 5 bolts per cross beam. *Hardware & qty: H1 x 10, H3 x 10, H7 x 10*



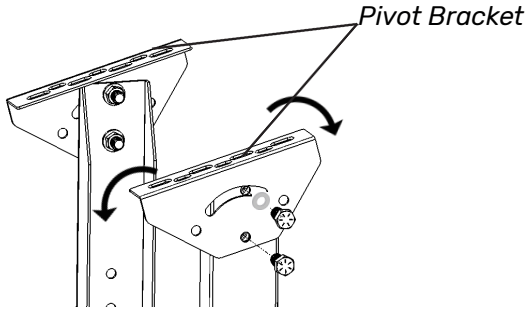


18”W Configuration

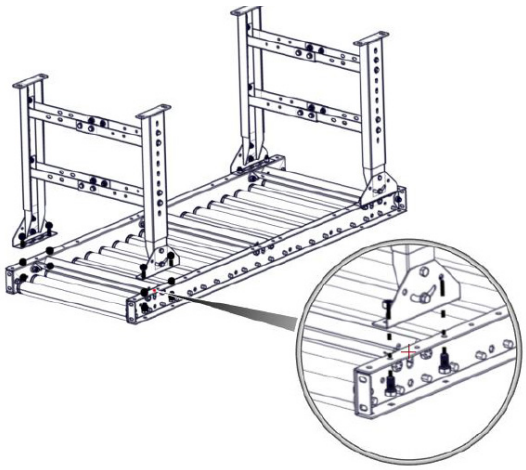


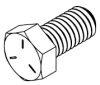
24”W Configuration Hard-

3. Install the pivot brackets by bolting the two bolts in the top bolt. Adjust the angle of the bracket to the angle. *Hardware & qty: H1 x 4, H3 x 4, H7 x 2*



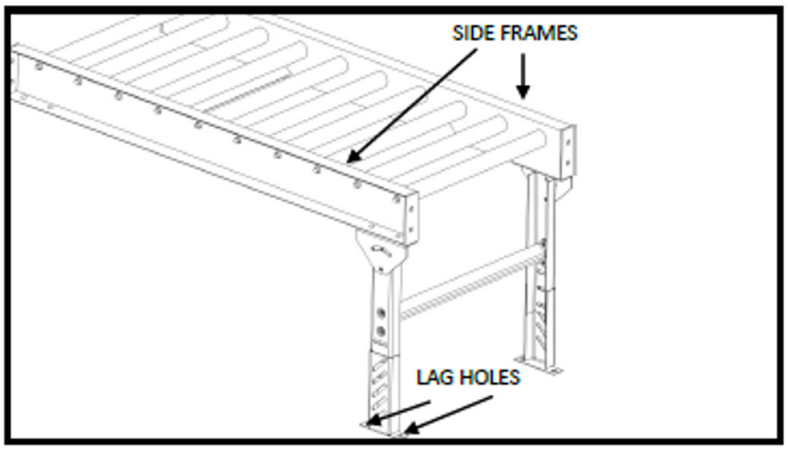
4. Follow the directions to connect the H Stand to the conveyor or table.
Hardware & qty: H1 x 8, H3 x 8



ID	Description	Qty	Image
H1	Hex Head Bolt, 3/8"-16 Thread Size, 3/4" Long	26	
H3	Hex Flange Nut, 3/8"-16 Thread Size	26	
H7	Washer or M10 Screw Size	20	

LEG SUPPORTS AND INSTALLATION: BOLT-TOGETHER

Permanent installation of legs: Secure leg supports to the floor utilizing the lag holes in the adjustable leg boot.

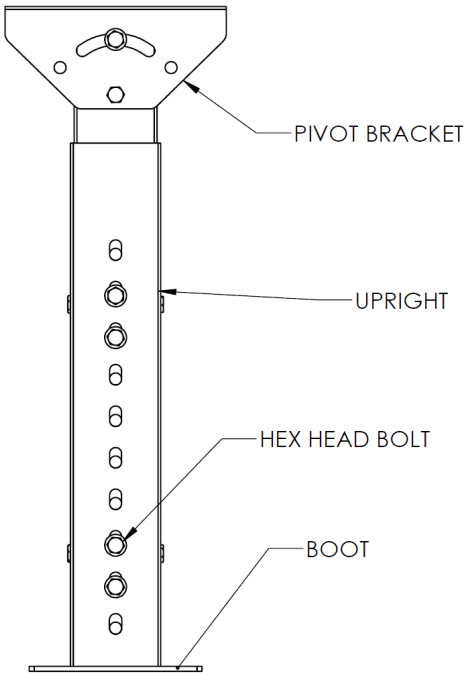


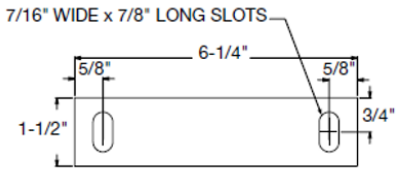
NOTE: Lag bolts are not included.

Make sure the conveyor is level by placing a level on the conveyor side frames. If the conveyor is not level, adjust the legs appropriately as shown below.

Leg adjustment:

1. Remove all load from the conveyor.
2. Position conveyor in the location to be installed.
3. Support conveyor section with jack, hoist or forklift.
4. Carefully loosen the fasteners within the slots.
5. Lift or lower conveyor until it is at the desired height.
6. Ensure that the conveyor is completely level. (reference leveling note below)
7. Tighten fasteners using torque appropriate tool for each fastener's size and grade. (Grade 5 fasteners provided)

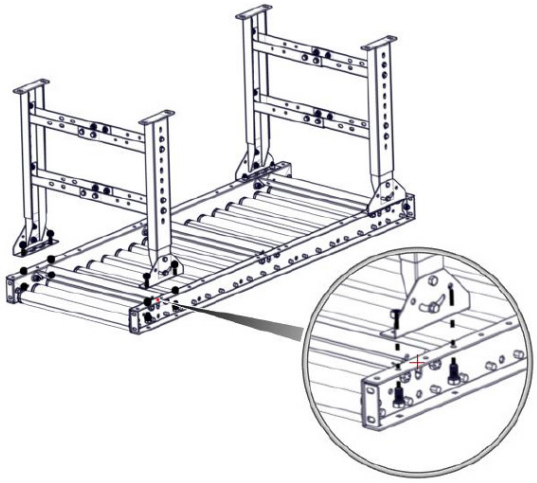




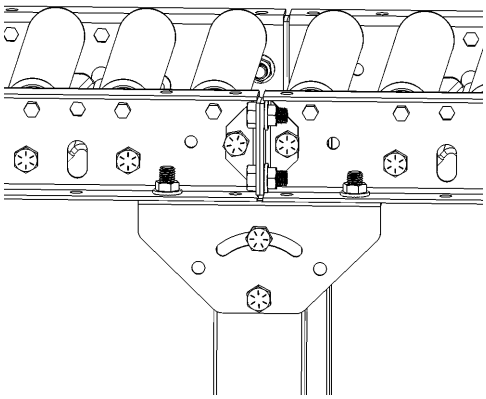
FOOT PLATE FOR FLOOR SUPPORT

CONVEYORS AND STAND ASSEMBLY – 1.9" DIAMETER ROLLERS

BOLTING TWO H-STANDS TO ONE CONVEYOR FRAME
Position H-stands with two holes on the end of the conveyor frame. On the end, tighten bolts. Fasten bolts through conveyor and H-Stand. *Hardware & qty: H1 x 8, H3 x 8*

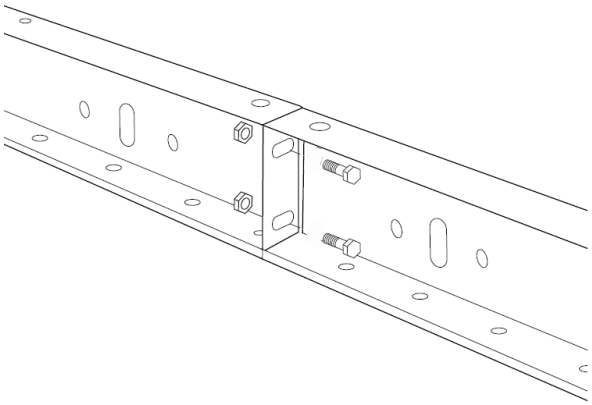


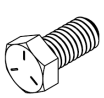
BOLTING A SINGLE H-STAND TO TWO CONVEYOR FRAMES
Place the H-Stand in the middle of two conveyor frame ends. Position the H-Stand to align one hole on each conveyor. Fasten bolts through conveyors and H-Stand.



NOTE: Each Conveyor frame has mounting holes for a center leg support, which is optional. The addition of a third support increases weight capacity.

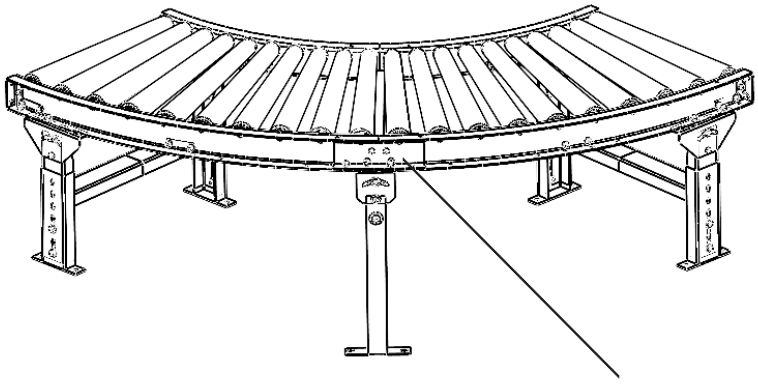
BOLTING MULTIPLE CONVEYOR FRAMES TOGETHER
Using the holes, fasten the bolts through the ends of both conveyor frames.
Hardware & qty: H1 x 4, H3 x 4



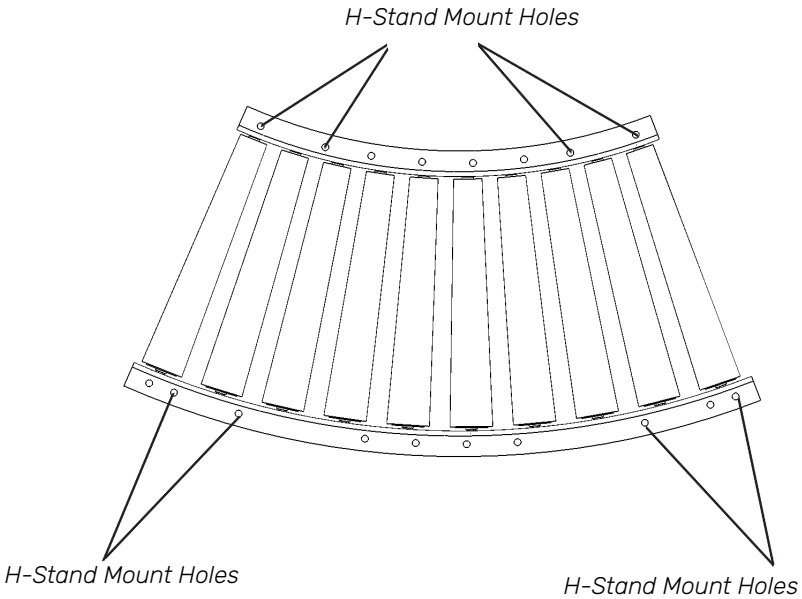
ID	Description	Qty	Image
H1	Hex Head Bolt, 3/8"-16 Thread Size, 3/4" Long	4	
H3	Hex Flange Nut, 3/8"-16 Thread Size	4	

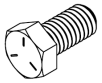
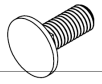
CURVE CONVEYOR ASSEMBLY

18" OAW Model no. 293290
24" OAW Model no. 293291
Hardware & qty: H1 x 40, H3 x 40, H4 x 4, H6 x 4, H7 x 4



1. Combine both pieces of the curved conveyors with the joint connection frame and hardware provided.
2. Attach the H-Stands to the indicated holes shown in the diagram
3. Attach the single sided leg to the center of the arc tangent frame.



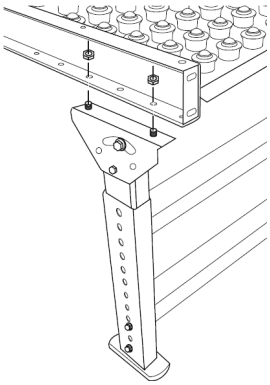
ID	Description	Qty	Image
H1	Hex Head Bolt, 3/8"-16 Thread Size, 3/4" Long	40	
H3	Hex Flange Nut, 3/8"-16 Thread Size	40	
H4	Steel Square-Neck Carriage, M8 x 1.25mm, 20mm Long	4	
H6	Hex flange nut, M8 x 1.25 mm Thread	4	
H7	Washer or M10 Screw Size	4	

BALL TRANSFER TABLES

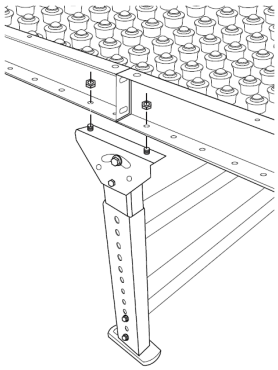
Model no.	Description
293268	18” OAW Ball Transfer Table x 2’ Length
293269	18” OAW Ball Transfer Table x 3’ Length
293270	24” OAW Ball Transfer Table x 2’ Length
293271	24” OAW Ball Transfer Table x 3’ Length

Assembly instructions

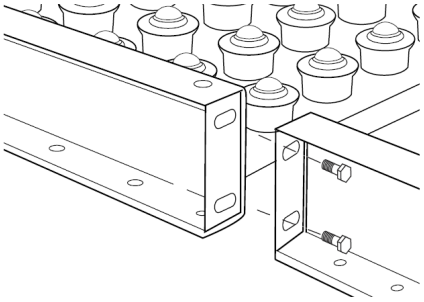
Bolting two H-stands to one table frame. *Hardware & qty: H1 x 4 , H3 x 4*
Position H-Stands on the end of the table frame. Fasten bolts through table and H-Stand.

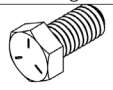


Bolting a single H-Stand to two table frames. *Hardware & qty: H1 x 4 , H3 x 4*
Place the H-stand halfway between the ends of two table frames, with one hole on each table lined up with the H-stand. Bolts should be threaded through the tables and H-stand.



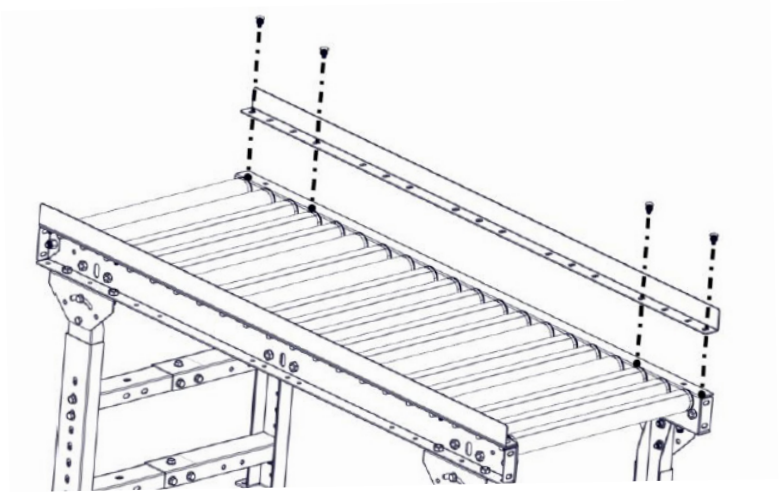
Connecting multiple tables together. *Hardware & qty: H1 x 4 , H3 x 4*
Fasten bolts through the ends of both frames.



ID	Description	Qty	Image
H1	Hex Head Bolt, 3/8"-16 Thread Size, 3/4" Long	4	
H3	Hex Flange Nut, 3/8"-16 Thread Size	4	

ACCESSORIES INSTALLATION
for Straight Gravity Conveyors

5' Guide rail kit (Model no. 293185)
Using the carriage bolts, bolt the guide rail through the holes closest to the edge on top of the conveyor. Be sure that the carriage bolt points down and nothing is in the way for items on the conveyor to cause interference. *Hardware & qty: H4 x 8 , H6 x 8*

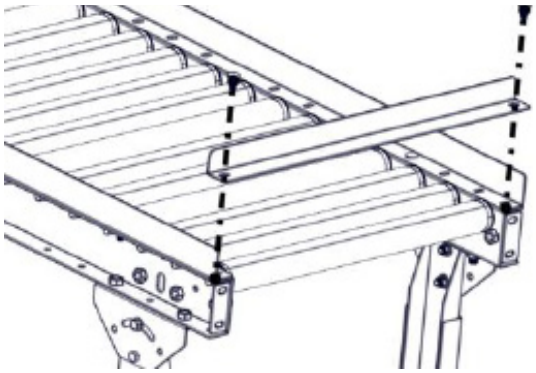


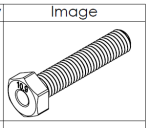
ID	Description	Qty	Image
H4	Steel Square-Neck Carriage, M8 x 1.25mm, 20mm Long	8	
H6	Hex flange nut, M8 x 1.25 mm Thread	8	

Angle End Stop
18"W Model no. 293188 *Hardware & qty: H2 x 2, H6 x 2, H7 x 2, H8 x 2*
24"W Model no. 293189 *Hardware & qty: H2 x 2, H6 X 2, H7 X 2, H8 X 2*

Using the bolts, bolt the end stop through the holes closest to the edge on top of the conveyor.

If installing both angle end stops and guide rail kit, be sure to install guide rail kit first.

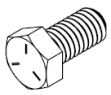
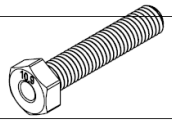
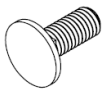


ID	Description	Qty	Image
H2	Hex head bolt M8 x 1.25 mm Thread Size, 30 mm Long	2	
H6	Hex flange nut, M8 x 1.25 mm Thread	2	
H7	Washer or M10 Screw Size	2	
H8	axle sleeve	2	

REPLACEMENT PARTS

Model no.	Description
293176	5’ Side Rail Kit for Gravity Roller Conveyor, 10 Ga. Steel
293177	10’ Side Rail Kit for Gravity Roller Conveyor, 10 Ga. Steel
293178	15” Roller, 1.9” Dia, 16 Ga. Galv. Steel, Pack of 10
293179	15” Roller, 1.9” Dia, 16 Ga. Galv. Steel, Pack of 3
293180	21” Roller, 1.9” Dia, 16 Ga. Galv. Steel, Pack of 10
293181	21” Roller, 1.9” Dia, 16 Ga. Galv. Steel, Pack of 3
293182	Heavy Duty Cross Tie, 15” Between Frame
293183	Heavy Duty Cross Tie, 21” Between Frame
293184	KD Adjustable Height H-Stand, 24” to 36”, 2000 lb cap.
293185	5’ Guide Rail Kit, 2”H, 12 Ga. Steel
293188	18” Angle End Stop, 12 Ga. Steel
293189	24” Angle End Stop, 12 Ga. Steel
293190	90 Deg. Curved Conveyor, 18” OAW, Tapered Rollers
293191	90 Deg. Curved Conveyor, 24” OAW, Tapered Rollers
293192	Adjustable Single Leg Support for Curved Conveyors

HARDWARE REFERENCE TABLE

HARDWARE ID	DESCRIPTION	IMAGE
H1	Hex Head Bolt, 3/8"-16 Thread Size, 3/4" Long	
H2	Hex head bolt M8 x 1.25 mm Thread Size, 40 mm Long	
H3	Hex Flange Nut, 3/8"-16 Thread Size	
H4	Steel Square-Neck Carriage, M8 x 1.25mm, 20mm Long	
H5	Steel Washer for 3/8" Screw Size	
H6	Hex flange nut, M8 x 1.25 mm Thread	
H7	Washer for φ10 Screw Size	
H8	Axle Sleeve	

WARRANTY PAGE

REGISTER ONLINE AT

http://www.globalindustrial.com/wr or http://www.globalindustrial.ca/wr

Global Limited 1 Year Warranty

1. LIMITED WARRANTY

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THE FOREGOING DESCRIBES THE SOLE LIABILITY OF GLOBAL, AND YOUR SOLE REMEDY, FOR ANY BREACH OF WARRANTY. IF YOU DO NOT AGREE WITH THE TERMS OF THIS LIMITED WARRANTY, YOU MUST RETURN THE PRODUCTS UNUSED AND IN THEIR ORIGINAL PACKAGING WITHIN THREE (3) DAYS AND YOUR PURCHASE PRICE WILL BE REFUNDED.

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Please note that you are responsible for all shipping charges incurred in returning an item for exchange or repair. Global shall pay for return shipping of repaired and/or replaced Products to addresses within the United States and Canada only, and return shipments to all other addresses outside of the United States or Canada is your responsibility. If Global determines that any Product is not covered by this Limited Warranty, you must pay all parts, labor charges and return shipping for such Product.

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FOR PURCHASES WITHIN CANADA - This Limited Warranty shall be subject solely to the laws of the Province of Ontario. Any dispute arising hereunder shall be subject to the sole jurisdiction of Ontario, Canada. The parties hereby consent to the personal jurisdiction of such courts