

# MODEL "22ACDE"

## Air Operated Accumulating Conveyor Photo Eye Controlled

- **Medium Weight Pallets**
- **Drum Filling Operations**
- **Large Carton Accumulation**
- **Handles Product on Slip Sheets**
- **Photo eye controlled**



### STANDARD SPECIFICATIONS

**Frame** - Conveying surface width 14", 16", 18", 24", 28", and 34". 5 1/2" x 1 1/2" x 10 gauge powder painted formed steel channel both sides. Sections are bolted together with butt couplings and floor supports.

**Tread Rollers** - 2" dia. x 12 gauge steel with #40 sprockets welded to roller tube, 7/16" hex shaft. Rollers spaced on 4" or 6" centers, set low 1 1/2". Roller to roller driven.

**Drive** - Located near center of conveyor length, under conveyor frame.

**Drive Chain** - RC #40 for roller to roller connections, RC #50 chain drive for each zone. Chains are totally enclosed by metal guards.

**Floor Supports** - Adjustable 28 1/4" to 42 1/4" from floor to top of rollers. One support supplied for each end of conveyor and at each bed joint.

**Accumulation Zones** - Standard zone lengths are 24", 30", and 36" with a maximum of 30 zones per drive. Conveyor frame lengths change with zone lengths and zone length must be divisible by roller centers. Each zone is driven by an air clutch and controlled by a photo eye sensor.

**Sensing Device** - Photo electric sensor in each zone detects product presence and activates accumulation feature in trailing zone if leading zone is occupied.

**Power Supply** - 120VAC power supply controls accumulation feature with 24VDC output. Power supply will control 40 accumulation zones.

**Filter/Regulator** - Mounted to conveyor side frame. 50 PSI recommended operating pressure with free air consumption of .001 cu. ft. per sensor operation.

**Motor** - 1/2 HP 230/460-3-60 TE Motor.

**Conveyor Speed** - 60 FPM constant.

**Capacity** - Maximum load 250 lbs. per foot; maximum unit load 1000 lbs. Not to exceed load capacity chart.

### OPTIONAL EQUIPMENT

**Electrical Controls** - Magnetic starters and push button stations; manual motor starters, others.

**Diffused Photo Eyes** - To be used when retro-reflective photo eyes can't be used due to product interference.

**Workstation** - External control of a zone or zones can be achieved with a workstation kit - contact factory for more information.

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Bed Length	Conveying Surface	14"	16"	18"	24"	28"	34"
	Between Frame Width	17"	19"	21"	27"	31"	37"
	Overall Frame Width	26.5"	28.5"	30.5"	36.5"	40.5"	46.5"
10'	<b>Weight (lbs.) Based On 4" Roller</b>	328	375	424	564	660	796
20'		617	703	795	1057	1237	1496
30'		925	1055	1192	1585	1854	2244
40'		1160	1322	1495	1987	2325	2814
50'		1450	1653	1868	2484	2907	3517
60'		1740	1983	2241	2981	3488	4220
70'		2030	2314	2615	3478	4069	4924
80'		2320	2645	2989	3975	4651	5627
90'		2610	2975	3362	4472	5232	6331

## OPERATIONAL SEQUENCE

- Model "22ACDE" is loaded at the infeed end of conveyor. The first load travels the entire length of the conveyor to Zone #1. If the photoelectric sensor in Zone #1 has been activated by an external signal (normally open contact, not supplied) the product will stop in Zone #1.
- The second load travels the length of the conveyor until it reaches Zone #2. If Zone #1 is occupied, the second load will stop in Zone #2. Load #3 will stop in Zone #3 and continue to accumulate at "zero pressure" until fully loaded.
- To unload, an external signal (normally open contact, not supplied) to the photoelectric sensor in Zone #1 will release the accumulation feature and allow the product in Zone #1 to leave the conveyor. The load in Zone #2 will not advance into Zone #1 until the load in Zone #1 has completely cleared Zone #1's photoelectric sensor; the third load will not advance into Zone #2 until the second load clears the photoelectric sensor in Zone #2. Once the first load clears the photoelectric sensor in Zone #1, the external signal must be restored to Zone #1's photoelectric sensor for the accumulation process to continue.

## Load Capacity Charts

Accumulated			Moving		
Conveyor Speed @ 60 FPM	Total Load (lbs.)		Conveyor Speed @ 60 FPM	Total Load (lbs.)	
HP	Up to 50'	Up to 100'	HP	Up to 50'	Up to 100'
1/2	6000	5000	1/2	3000	2000
3/4	7500	6500	3/4	4500	3500
1	9000	8000	1	6000	5000
1 1/2	10500	9500	1 1/2	7500	6500
2	12000	11000	2	9000	8000

