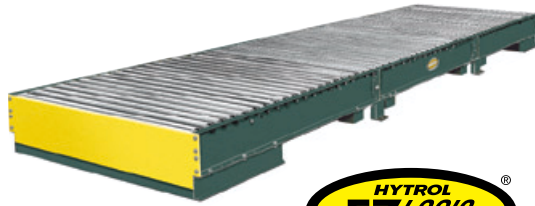


Model 25-LREZ Heavy Duty Accumulating Conveyor

The Model 25-LREZ is a belt driven live roller conveyor designed for use where zero-pressure accumulation, low elevation (12") and close roller centers are required.



Conveyor shown with optional floor supports



- ★ EZLogic® Accumulation System
- ★ Zero-Pressure Accumulation
- ★ Compact Drive
- ★ Low Elevation
- ★ Adjustable LRAS-Type Floor Supports Available

HOW IT WORKS

The conveyor is made up of standard 60 in. long accumulation zones. Each zone extracts power from a flat drive belt that runs the entire length of the conveyor. Hytrol's EZ-Logic accumulation modules sense product presence and control the accumulation and release of product from the zones.

SIZE TO ORDER Overall Length "A"	Between Rail Width	39"	41"	43"	45"	47"	49"	51"	61"	73"	85"
	Overall Frame Width	42"	44"	46"	48"	50"	52"	54"	64"	76"	88"
10'	WEIGHTS (Lbs.)	1261	1296	1331	1366	1400	1435	1470	1645	1854	2063
15'		1764	1815	1867	1918	1970	2021	2072	2329	2638	2946
20'		2267	2335	2403	2471	2538	2606	2674	3014	3421	3828
25'		2770	2854	2939	3023	3107	3192	3276	3698	4204	4710
30'		3272	3373	3474	3575	3675	3776	3877	4382	4987	5592
35'		3776	3893	4011	4128	4245	4363	4480	5067	5771	6475
40'		4279	4413	4547	4680	4814	4948	5082	5751	6554	7357
45'		4781	4931	5082	5232	5382	5533	5683	6435	7337	8239
50'		5284	5451	5618	5784	5951	6118	6285	7119	8120	9121

All weights in catalog are conveyor weights only. Accessories, crating, etc., are not included.

Overall lengths in chart are for 60" zones. Other zone lengths will affect overall length.

CONTACT FACTORY FOR LENGTHS OVER 50'-0"

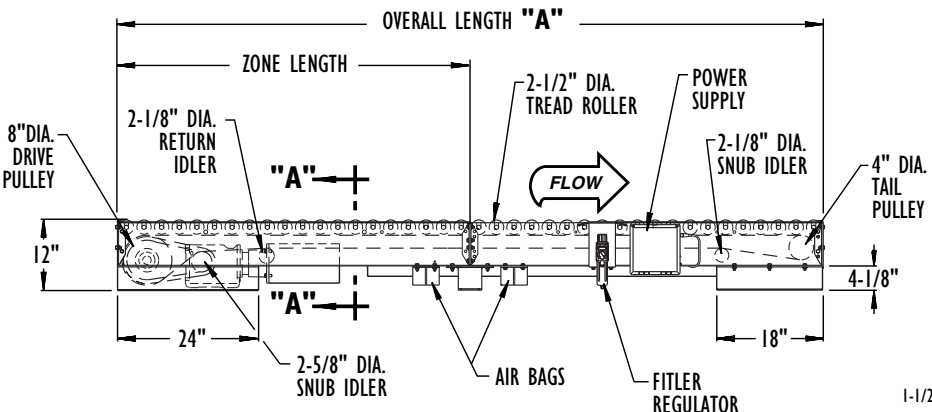
**ACCUMULATION ZONE LENGTHS					
3" Roller Centers		4" Roller Centers		6" Roller Centers	
*30"	Optional	*32"	Optional	*30"	Optional
*36"		*40"		*36"	
*42"		*48"		*42"	
*48"		*56"		*48"	
*54"		60"		*54"	
60"		72"		60"	
66"				66"	
72"				72"	

*MINIMUM INFEED DRIVE ZONE LENGTH IS 60" WITH 3", 4" & 6" ROLLER CENTERS.

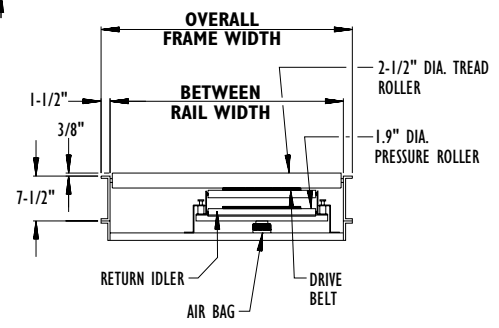
**FRAME LENGTH AND OVERALL LENGTH CHANGE WITH ZONE LENGTH.



ACCUMULATION - ZERO PRESSURE



NOTE: Offset belt only.



SECTION A-A

Standard Specifications

BELT—14 in. black PVC 120- CBS (cover both sides). Clipper unibar lacing.

BED—Roller bed with 2-1/2 in. dia. x 11 ga. unplated tread rollers spaced every 3 in. and 1.9 in. dia. x 16 ga. unplated pressure rollers spaced every 6 in. Mounted in 7-1/2 in. x 10 ga. powder painted formed steel channel frame. Bolted together with butt coupling.

END DRIVE—Located on infeed end of conveyor.

DRIVE PULLEY—8 in. dia. with 1-7/16 in. dia. shaft at bearings, machine crowned and fully lagged.

TAIL PULLEY—4 in. dia. with 1 in. dia. shaft, machine crowned.

SNUB IDLER—Adjustable 2-5/8 in. dia. at drive pulley, 2-1/8 in. dia. at tail pulley. Pre-lubricated ball bearings.

RETURN IDLER—2-1/8 in. dia. at drive end, all others 1.9 dia. unplated. Pre-lubricated ball bearings.

TAKE-UP—Take-up at tail pulley.

BEARINGS—Sealed, pre-lubricated, self-aligning ball bearings on drive and tail pulley. Sealed, pre-lubricated ball bearings in tread and pressure rollers.

ACCUMULATION ZONES—60 in. long with EZ-Logic Accumulation.

TREAD ROLLER BRAKE—Friction type brake stops tread rollers to prevent coasting of product in accumulation zone.

EZLogic® ACCUMULATION MODULE—Located in each zone (Diffuse). Power supply must be located in the center - maximum 50 zones per power supply. UL and CSA approved.

AIR REQUIREMENTS—Recommended working pressure 40 P.S.I. Free air consumption at 40 P.S.I.—.028 cu. ft. per sensor actuation.

FILTER, REGULATOR—Supplied for main air supply line. (3/8 in. NPT port).

SPEED REDUCTION—Sealed Helical—Bevel C-Face gear reducer. No.60 roller chain to drive pulley.

MOTOR—3/4 HP—230/460V—3 PH. 60 Hz. Totally Enclosed C-Face.

CONVEYING SPEED—Constant 30 FPM.

CAPACITY—Maximum load per linear foot of conveyor 1000 lbs. Maximum unit load 4000 lbs. Total load NOT TO EXCEED capacity in charts.

POWER SUPPLY—27 VDC, 4 amp Power Supply located near center of conveyor. Maximum of 50 zones per power supply (25 each side of power supply). Requires 120 VAC input.

FLOOR SUPPORTS—Now supplied as optional equipment.

EZLogic® Accumulation System

Hytrol's EZLogic®, or "Electronic Zero-pressure Logic" Accumulation System, combines the sensing accuracy of photo-electronics with discrete electronic logic control without the use of a PLC or pneumatic logic components. The EZLogic® Accumulation System provides many features including:

Zero-pressure accumulation of product

Zone Stop function is built in! Any zone may be transformed into a workstation by connecting the EZLogic® Accumulation Module to any dry contact type switching device. The feature is always used at the **discharge end** of the conveyor line, and may be used at any other location where a zone stop is required.

Sleep Mode stops tread rollers from turning when no product is present, reducing noise and extending roller bearing life.

Zone On delay timer delays the zone immediately upstream from a removed load, from driving for a set time. This feature is ideal where loads are routinely removed from the conveyor with a lift truck.

NOTE: Product footprint may affect drive capacity.

LOAD CAPACITY CHART (Accumulated) @ 30 FPM						
HP	OVERALL FRAME WIDTH 42" TO 48"		OVERALL FRAME WIDTH 50" TO 64"		OVERALL FRAME WIDTH 76" TO 88"	
	TOTAL LOAD (LBS.)		TOTAL LOAD (LBS.)		TOTAL LOAD (LBS.)	
	UP TO 25'	UP TO 50'	UP TO 25'	UP TO 50'	UP TO 25'	UP TO 50'
3/4	11400	7900	10300	5700	8700	2400
1	16500	12900	15400	10800	13700	7500
1 1/2	*20000	23000	*20000	20900	*20000	17600

*Limited to 4000# Per Accumulation Zone

Optional Equipment

FLOOR SUPPORTS—LRAS Type floor supports are available with a wide range of adjustment. Specify top of belt or roller elevation. One support required at every bed joint and ends of conveyor. Holes in feet for lagging to floor.

CONVEYING SPEED—Other constant speeds to 50 FPM. **NOTE: Capacity and accumulation feature affected with speed change.**

UNDERSIDE TAKE-UP—Provides 12 in. of belt take-up. Minimum elevation 12 in. (Required on units 40 ft. or longer.) Must be located in 4 ft. long intermediate section.

ACCUMULATION ZONES—See chart for intermediate and discharge zone lengths. Minimum length of infeed zone (drive) is 60 in. Frame length changes with zone length.

Note: 51 or more zones will require additional power supply and isolation cable.

O-RING DRIVE CHAIN—With sealed in lubricant (Recommended for applications that do not permit regular lubrication).

TREAD ROLLERS—2-5/8 in. dia. x 7 ga. unplated steel, 11/16 in. hex spring loaded shaft.

MOTORS—Energy efficient, single phase, other characteristics. 1-1/2 HP maximum.

ELECTRICAL CONTROLS—Non-reversing magnetic starter — push-button stations. AC variable frequency drive.

EZ-Logic :

- **Zone stop connector cable** - Attaches to any zone module. It requires a "dry contact" type input signal. Closed for zone stop.
- **Power supply isolation cable** - Used when joining conveyors with separate power supplies.
- **Accumulation module with photo eye output** - Used to supply "dry contact" photo eye output or to accept a voltage type zone stop input.
- **Retroreflective type module** - Mounts to sides of conveyor.