

Product Information

04/2016



Interroll Belt Conveyor Solutions  
**Spirals, Lifts, Merges,  
Chutes & The Interroll  
Portec Belt Curve**

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# Belt Conveyors & Merges: BM4081 (HD)

**BM4081 (HD)**

## > Interroll Belt Conveyor BM 4081 (HD)

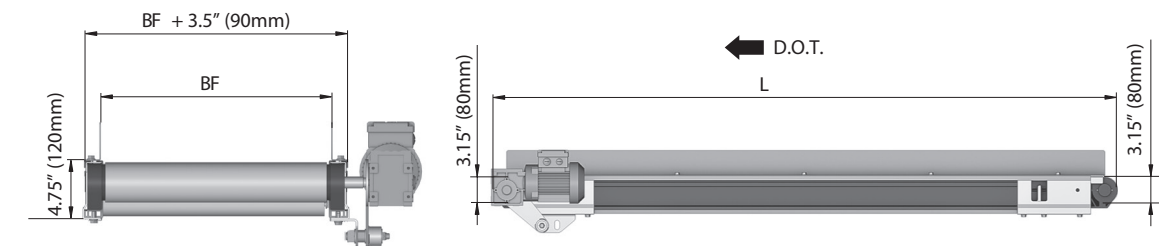
### The Interroll Belt Conveyor BM 4081 (Head Drive)


is a slider bed conveyor suitable  
for transporting boxes, containers, etc.



### Technical Data

General technical data	
Max. load capacity	35 lb/ft (50 kg/m)
Conveyor speed	20 to 200 ft/min (0.10 to 1.0 m/s)
Inclined/declined	Not suitable
Ambient temperature	+25 to +105 °F (-5 to + 40 °C)
Drive	
Available voltage	230 V / 60 Hz / 1 phase 480 V / 60 Hz / 3 phase
Motor type	Max. 1.0HP/.75kW drum motor or shaft-mounted gear motor
Diameter of drive roller	3.15" (80mm)
Diameter of idler roller	3.15" (80mm)
Bearings	Flange bearing, above 150 ft/min Self-aligning ball bearing, up to 150 ft/min
Materials	
Conveyor belt	Two-ply polyester fabric with PVC cover
Slider bed	Galvanized steel
Drive/idler roller	Aluminum extrusion with steel axles
Support legs	Fabricated steel or extruded aluminum, height adjustable
Side frame	
Side frame	Aluminum extrusion, height 4.75" (120mm)
Side guards (optional)	Fabricated steel or aluminum extrusion



 Arrow indicates direction of travel shown with optional gear motor.

### Dimensions

Width (BF)	12", 16", 20", 24", 30"
Conveyor length (L)	30" to 400" (762mm to 10,000mm)

# Belt Conveyors & Merges: BM4081 (CD)

**BM4081 (CD)**

## > Interroll Belt Conveyor BM 4081 (CD)

### The Interroll Belt Conveyor BM 4081 (Center Drive)

is a slider bed conveyor suitable for transporting boxes, containers, etc. over long lengths.



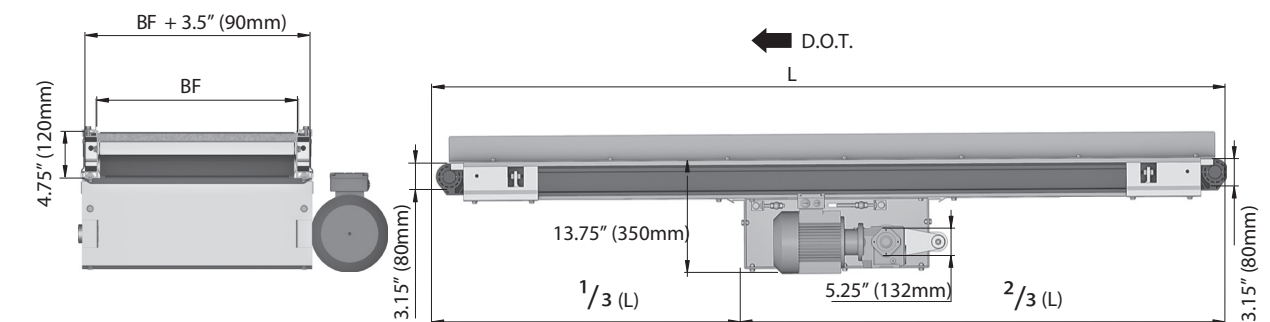
### Technical Data


General technical data	
Max. load capacity	35 lb/ft (50 kg/m)
Conveyor speed	20 to 400 ft/min (0.10 to 2.0 m/s)
Inclined/declined	Not suitable
Ambient temperature	+25 to +105 °F (-5 to + 40 °C)

Drive	
Available voltage	230 V / 60 Hz / 1 phase 480 V / 60 Hz / 3 phase
Motor type	Max. 5.0HP/3kW drum motor or shaft-mounted gear motor
Diameter of drive roller	5.25" (132mm)
Diameter of idler roller	3.15" (80mm)
Bearings	Flange bearing, above 150 ft/min Self-aligning ball bearing, up to 150 ft/min

Materials	
Conveyor belt	Two-ply polyester fabric with PVC cover
Slider bed	Galvanized steel
Drive/idler roller	Aluminum extrusion with steel axles
Support legs	Fabricated steel or extruded aluminum, height adjustable

Side frame	
Side frame	Aluminum extrusion, height 4.75" (120mm)
Side guards (optional)	Fabricated steel or aluminum extrusion



 Arrow indicates direction of travel shown with optional gear motor.

### Dimensions

Width (BF)	12", 16", 20", 24", 30"
Conveyor length (L)	60" to 1200" (1500mm to 30,000mm)



# Belt Conveyors & Merges: BM4081 (CD) Incline/Decline

## BM4081 (CD) INCLINE/DECLINE

### > Interroll Belt Conveyor BM 4081 (CD) Incline/Decline

#### The Interroll Belt Conveyor BM 4081 Incline/Decline (Center Drive)

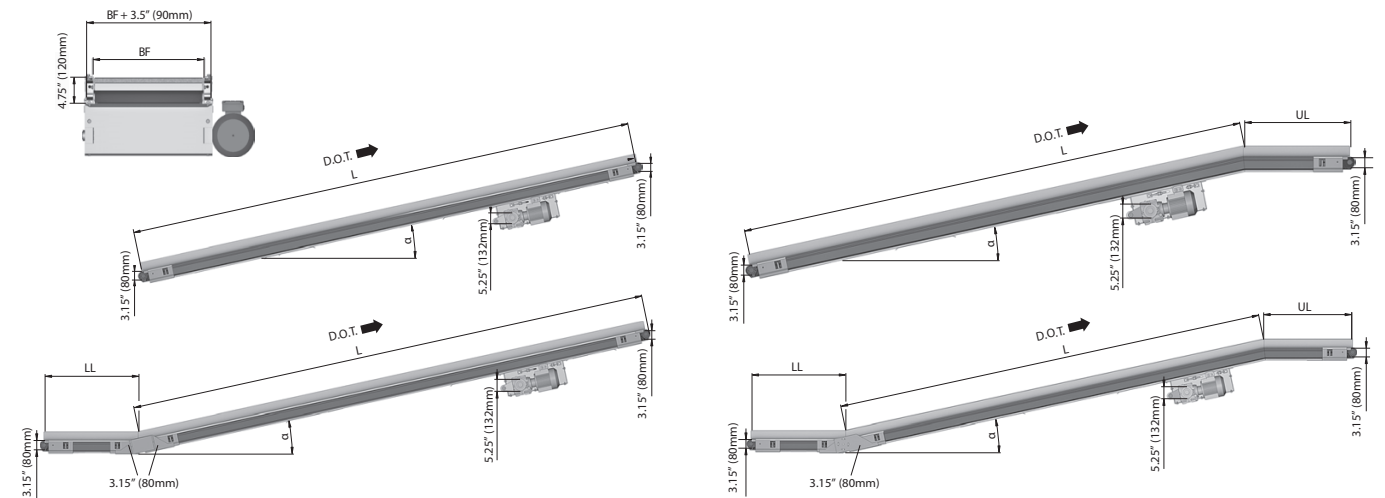
is suitable for transporting boxes, containers, etc. on inclines and declines.



### Technical Data

General technical data	
Max. load capacity	35 lb/ft (50 kg/m)
Conveyor speed	20 to 400 ft/min (0.10 to 2.0 m/s)
Inclined/declined	Suitable
Ambient temperature	+25 to +105 °F (-5 to + 40 °C)
<b>Drive</b>	
Available voltage	230 V / 60 Hz / 1 phase 480 V / 60 Hz / 3 phase
<b>Motor type</b>	
Diameter of drive roller	Max. 5.0HP/3kW drum motor or shaft-mounted gear motor
Diameter of idler roller	5.25" (132mm) 3.15" (80mm)
<b>Bearings</b>	
	Flange bearing, for speeds over 150 ft/min Self-aligning ball bearing, for speeds up to 150 ft/min
<b>Materials</b>	
Conveyor belt	Two-ply polyester fabric with longitudinally grooved cover
Slider bed	Galvanized steel
Drive/idler roller	Aluminum extrusion with steel axles
Support legs	Fabricated steel or extruded aluminum, height adjustable
Side frame	
Side frame	Aluminum extrusion, height 4.75" (120mm)
Side guards (optional)	Fabricated steel or aluminum extrusion

### Dimensions



Arrow indicates direction of travel shown with optional gear motor.

# Belt Conveyors & Merges: Belt Merge

## BELT MERGE

### > Multi Conveyor Merging Operations

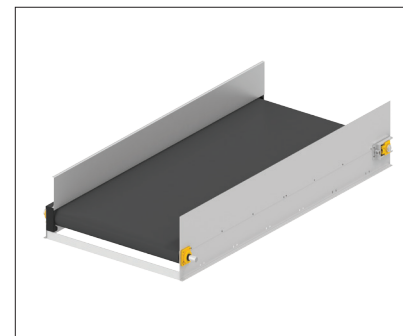
#### When You Need To Merge Two or More Conveyor Lines.

The Most Reliable - Belt Merge Conveyors from Interroll!



Interroll Belt Merge Conveyors facilitate the merging of two or more conveyor lines into a single product transport line and provide a solution to belt tracking problems found whenever a short wide belt conveyor is utilized.

Manufactured by the world's most reliable producer of specialty conveyor equipment, Belt Merge Conveyors eliminate side load tracking problems encountered on regular belt conveyors. These units are specially designed for manufacturing, warehouse/distribution center and airline baggage applications. An optional series of fixed position bed idler rollers allows for the safe, smooth transition of extra-heavy product loads.



### Technical Specifications

#### General technical data

Max. Load Capacity	50 lbs/ft
Max. Conveyor Load	500 LBS
Conveyor Speed At CL	0 - 568 fpm
Ambient temperature	5° - 176° F

#### Drive Data

Rated Voltage	400V / 50HZ / 3PH 460V / 60HZ / 3PH
Power	.5HP - 7.5HP
Motor Type	Gear Motor
Drive Mount	Shaft Mounted
End Roll Diameter	6 in

#### Materials

Belt Material	PHR 3-135 MF FR BB x BB
Construction	10 gauge / 3mm
Shaft Size	1 15/16"
Drive Chain	Tsubaki #50 Or #60
Finish	RAL DTM
Bearings	Peer MHS

#### Dimensions

Frame Height	10-5/8 in / 270mm
Length	60" - 360"
LW Clearance (BSG)	10-5/8 in / 270mm
Min TOB Height	10-5/8 in / 270mm
Side Guards	0" - 12"

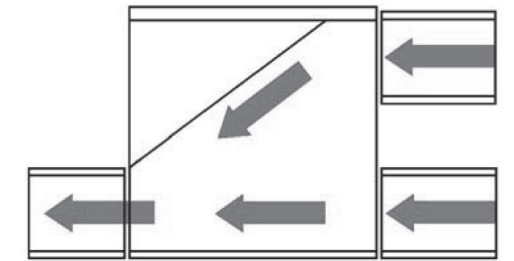
#### Options

Underguarding	Expanded Metal Solid Metal Pinned Solid Steel Plastic Mesh
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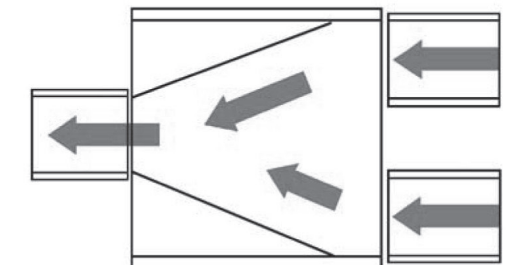
#### Drive Mount Styles

Support	2" Square tubing 3" Square tubing H/S Supports Floor Blocks Ceiling Hanger
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#### Single Chain Merge Application (Lateral force on belt in one direction only)



#### Double Chain Merge Application (Lateral force on belt in two directions)



#### Diverters

Fixed diverters are custom-designed for your installation.

#### > Positive Drive Belt System

The conveyor belt is positively driven by a shaft mounted sprocket engaging a precision sidebow chain which is attached directly to the outside edge of the belt. This positive drive system is unaffected by changes in loading, tension, temperature, humidity, and foreign material on the belt. The positive drive belt system ensures continuous, reliable operation even in harsh and difficult environments with minimal maintenance.



**Note:** the above models are examples only. Each conveyor is custom designed for your application.

# Belt Conveyors & Merges: Angle Merges

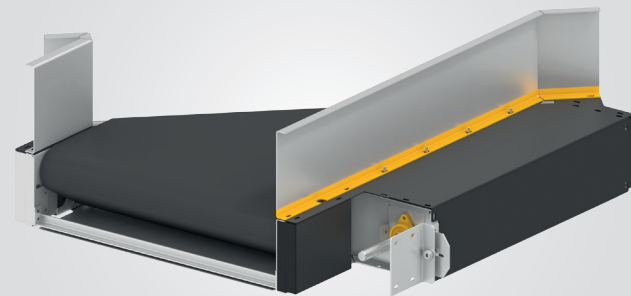
## > Merging Diverging Operations

For merging or diverging operations, Interroll has what you are looking for.

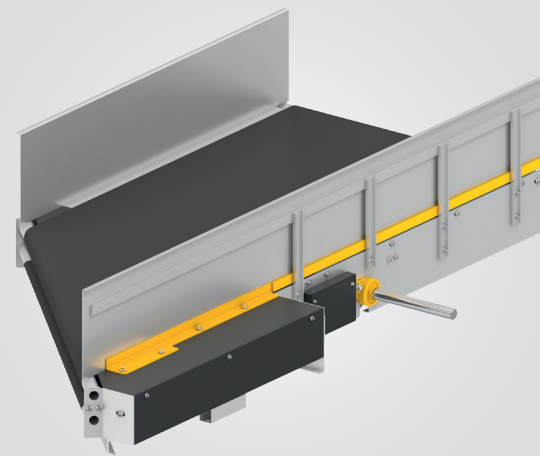
Interroll Angle Merge Conveyors facilitate the merging or diverging of two conveyor lines in a smooth and efficient manner.

### Key Features include:

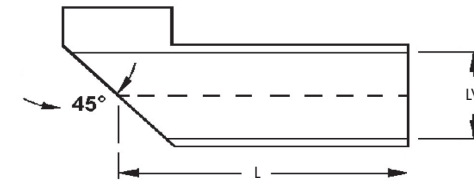
- Low friction angle bar
- 30 (Angle-Flo only) or 45 degree angles
- Spring take-up tension system (Angle-Flo only)
- Quiet operation
- Smooth positive angular transfer of products
- Simple belt tracking system
- Low maintenance
- Heavy duty steel construction
- Transfers small products
- Laced belt for quick change



AMS® (Angle Merge Short)

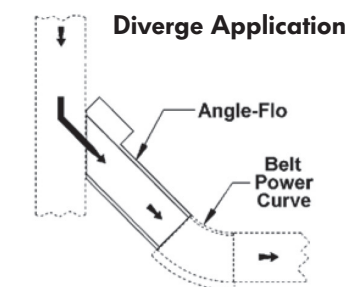
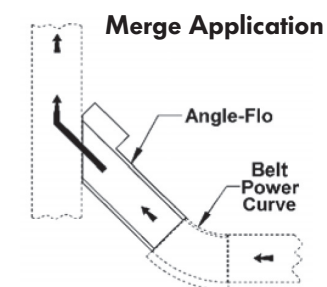


Angle-Flo

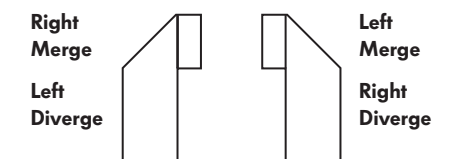


### Merge Model Dimensions

Model	AXL	AX	AXH	AMS®
<b>General Technical Data</b>				
Max Load Capacity	40 lbs/ft	40 lbs/ft	40 lbs/ft	40 lbs/ft
Max Conveyor Load				
Conveyor Speed At CL	75 - 140 fpm	75 - 350 fpm	75 - 350 fpm	75 - 350 fpm
Merge Angle	45 or 30 Degrees	45 or 30 Degrees	45 or 30 Degrees	45 Degree
Direction	Merge / Diverge	Merge / Diverge	Merge / Diverge	Merge / Diverge
Ambient Temperature	5° - 176° F	5° - 176° F	5° - 176° F	5° - 176° F
<b>Drive Data</b>				
Rated Voltage	400V / 50HZ / 3PH	400V / 50HZ / 3PH	400V / 50HZ / 3PH	400V / 50HZ / 3PH
	460V / 60HZ / 3PH	460V / 60HZ / 3PH	460V / 60HZ / 3PH	460V / 60HZ / 3PH
	110V / 220V / 60HZ / 1PH	110V / 220V / 60HZ / 1PH	110V / 220V / 60HZ / 1PH	110V / 220V / 60HZ / 1PH
Power	.5HP - 2HP	.5HP - 5HP	.5HP - 5HP	3HP
Motor Type	Gear Motor	Gear Motor	Gear Motor	Gear Motor
Drive Mount	Shaft Mounted	Shaft Mounted	Shaft Mounted	Shaft Mounted
End Roll Diameter	2 in	2.5 in	3.5 in	6 in
<b>Materials</b>				
Belt Material	Flexam EF 10/2 0+07 Black M2 FR	Flexam EF 10/2 0+07 Black M2 FR	Flexam EF 10/2 0+07 Black M2 FR	Flexam EF 10/2 0+07 Black M2 FR
	Others upon Request	Others upon Request	Others upon Request	Others upon Request
Construction	10 gauge / 3mm	10 gauge / 3mm	10 gauge / 3mm	10 gauge / 3mm
Shaft Size	1" - 1-3/16" 25mm - 30mm	1 7/16" 35mm	1-7/16" - 1-11/16" 35mm - 45mm	1-7/16" 35mm
Finish	RAL DTM	RAL DTM	RAL DTM	RAL DTM
Bearings	Peer MHS	Peer MHS	Peer MHS	Peer MHS
<b>Dimensions</b>				
Frame Height	7 in / 177mm	8.5 in / 216mm	12 in / 216mm	12 in / 216mm
Length (CL) Merge/Diverge	31" / 44"	41" / 57"	60" / 72"	36"
Min Clearance (BSG)	13"	29"	39"	39"
Min TOB Height	7 in / 177mm	8.5 in / 216mm	12 in / 216mm	12 in / 216mm
Side Guards	0" - 12"	0" - 21"	0" - 21"	12" or 21"
<b>Options</b>				
Belt Construction	Laced/ Vulcanized Belt	Laced/ Vulcanized Belt	Laced/ Vulcanized Belt	Laced
Underguarding	Expanded Metal	Expanded Metal	Expanded Metal	
	Solid Metal Pinned	Solid Metal Pinned	Solid Metal Pinned	Solid Metal included
	Plastic Mesh	Plastic Mesh	Plastic Mesh	
Supports	2" Square tubing	2" Square tubing	2" Square tubing	2" Square tubing
	H/S Supports	H/S Supports	H/S Supports	H/S Supports
	Floor Blocks	Floor Blocks	Floor Blocks	Floor Blocks
	Ceiling Hanger	Ceiling Hanger	Ceiling Hanger	Ceiling Hanger
Drip Pans	Available	Available	Available	Available



### Direction of travel



### Belt Drive System (Angle Flo only):

The conveyor belt is driven by its bottom side contacting a heavy duty lagged drive roll. Contamination of the belt surface does not effect the conveyor operation. A spring-loaded take-up maintains even belt tension even through changes in loading and temperature.



**Note:** the above dimensions are for Merge units only and represent the shortest length for the conveying width. Diverge units are typically longer. Call the factory for minimum lengths for diverge units. The above models are examples that show the narrowest and widest conveying widths for each frame height.

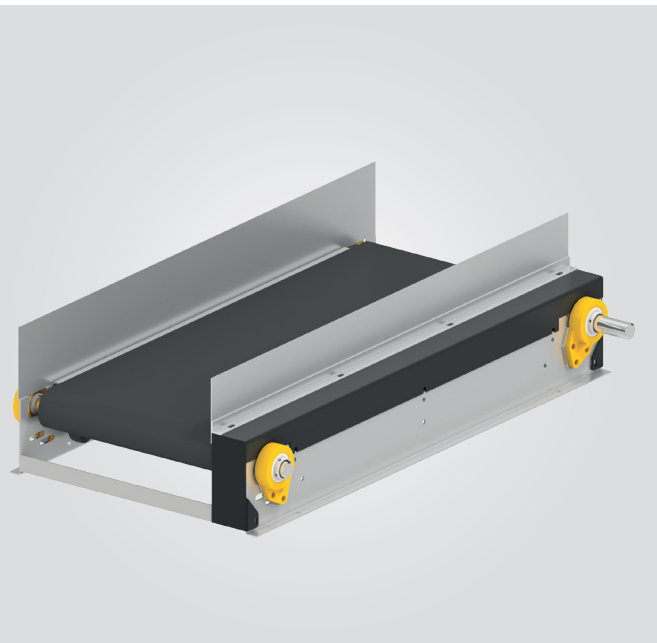
# Belt Conveyors & Merges: Queue-Flo

QUEUE-FLO

## > Positive Drive Queuing Conveyor

### The Queue-Flo belt conveyor from Interroll

is a perfect solution whenever a positive-drive queuing conveyor or short, wide belt conveyor is required.



**The positive-drive system ensures belt tracking without special adjustments and rugged dependability under heavy duty induction or metering applications.**

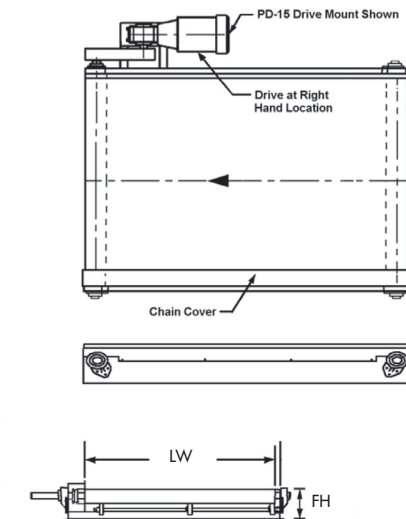
The Queue-Flo is ideal for indexing, as the chain drive assures no belt drift. It is also ideal as a "gap" conveyor where a short length and wide belt width are required.

## > Positive Drive Belt System

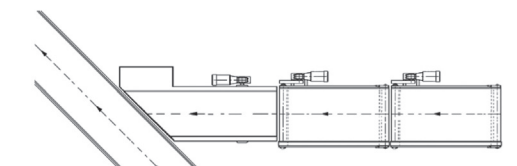
The conveyor belt is positively driven by a shaft mounted sprocket engaging a precision sidebow chain which is attached directly to the outside edge of the belt. This positive drive system is unaffected by changes in loading, tension, temperature, humidity, and foreign material on the belt. The positive drive belt system ensures continuous, reliable operation even in harsh and difficult environments with minimal maintenance.

## Technical Specifications

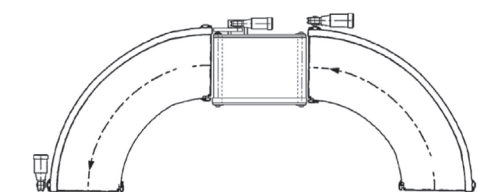
<b>Sprocket Size</b>	17
<b>General Technical Data</b>	
<b>Max Load Capacity</b>	40 lbs/ft
<b>Max Conveyor Load</b>	500 LBS
<b>Conveyor Speed At CL</b>	0 - 300 fpm / 1.78 m/s
<b>Ambient Temperature</b>	5° - 176° F
<b>Drive Data</b>	
<b>Rated Voltage</b>	400V / 50HZ / 3PH 460V / 60HZ / 3PH 110V / 220V / 60HZ / 1PH
<b>Power</b>	.5HP - 2HP
<b>Motor Type</b>	Gear Motor
<b>Drive Mount</b>	Shaft Mounted
<b>End Roll Diameter</b>	3-3/8 in
<b>Materials</b>	
<b>Belt Material</b>	Flexam EF 10/2 0+A22 Black AS FR (Accumulation) PVOP (Queuing) Others upon Request
<b>Construction</b>	12 gauge / 2mm
<b>Shaft Size</b>	1-7/16" 35mm
<b>Drive Chain</b>	Tsubaki #50 Sidebow
<b>Finish</b>	RAL DTM
<b>Bearings</b>	Peer MHS
<b>Dimensions</b>	
<b>Frame Height</b>	7 in / 177mm
<b>Length</b>	18" - 240"
<b>LW Clearance (BSG)</b>	7" to 60"
<b>Min TOB Height</b>	7 in / 177mm
<b>Side Guards</b>	0" - 21"
<b>Options</b>	
<b>Underguarding</b>	Expanded Metal Solid Steel Plastic Mesh
<b>Drive Mount Styles</b>	
<b>Supports</b>	2" Square tubing H/S Supports Floor Blocks Ceiling Hanger



## Queuing an induction angle Merge Conveyor



## Short straight Conveyor between two Belt Curves



**Note:** Contact factory for applications requiring higher loads or speeds.



# Belt Curves: Interroll Portec Belt Curve

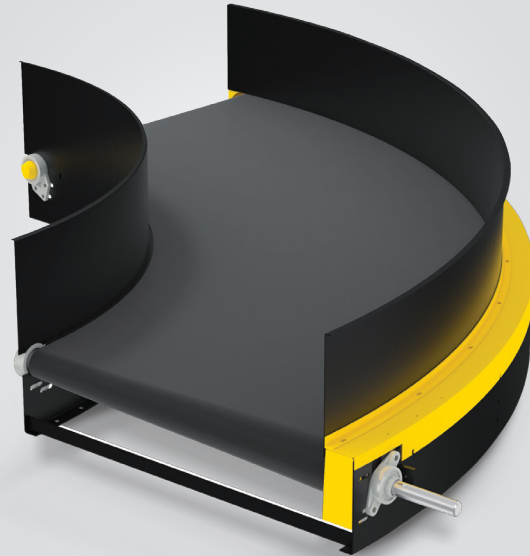
## INTERROLL PORTEC BELT CURVE

### > Interroll Portec Belt Curve

The Interroll Portec Belt Curve has been specifically designed to provide trouble-free performance for many years in a variety of applications.

#### Proven Interroll Portec Technology

- Smooth product transfers
- Low noise operation
- Complies with latest safety and sanitary standards
- Wide conveying widths available
- Custom designed for your specific application
- Low belt tension for long component life
- Rugged steel construction - no shortcuts or inferior materials
- Positive drive belt system means no end roll slip
- Simplified maintenance enhancements



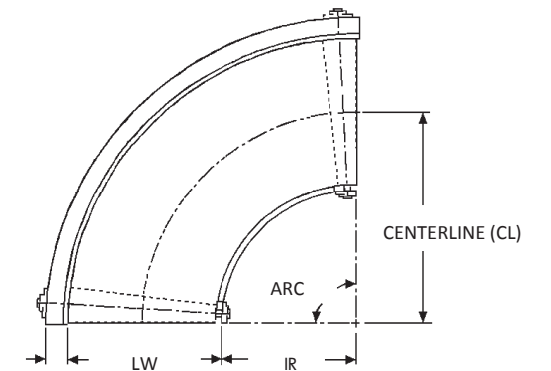
The design accommodates many variations in width, arc, and weight conveyance. The laced belt can be changed within a very short time and does not require the removal of the drive package. Our Belt Curve can operate in much higher and lower ambient temperatures than a friction-driven conveyor and reaches speeds of more than 3 meters per second (600+ feet / minute).

The combination of heavy duty equipment, durability and simple maintenance matched with quiet, high speed operation make Interroll the company of choice for material handling professionals the world over.



#### Positive Drive Belt System

The conveyor belt is positively driven by a shaft mounted sprocket engaging a precision sidebow chain which is attached directly to the outside edge of the belt. This positive drive system is unaffected by changes in loading, tension, temperature, humidity, and foreign material on the belt. The positive drive belt system ensures continuous, reliable operation even in harsh and difficult environments with minimal maintenance.



#### Technical Specifications

Sprocket size	17	27	40
<b>General Technical Data</b>			
<b>Max Load Capacity</b>	30 lbs./ft.	50 lbs./ft. w/o Bedrolls 75 lbs./ft. w/o Single bedrolls 150 lbs./ft. w/o Double bedrolls	50 lbs./ft. w/o Bedrolls 75 lbs./ft. w/o Single bedrolls 150 lbs./ft. w/o Double bedrolls
<b>Max Conveyor Load</b>	250 lbs. OCR <=47" OCR	500 lbs. OCR <=87"	500 lbs. OCR <=168"
<b>Conveyor speed at CL</b>	0 - 250 FPM	0 - 375 FPM	0 - 560 fpm
<b>Ambient temperature</b>	5° - 176° F	5° - 176° F	5° - 176° F
<b>Drive Data</b>			
<b>Rated voltage</b>	400V / 50HZ / 3PH 460V / 60HZ / 3PH 110V / 220V / 60HZ / 1PH	400V / 50HZ / 3PH 460V / 60HZ / 3PH 110V / 220V / 60HZ / 1PH	400V / 50HZ / 3PH 460V / 60HZ / 3PH 110V / 220V / 60HZ / 1PH
<b>Power</b>	.5HP - 2HP	.5HP - 5HP	5HP - 7.5HP
<b>Motor Type</b>	Gear Motor	Gear Motor	Gear Motor
<b>Drive Mount</b>	Shaft Mounted	Shaft Mounted	Shaft Mounted
<b>End roll diameter at OR</b>	3 in	5 in	7.5 in
<b>Materials</b>			
<b>Belt Material</b>	Flexam EF 10/2 0+A22 Black AS FR Others upon request	Flexam EF 10/2 0+A22 Black AS FR Others upon request	Flexam EF 10/2 0+A22 Black AS FR Others upon request
<b>Construction</b>	12 Gauge Steel / 2.5 mm	12 Gauge Steel / 2.5 mm	12 Gauge Steel / 2.5 mm
<b>Shaft Size</b>	1" - 1-3/16" 25mm - 30mm	1-3/16" - 1-7/16" 30mm - 35mm	1-7/16" - 1 15/16" 35mm - 45mm
<b>Drive Chain</b>	Tsubaki #50 Sidebow	Tsubaki #50 Sidebow	Tsubaki #50 Sidebow
<b>Finish</b>	RAL DTM	RAL DTM	RAL DTM
<b>Bearing</b>	Peer MHS	Peer MHS	Peer MHS
<b>Dimensions</b>			
<b>Frame Height</b>	7 in / 177 mm	8.5 in / 216 mm	12 in / 305 mm
<b>Angle</b>	15 - 180 Degrees	15 - 180 Degrees	15 - 180 Degrees
<b>Inner Radius (IR)</b>	12" - 87"	17" - 87"	17" - 168"
<b>LW Clearance (BSG)</b>	Dependent on IR	Dependent on IR	Dependent on IR
<b>Min TOB Height</b>	7 in / 177mm	8.5 in / 216 mm	12 in / 305 mm
<b>Side Guards</b>	0" - 12"	0" - 12"	0" - 12"
<b>Options</b>			
<b>Vulcanized Unit</b>			
<b>Drip Hands Optional</b>			
<b>Drive Mount Style</b>			
<b>Nickel Plate Components</b>			
<b>Underguarding</b>	Expanded Metal Solid Metal Pinned Solid Steel Plastic Mesh	Expanded Metal Solid Metal Pinned Solid Steel Plastic Mesh	Expanded Metal Solid Metal Pinned Solid Steel Plastic Mesh
<b>Supports</b>	2" Square tubing 3" Square tubing H/S Supports Floor Blocks Ceiling Hanger	2" Square tubing 3" Square tubing H/S Supports Floor Blocks Ceiling Hanger	2" Square tubing 3" Square tubing H/S Supports Floor Blocks Ceiling Hanger

# Belt Curve Airport Applications

## > Interroll Portec Belt Curve Airport Applications

Sprocket size	27	40
<b>General Technical Data</b>		
<b>Max Load Capacity</b>	50 lbs/ft	50 lbs/ft
<b>Max Conveyor Load</b>	500 lbs OCR <=87"	500 lbs OCR <=87"
<b>Conveyor speed at CL</b>	0 - 375 fpm	0 - 560 FPM
<b>Ambient temperature</b>	5° - 176° F	5° - 176° F
<b>Drive Data</b>		
<b>Rated voltage</b>	400V / 50HZ / 3PH 460V / 60HZ / 3PH	400V / 50HZ / 3PH 460V / 60HZ / 3PH
<b>Power</b>	1HP - 5HP	1HP - 7.5HP
<b>Motor Type</b>	Gear Motor	Gear Motor
<b>Drive Mount</b>	Shaft Mounted	Shaft Mounted
<b>End Roll Diameter</b>	5 in	7.5"
<b>Materials</b>		
<b>Belt Material</b>	Flexam EF 10/2 0+A22 Black AS FR Others upon Request	Flexam EF 10/2 0+A22 Black AS FR Others upon Request
<b>Construction</b>	12 gauge / 2.5mm	12 gauge / 2.5mm
<b>Shaft Size</b>	1-7/16" - 1-11/16" 35mm - 45mm	1-7/16" - 1-11/16" 35mm - 45mm
<b>Drive Chain</b>	Tsubaki #50 Sidebow	Tsubaki #50 Sidebow
<b>Finish</b>	RAL DTM	RAL DTM
<b>Bearing</b>	Peer MHS	Peer MHS
<b>Dimensions</b>		
<b>Frame Height</b>	8.5 in / 216mm	12 in / 305mm
<b>Angle</b>	15 - 180 Degrees	15 - 180 Degrees
<b>Inner Radius (IR)</b>	48"	48"
<b>LW Clearance (BSG)</b>	39"	39"
<b>Min TOB Height</b>	8.5 in / 216mm	12 in / 305mm
<b>Side Guards</b>	12" or 21"	12" or 21"
<b>Options</b>		
<b>Underguarding</b>	Expanded Metal Solid Metal Pinned Solid Steel Plastic Mesh	Expanded Metal Solid Metal Pinned Solid Steel Plastic Mesh
<b>Mark and Tag</b>	Vinyl Stencil	Vinyl Stencil
<b>Supports</b>	2" Square tubing 3" Square tubing H/S Supports Floor Blocks Ceiling Hanger	2" Square tubing 3" Square tubing H/S Supports Floor Blocks Ceiling Hanger
<b>Drip Pan</b>	Standard Standard w/ Drain Plug	Standard Standard w/ Drain Plug

# Belt Curve CEP Applications

## > Interroll Portec Belt Curve CEP Applications

Sprocket size	27	40
<b>General Technical Data</b>		
<b>Max Load Capacity</b>	50 lbs/ft 75 lbs/ft w/Single Bedrolls 150 lbs./ft. w/Double bedrolls	50 lbs/ft 75 lbs./ft. w/Single bedrolls 150 lbs./ft. w/Double bedrolls
<b>Max Conveyor Load</b>	500 lbs OCR <=87"	500 lbs OCR <=168"
<b>Conveyor speed at CL</b>	0 - 375 fpm	0 - 560 FPM
<b>Ambient temperature</b>	5° - 176° F	5° - 176° F
<b>Drive Data</b>		
<b>Rated voltage</b>	400V / 50HZ / 3PH 460V / 60HZ / 3PH	400V / 50HZ / 3PH 460V / 60HZ / 3PH
<b>Power</b>	.5HP - 5HP	.5HP - 7.5HP
<b>Motor Type</b>	Motor / Reducer	Motor / Reducer
<b>Drive Mount</b>	Shaft Mounted	Shaft Mounted
<b>End roll diameter</b>	5 in	7.5"
<b>Materials</b>		
<b>Belt Material</b>	PHR2-160 LI 3/64 X BB E 12/2 U0/V6 GSTR-C-SE	PHR2-160 LI 3/64 X BB E 12/2 U0/V6 GSTR-C-SE
<b>Construction</b>	12 gauge / 2.5mm	12 gauge / 2.5mm
<b>Shaft Size</b>	1-7/16" - 1-11/16" 35mm - 45mm	1-7/16" - 1 15/16" 35mm - 45mm
<b>Drive Chain</b>	Tsubaki #50 Sidebow	Tsubaki #50 Sidebow
<b>Finish</b>	RAL DTM	RAL DTM
<b>Bearing</b>	Peer MHS	Peer MHS
<b>Dimensions</b>		
<b>Frame Height</b>	8.5 in / 216mm	12 in / 305mm
<b>Angle</b>	15 - 180 Degrees	15 - 180 Degrees
<b>Inner Radius (IR)</b>	60", 72", or 96"	60", 72", or 96"
<b>LW Clearance (BSG)</b>	43", 49" or 61.5"	43", 49" or 61.5"
<b>Min TOB Height</b>	8.5 in / 216mm	12 in / 305mm
<b>Side Guards w/Belt Wiper</b>	12" or 21"	12" or 21"
<b>Options</b>		
<b>Bulk Flow (UPS)</b>	N/A	
<b>Memo Lube</b>		
<b>Tsubaki Shock Relay (UPS)</b>		
<b>End Roll Guards (UPS)</b>		
<b>Underguarding</b>	Expanded Metal or Solid Metal	Expanded Metal or Solid Metal
<b>Supports</b>	2" Square tubing 3" Square tubing H/S Supports Floor Blocks Ceiling Hanger	2" Square tubing 3" Square tubing H/S Supports Floor Blocks Ceiling Hanger



# Belt Curves: Z-Turn Interroll Portec Belt Curve

**Z-TURN**

## > Small Inside Radius Curve

### Proven Interroll Portec Technology

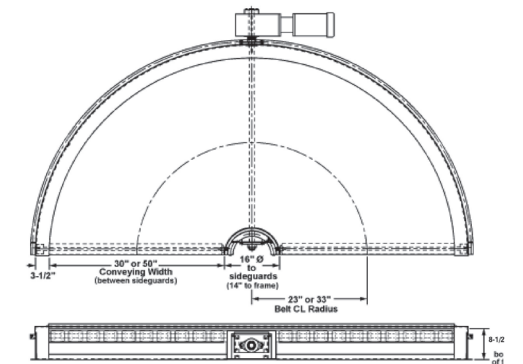
- Small inside radius for space-saving conveyor layout
- Cylindrical end rolls for outstanding product transfers
- Bi-directional operation
- Positive drive belt system means no end roll slip
- Low belt tension for long component life
- Custom designed for your specific application
- Low noise operation
- Rugged steel construction - no shortcuts or inferior materials
- Simplified maintenance enhancements



**A compact, quiet and reliable 180 degree belt power curve.**

## Technical Specifications

Sprocket size	8ZT30	8ZT50
<b>General Technical Data</b>		
Max Load Capacity	40 lbs/ft	40 lbs/ft
Max Conveyor Load	240 lbs	350 lbs
Conveyor speed at CL	0 - 170 fpm	0 - 170 FPM
Ambient temperature	5° - 176° F	5° - 176° F
<b>Drive Data</b>		
Rated voltage	400V / 50HZ / 3PH	400V / 50HZ / 3PH
	460V / 60HZ / 3PH	460V / 60HZ / 3PH
	110V / 220V / 60HZ / 1PH	110V / 220V / 60HZ / 1PH
Power	.5HP - 2HP	.5HP - 5HP
Motor Type	Gear Motor	Gear Motor
Drive Mount	Shaft Mounted	Shaft Mounted
End Roll Diameter	3 in	3 in
<b>Materials</b>		
Belt Material	Flexam EF 10/2 0	Flexam EF 10/2 0
	+A22 Black AS FR	+A22 Black AS FR
Construction	12 gauge / 2.5mm	12 gauge / 2.5mm
Shaft Size	1-7/16" 35mm	
Drive Chain	Tsubaki #50 Sidebow	Tsubaki #50 Sidebow
Finish	RAL DTM	RAL DTM
Bearing	Peer MHS	Peer MHS
<b>Dimensions</b>		
Frame Height	8.5 in / 216mm	8.5 in / 216mm
Angle	180 Degrees	180 Degrees
Inner Radius (IR)	8"	8"
LW Clearance (BSG)	30"	50"
Min TOB Height	8.5 in / 216mm	12 in / 305mm
Side Guards	0" - 12"	0" - 12"
<b>Options</b>		
Underguarding	Expanded Metal	Expanded Metal
	Solid Steel	Solid Steel
	Plastic Mesh	Plastic Mesh
Supports	2" Square tubing	2" Square tubing
	3" Square tubing	3" Square tubing
	H/S Supports	H/S Supports
	Floor Blocks	Floor Blocks
	Ceiling Hanger	Ceiling Hanger
<b>Drive Mount Styles</b>		
Drip Pan	Standard	Standard
	Standard w/ Drain Plug	Standard w/ Drain Plug



## > Positive Drive Belt System

The conveyor belt is positively driven by a shaft mounted sprocket engaging a precision sidebow chain which is attached directly to the outside edge of the belt. This positive drive system is unaffected by changes in loading, tension, temperature, humidity, and foreign material on the belt. The positive drive belt system ensures continuous, reliable operation even in harsh and difficult environments with minimal maintenance.

# Belt Curves: Spiral Curves

## SPIRAL CURVE

### > Elevation and Directional Unit Handling

#### Proven Interroll Technology

- High speed capacity
- Low noise operation
- Positive drive belt system means no end roll slip
- Rugged steel construction - no shortcuts, such as wood components
- Low belt tension for long component life
- Wide conveying widths available
- Simplified maintenance enhancements
- Complies with latest safety standards
- Over 57 years experience Interroll invented the Spiral Curve belt conveyor



### Getting up and around made easy...

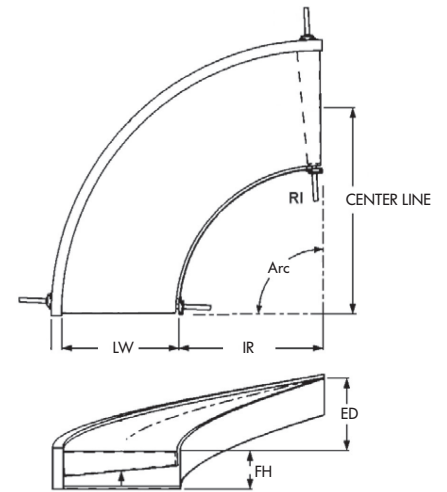
#### Interroll Spiral Curve

#### > Positive Drive Belt System

The conveyor belt is positively driven by a shaft mounted sprocket engaging a precision sidebow chain which is attached directly to the outside edge of the belt. This positive drive system is unaffected by changes in loading, tension, temperature, humidity, and foreign material on the belt. The positive drive belt system ensures continuous, reliable operation even in harsh and difficult environments with minimal maintenance.

### Technical Specifications

Sprocket size	17	27	40
<b>General Technical Data</b>			
<b>Max Load Capacity</b>	30 lbs/ft	50 lbs/ft 75 lbs/ft w/ Single Bedrolls 150 lbs/ft w/ Double Bedrolls	50 lbs/ft 75 lbs/ft w/ Single Bedrolls 150 lbs/ft w/ Double Bedrolls
<b>Max Conveyor Load</b>	250 lbs OCR <=47"	500 lbs OCR <=87"	500 lbs OCR <=87"
<b>Conveyor speed at CL</b>	0 - 250 fpm	0 - 350 fpm	0 - 350 fpm
<b>Inclined / Declined</b>	Angle Dependent on OCR	Angle Dependent on OCR	Angle Dependent on OCR
<b>Ambient temperature</b>	5° - 176° F	5° - 176° F	5° - 176° F
<b>Drive Data</b>			
<b>Rated voltage</b>	400V / 50HZ / 3PH 460V / 60HZ / 3PH 110V / 220V / 60HZ / 1PH	400V / 50HZ / 3PH 460V / 60HZ / 3PH 110V / 220V / 60HZ / 1PH	400V / 50HZ / 3PH 460V / 60HZ / 3PH 110V / 220V / 60HZ / 1PH
<b>Power</b>	.5HP - 2HP	.5HP - 5HP	.5HP - 7.5HP
<b>Motor Type</b>	Gear Motor	Gear Motor	Gear Motor
<b>Drive Mount</b>	Shaft Mounted	Shaft Mounted	Shaft Mounted
<b>OR End Roll Diameter</b>	3 in	5 in	7.5"
<b>Materials</b>			
<b>Belt Material</b>	PHR 2-160 GR11 RTxBB Black PHR2-160 LI 3/64 X BB Others upon Request	PHR 2-160 GR11 RTxBB Black PHR2-160 LI 3/64 X BB Others upon Request	PHR 2-160 GR11 RTxBB Black PHR2-160 LI 3/64 X BB Others upon Request
<b>Construction</b>	12 gauge / 2.5mm	12 gauge / 2.5mm	12 gauge / 2.5mm
<b>Shaft Size</b>	1" - 1-3/16" 25mm - 30mm	1" - 1-7/16" 25mm - 35mm	1-7/16" 1 15/16" 35mm - 45mm
<b>Drive Chain</b>	Tsubaki #50 Sidebow	Tsubaki #50 Sidebow	Tsubaki #50 Sidebow
<b>Finish</b>	RAL DTM	RAL DTM	RAL DTM
<b>Bearing</b>	Peer MHS	Peer MHS	Peer MHS
<b>Dimensions</b>			
<b>Frame Height</b>	7 in / 177mm	8.5 in / 216mm	12 in / 305mm
<b>Angle</b>	15 - 180 Degrees	16 - 180 Degrees	17 - 180 Degrees
<b>Inner Radius (IR)</b>	12" - 87"	17" - 87"	17" - 168"
<b>LW Clearance (BSG)</b>	Dependent on IR	Dependent on IR	Dependent on IR
<b>Min TOB Height</b>	7 in / 177mm	8.5 in / 216mm	12 in / 305mm
<b>Side Guards</b>	0" - 21"	0" - 21"	0" - 21"
<b>Options</b>			
<b>Underguarding</b>	Expanded Metal Solid Metal Pinned Solid Steel Plastic Mesh	Expanded Metal Solid Metal Pinned Solid Steel Plastic Mesh	Expanded Metal Solid Metal Pinned Solid Steel Plastic Mesh
<b>Drive Mount Styles</b>			
<b>Mark and Tag</b>	Vinyl Stencil	Vinyl Stencil	Vinyl Stencil
<b>Supports</b>	2" Square tubing 3" Square Tubing H/S Supports Floor Blocks Ceiling Hanger	2" Square tubing 3" Square Tubing H/S Supports Floor Blocks Ceiling Hanger	2" Square tubing 3" Square Tubing H/S Supports Floor Blocks Ceiling Hanger
<b>Drip Pan</b>	Standard Standard w/ Drain Plug	Standard Standard w/ Drain Plug	Standard Standard w/ Drain Plug



# Belt Curves: Spiral Lift

## > Continuous Vertical Unit Handling

The answer to your vertical conveying needs

### Spiral-Lift Applications

- Beverages
- Printing Plants/Newspapers
- Mail Order Companies
- Distribution Centers
- Factories
- Airport Baggage Handling
- Medical Devices
- Food Processing Facilities

### Convey It Up or Down

- Saves floor space
- Requires no metering, accumulation or indexing
- Positive drive belt system means no end roll slip
- Wide selection of entry and exit combinations
- Custom designed for your particular operation
- Durable all steel construction
- Fully assembled or modular construction
- High conveying speeds available
- Steep angles of incline/decline available (over 21° @ centerline)
- Wide belt widths available
- Over 40 years experience building spiral belt conveyors
- No exposed pinch points over or under belt

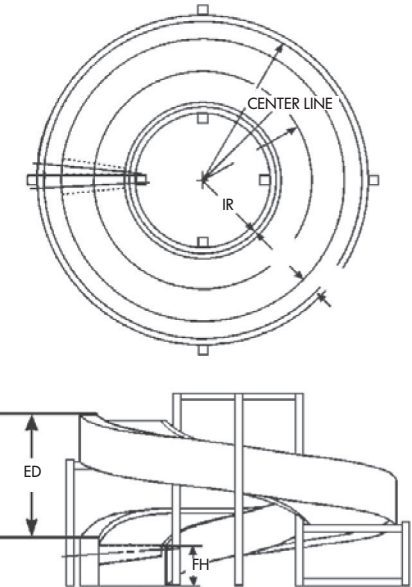


# SPIRAL-LIFT

## Technical Specifications

Sprocket size	17	27	40
<b>General Technical Data</b>			
<b>Max Load Capacity per module</b>	50 lbs/ft	50 lbs/ft 75 lbs/ft w/ Single Bedrolls	50 lbs/ft 75 lbs/ft w/ Single Bedrolls
<b>Max Module Load</b>	290 lbs OCR <=37"	500 lbs OCR <=87"	500 lbs OCR <=168"
<b>Conveyor Speed At CL</b>	0 - 140 fpm	0 - 300 fpm	0 - 350 fpm
<b>Max Ed per 360°</b>	Angle Dependent on OCR	Angle Dependent on OCR	Angle Dependent on OCR
<b>Ambient temperature</b>	-20°F to 225°F (-29°C to 107°C)	-20°F to 225°F (-29°C to 107°C)	-20°F to 225°F (-29°C to 107°C)
<b>Drive Data</b>			
<b>Rated voltage</b>	400V / 50HZ / 3PH 460V / 60HZ / 3PH	400V / 50HZ / 3PH 460V / 60HZ / 3PH	400V / 50HZ / 3PH 460V / 60HZ / 3PH
<b>Power</b>	.5HP - 2HP	.5HP - 5HP	.5HP - 7.5HP
<b>Motor Type</b>	Gear Motor	Gear Motor	Gear Motor
<b>Drive Mount</b>	Shaft Mounted OR	Shaft Mounted OR	Shaft Mounted OR
<b>End Roll Diameter</b>	3 in	5 in	7.5"
<b>Materials</b>			
<b>Belt Material</b>	PHR 2-160 GR11 RTxBB Black Others upon Request	PHR 2-160 GR11 RTxBB Black Others upon Request	PHR 2-160 GR11 RTxBB Black Others upon Request
<b>Construction</b>	12 gauge / 2.5mm	12 gauge / 2.5mm	12 gauge / 2.5mm
<b>Shaft Size</b>	1" - 1-3/16" 25mm - 30mm	1-3/16" - 1-7/16" 30mm - 40mm	1-7/16" - 1 15/16" 35mm - 45mm
<b>Drive Chain</b>	Tsubaki #50 Sidebow	Tsubaki #50 Sidebow	Tsubaki #50 Sidebow
<b>Finish</b>	RAL DTM	RAL DTM	RAL DTM
<b>Bearing</b>	Peer MHS	Peer MHS	Peer MHS
<b>Dimensions</b>			
<b>Frame Height</b>	7 in / 177mm	8.5 in / 216mm	12 in / 305mm
<b>Module Arc</b>	Dependent on IR and LW	Dependent on IR and LW	Dependent on IR and LW
<b>Inner Radius (IR)</b>	20" - 87"	20" - 87"	20" - 90"
<b>LW Clearance (BSG)</b>	Dependent on IR	Dependent on IR	Dependent on IR
<b>Min TOB Height</b>	7 in / 177mm	8.5 in / 216mm	12 in / 305mm
<b>Side Guards</b>	0" - 12"	0" - 12"	0" - 12"
<b>Options</b>			
<b>Underguarding</b>	Expanded Metal Solid Steel Plastic Mesh	Expanded Metal Solid Steel Plastic Mesh	Expanded Metal Solid Steel Plastic Mesh
<b>Drive Mount Styles</b>			
<b>Drip Pan</b>	Standard Standard w/ Drain Plug	Standard Standard w/ Drain Plug	Standard Standard w/ Drain Plug

## Spiral Belt Conveyor



## > Application Specials

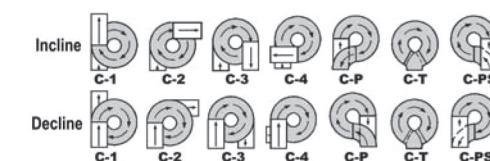
Interroll can design and build the Spiral-Lift to meet your special application requirements.

## > Positive Drive Belt System

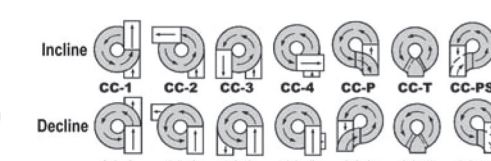
The conveyor belt is positively driven by a shaft mounted sprocket engaging a precision sidebow chain which is attached directly to the outside edge of the belt. This positive drive system is unaffected by changes in loading, tension, temperature, humidity, and foreign material on the belt. The positive drive belt system ensures continuous, reliable operation even in harsh and difficult environments with minimal maintenance.

## Entry/Exit Orientation

Clockwise (Right-hand)



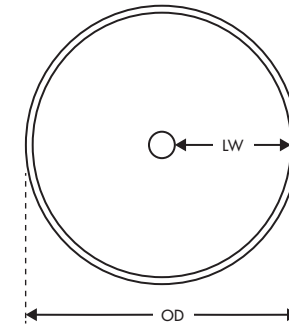
Counter-Clockwise (Left-hand)





# Chutes: Fiberglass Chutemaster

**CHUTEMASTER**



## > Compact Lowering Operations

- Saves Floor Space
- Economical Cost
- Virtually Maintenance-free

### The ChuteMaster Fiberglass Spiral Chute

from Interroll provides a safe, secure means of lowering your products.

Specially designed fiberglass module profiles help control the descending speed of your products.

In high humidity situations, the characteristics of the gel-coated fiberglass assists products to flow freely, gently and safely.

Made of durable hand-laid fiberglass and have a special gel-coating to provide long wearing low-friction service



## Technical Specifications

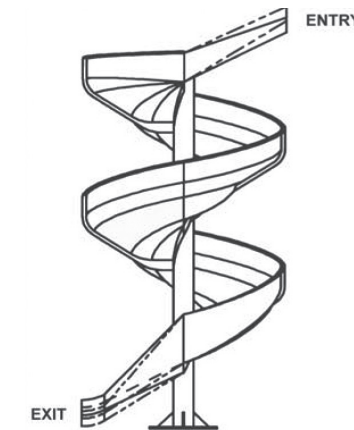
Model	CM-18	CM-25	CM-35	CM-45	CM-51	CM-61	CM-27
<b>General Technical Data</b>							
Outside Diameter (OD)	40"	54.75"	74"	94"	106"	126"	59"
Inside Diameter	5.56"	5.56"	10.75"	10.75"	10.75"	10.75"	9"
Conveying Width (LW)	15.25"	22.63"	29.63"	39.63"	45.63"	55.63"	18"
Angle of Decline	27 Degrees	27 Degrees	27 Degrees	27 Degrees	27 Degrees	27 Degrees	27 Degrees
Ambient Temperature	5° - 176° F	5° - 176° F	5° - 176° F	5° - 176° F	5° - 176° F	5° - 176° F	5° - 176° F
Conveying Radius	18	25	35	45	51	61	27
<b>Materials</b>							
Profile	Fiberglass	Fiberglass	Fiberglass	Fiberglass	Fiberglass	Fiberglass	Fiberglass
Pole Construction	5" Round Pipe	5" Round Pipe	10" Round Pipe	10" Round Pipe	10" Round Pipe	10" Round Pipe	4" Square Tube
Profile Finish	Black Gel Coat	Black Gel Coat	Black Gel Coat	Black Gel Coat	Black Gel Coat	Black Gel Coat	Black Gel Coat
Pole Finish	RAL DTM	RAL DTM	RAL DTM	RAL DTM	RAL DTM	RAL DTM	RAL DTM
<b>Dimensions</b>							
Min Height Exit to Floor	10"	10"	12"	12"	12"	12"	10" <-- (W/ No Exit Slide)
Elevation Per 360°	33"	45"	63"	70.5"	75"	75"	41"
<b>Options</b>							
Sort Table / Outriggers / Multi Section Pole / Supports / Custom Tapered Steel Entry or Exit Slides / Standard Fiberglass Entry and Exit Slides / Multi Entry Points							



**Note:** Elevation dimension does not include entry/exit components. CM51 and CM61 must ship disassembled.

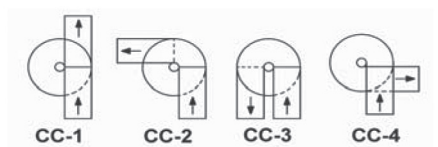
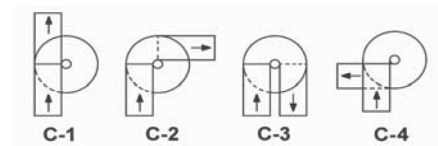
### Entry/Exit Slides

A ChuteMaster spiral chute is normally composed of fiberglass 90° profiles with an exit scoop. Additionally, a custom entry slide, a custom exit slide, and/or a sort table can be provided.



### Entry/Exit Configurations

Right Decline (clockwise)



Left Decline (counter-clockwise)

# Chutes: Spiral Fiberglass Chute with Skate Wheels

### > Gravity and Skatewheels Combined

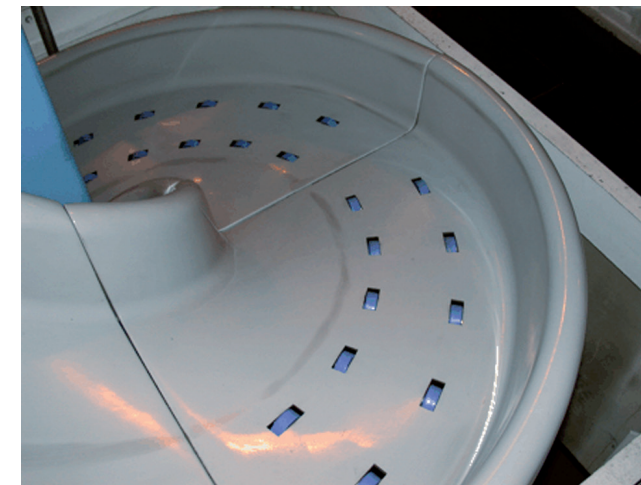
- Durable
- Cost Effective
- Maintenance Free

#### Spiral Fiberglass Chute With Skate Wheels

An efficient and effective design that utilizes gravity and skate wheels to move trays from one level to another.

Each module has a flat bottom with vertical sides to contain the trays/totes and assist in maintaining tray/tote orientation. Product descent is controlled through the unique spiral design.

It is constructed out of durable hand-laid fiberglass and is an inexpensive alternative to conventional equipment.



#### General Description

The CM-27 with skate wheels is a spiral chute consists of reinforced 90° fiberglass modules assembled to a center pole support. Each module is attached to the square center pole with a steel arm. Trays/tote boxes are fed into the chute at the top and are gravity fed down to the bottom. It is possible to utilize a swoop module at the end for transitioning the tray/tote box to a horizontal take-away conveyor. An efficient and effective design that utilizes skatewheels to move trays from one level to another. Each module has a flat bottom with vertical sides to contain the trays/totes and assist in maintaining tray/tote orientation.

# Supermarket Solutions: Cassette

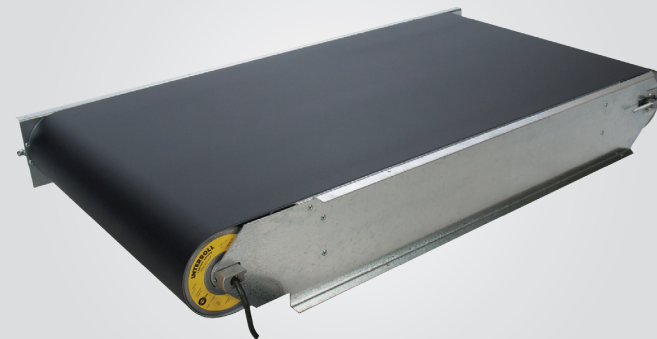
## > Interroll Cassette Conveyor

### Product Features

- U or Z profiled frame
- All galvanized steel construction
- All stainless steel construction
- Galvanized & stainless steel construction
- Two-ply belt with PVC cover

### Product Benefits

- High load capacity
- Modular drop-in design



### General Technical Data

<b>Length</b>	20" to 96"
<b>Belt width</b>	12" to 26"
<b>Min. ratio length/width</b>	2
<b>Voltage</b>	115V/60Hz/1Ph
<b>Optional voltage</b>	230V/50-60Hz/1Ph 230/60Hz/3Ph 460/60Hz/3Ph
<b>Drive motor diameter</b>	113mm (4.5") or 80mm (3.15")
<b>Idler pulley diameter</b>	Standard 4.5" (113mm) Optional 1.9" or 3.15"
<b>Belt speed options</b>	27/35/45/58 FPM
<b>Load capacity (max.)</b>	Small 110 lb Medium 220 lb Large 330 lb

#### Note

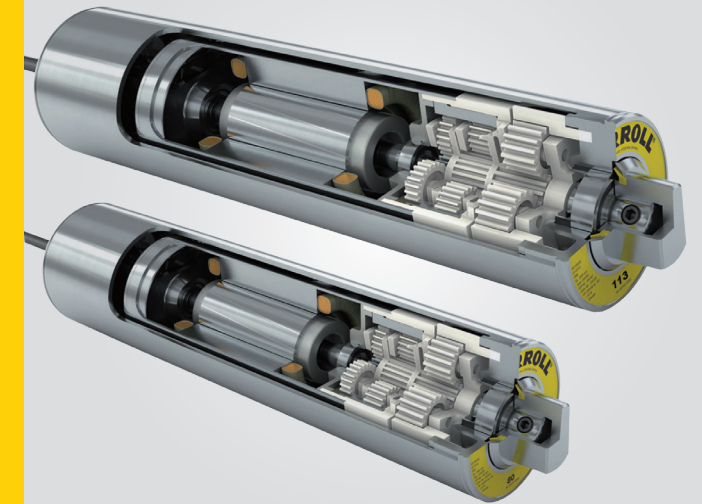
For more information on this product, please contact Interroll Canada Ltd. 1201 Gorham Street - Newmarket, Ontario L3Y 7V1 - Canada

# Supermarket Solutions: Drum Motors

## > Interroll Check Stand Drum Motors 80 & 113

### Product Features

- Techno-polymer planetary gearbox
- Lightweight
- Single-rated voltage
- 3-phase or 1-phase AC induction motor
- Maintenance free
- Lifetime lubricated
- Reversible
- Low noise



### General Technical Data

	Drum Motor 80	Drum Motor 113
<b>Motor type</b>	Asynchronous squirrel cage motor	Asynchronous squirrel cage motor
<b>Insulation class (motors windings)</b>	Class B	Class B
<b>Voltage</b>	115V +/- 5%, 1PH (IEC 34/38) 230V +/- 5%, 1PH (IEC 34/38)	116V +/- 5%, 1PH (IEC 34/38) 230V +/- 5%, 1PH (IEC 34/38) 230V +/- 5%, 3PH (IEC 34/38) 460V +/- 5%, 3PH (IEC 34/38)
<b>Frequency</b>	50/60Hz	50/60Hz
<b>Internal shaft sealing system</b>	Double lipped oil seal	Double lipped oil seal
<b>Internal end housing sealing system</b>	Two (2) O-rings each side	Two (2) O-rings each side
<b>Protection rate</b>	IP 64	IP 64
<b>Thermal protection</b>	Resettable bi-metal switch	Resettable bi-metal switch
<b>Rated power, 1 Ph</b>	0.15 HP	0.1 HP to 0.2 HP
<b>Rated power, 3 Ph</b>	N/A	0.25 HP
<b>Shell speed (ft/min), 1 Ph</b>	27 or 35	27, 36, 46 or 58
<b>Rated torque, 1 Ph</b>	149 in-lb and 115 in-lb	124 in-lb and 380 in-lb
<b>Rated torque, 3 Ph</b>	N/A	243 in-lb and 416 in-lb
<b>Face width</b>	12.8 - 30"	11" - 38"

#### Note

For more information on this product, please contact Interroll Canada Ltd. 1201 Gorham Street - Newmarket, Ontario L3Y 7V1 - Canada





## About Interroll

Established in 1959, Interroll has grown to become the world's leading supplier of key equipment for material handling. Whether you're handling boxes, pallets, parcels or soft goods, no other supplier has such a comprehensive range of solutions on offer.

This is why system integrators, OEMs and operators choose Interroll as a trusted partner for material handling installations, worldwide.

Interroll's global reach ensures quick delivery and superior after-sale service for customers, no matter where they are. By helping increase our customers' efficiency, we boost their competitiveness in today's high-stress marketplace.

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### **interroll.us**

Interroll reserves the right to modify the technical features of its products at any time. Technical information, volumes, data and features are only rough guidelines.

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