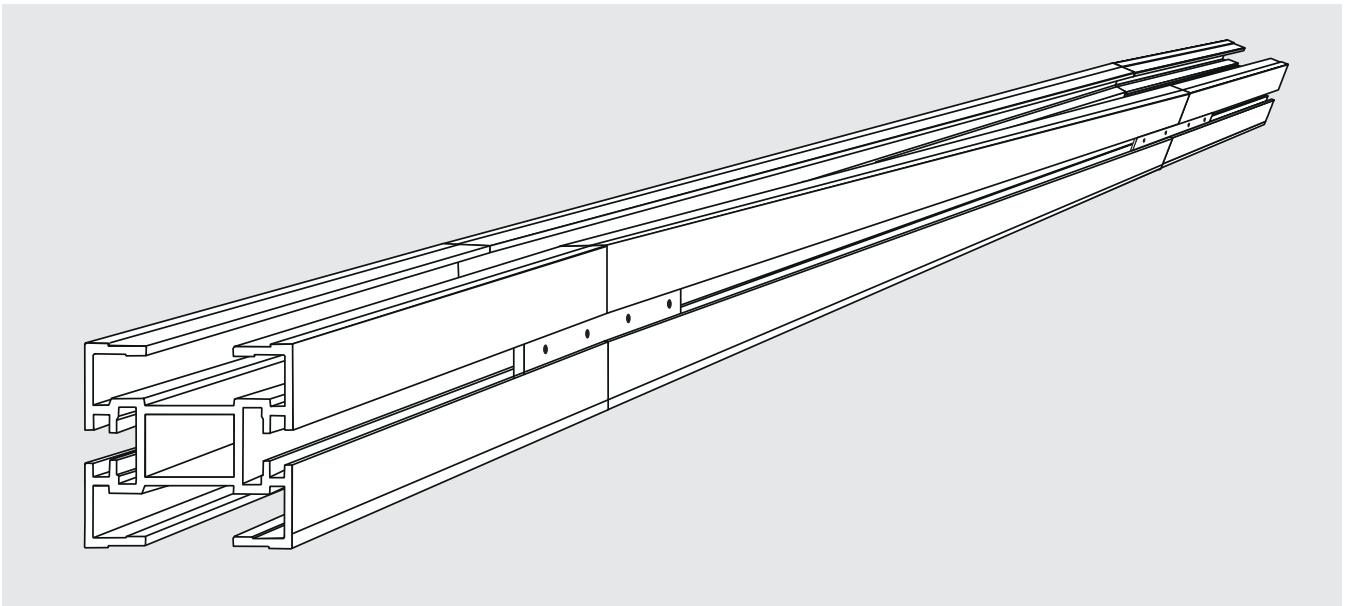




Twisted conveyor beams Assembly instruction — conveyor system XL, XM and XH



Twisted beams

Twisted beams can be used in applications where a gradual rotation of the conveyor beam is desired.

A twisted beam consists of three beam sections: two short pieces of standard conveyor beam and one split beam section.

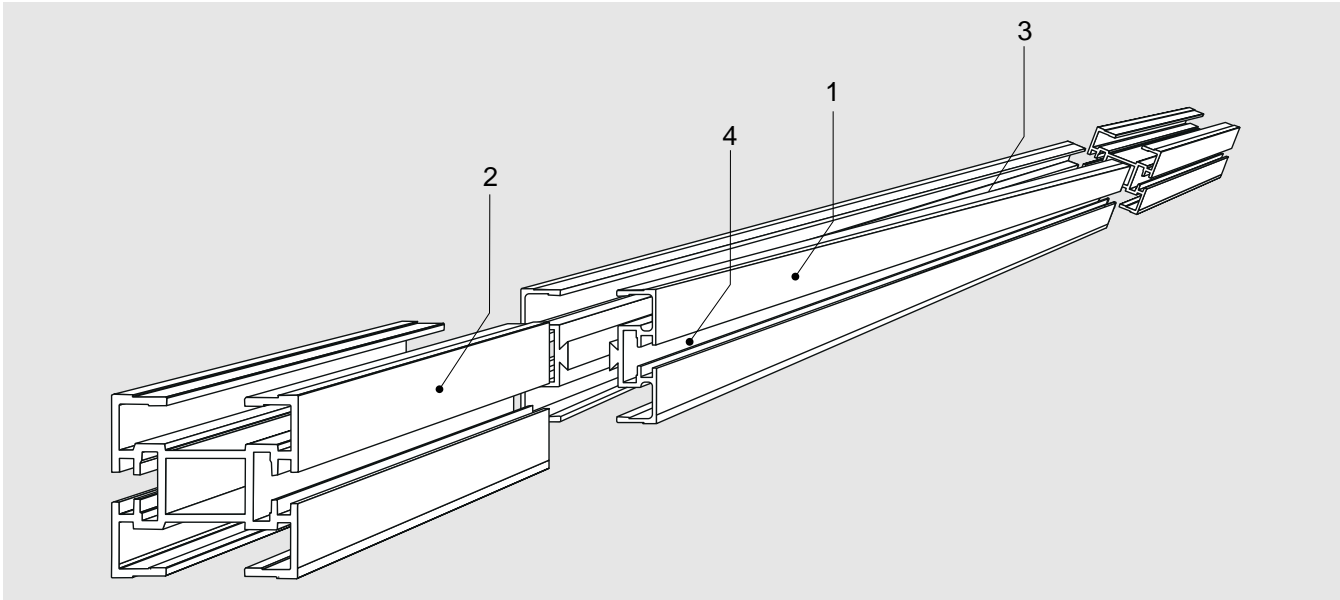
This bulletin is an instruction on how to make twisted beams.

Twisted beam

Components

A twisted beam consists of three beam sections: two short pieces of standard conveyor beam and one split beam section. For more information about the split beam, see technical bulletins 960321– 960323 (XL–XH). Note that slide rail XLCR 3 T (stainless steel) is not suitable for twisted beams.

The illustration and tables below show what components the twisted beam consists of. Page 3 contains a short instruction on how to twist the split beam.



Conveyor system XL

Position	Amount	Designation	Description
1	2	XLCB 6 H	XL split beam
2	2	XLCB 6	XL standard beam, 160 mm
3	See following page	XLCE 29x20	Complete mounting clips
4	8	XLCJ 6x130	Connecting strip

Conveyor system XM

Position	Amount	Designation	Description
1	2	XMCB 6 H	XM split beam
2	2	XMCB 6	XM standard beam, 160 mm
3	See following page	XMCE 49x30	Complete mounting clips
4	8	XLCJ 6x130	Connecting strip

Conveyor system XH

Position	Amount	Designation	Description
1	2	XHCB 6 H	XH split beam
2	2	XHCB 6	XH standard beam, 160 mm
3	See following page	XHCE 69x30	Complete mounting clips
4	8	XLCJ 6x130	Connecting strip

Twisting a split beam

- 1 Assemble the split beam. There should be at least 5 beam clips per meter. Leave a “clip-free” distance of 100 mm at each end.
- 2 Mount the standard beam sections at the ends of the split beam.
- 3 Mount connecting strips at the ends of the assembled beam section.
- 4 Place one end of the beam in a vice and tighten it.
- 5 Holding the connecting strips at the other end, twist the beam, using a lever, to the desired angle.

For ordering information, see the FlexLink main catalogue and technical bulletins 960321–960323.

The twist degree of the split beam has to be proportional with the length and type of beam required (XL, XM or XH). See tables below for further details.

Conveyor system XL

Twist degree (left or right)	Cutting length (mm)	Number of clips required
± 15°	700	4 pcs
± 20°	800	4 pcs
± 30°	1000	5 pcs
± 45°	1500	8 pcs
± 60°	2000	10 pcs
± 90°	3000	15 pcs

Conveyor system XM

Twist degree (left or right)	Cutting length (mm)	Number of clips required
± 15°	800	4 pcs
± 20°	1000	4 pcs
± 30°	1200	5 pcs
± 45°	1800	8 pcs
± 60°	2400	10 pcs
± 90°	3600	15 pcs

Conveyor system XH

Twist degree (left or right)	Cutting length (mm)	Number of clips required
± 15°	900	5 pcs
± 20°	1100	5 pcs
± 30°	1400	7 pcs
± 45°	2100	12 pcs
± 60°	2800	15 pcs
± 90°	4200	20 pcs