



Product Catalog

Transfer system LT40

Montech AG

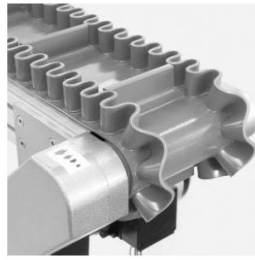
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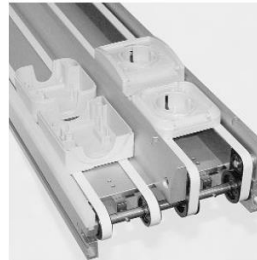
CUSTOMIZED SOLUTIONS



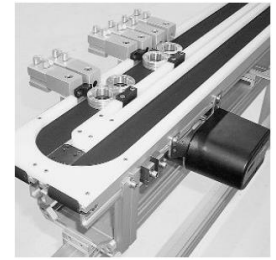
Assembly



Watch industry



Electronic industry



Construction industry



Mechanical engineering



Plastic industry



Printing industry



Automotive suppliers



Automotive



Medical industry



Automotive suppliers



Solar industry



Medical industry



Automotive supplier



Mechanical engineering



Airport



Airport



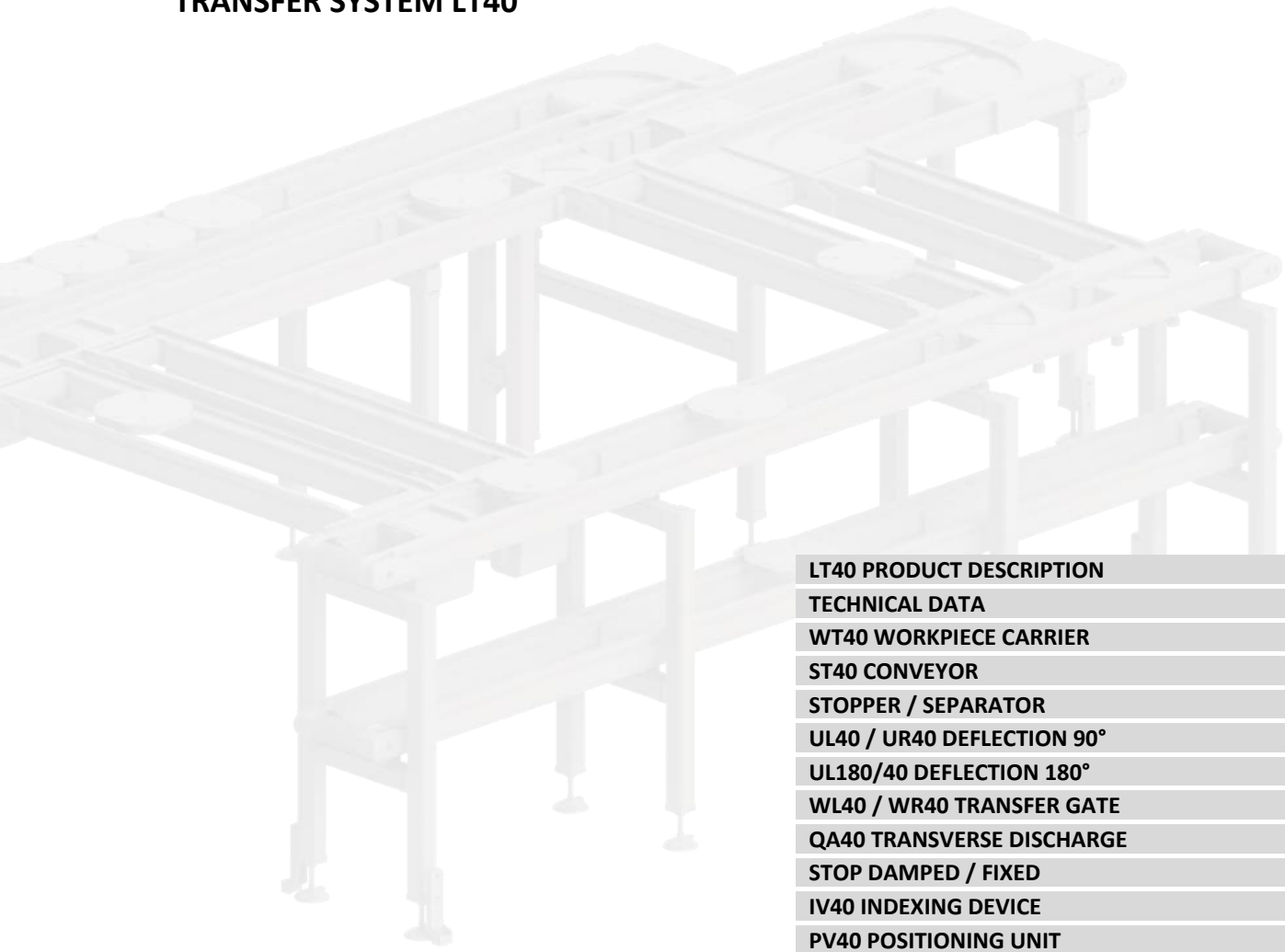
Automotive



Electronic industry



TRANSFER SYSTEM LT40



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Flexible - compact - energy efficient 24VDC drives - standardized construction modules, the **LT40 transfer system** from Montech.

TRANSFER SYSTEM LT40 – PRODUCT DESCRIPTION

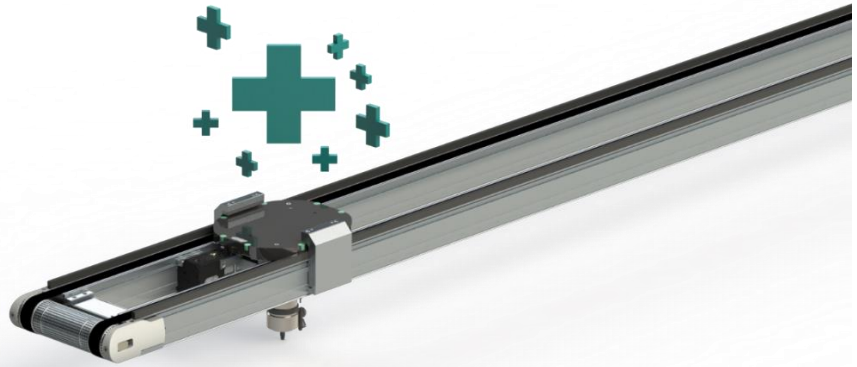


The **transfer system LT40** is a pallet circulation system in three system sizes with many advantages. Compact toothed belt conveyors in double strand design and integrated 24V drive form the basis. Combined with diverters, transverse discharges and transfer gates, the layout can be flexibly designed according to your wishes and requirements. Positioning units, stoppers and separators position the workpiece carrier in the processing stations and stop it within the conveyor line. Lifts literally take the system to another level.

As with the Aluminum framing system, the LT40 transfer system also uses the proven dovetail clamping technology with its manifold advantages. For each system size you have the choice between a square and a rectangular workpiece carrier.

TRANSFER SYSTEM LT40

One system - many advantages

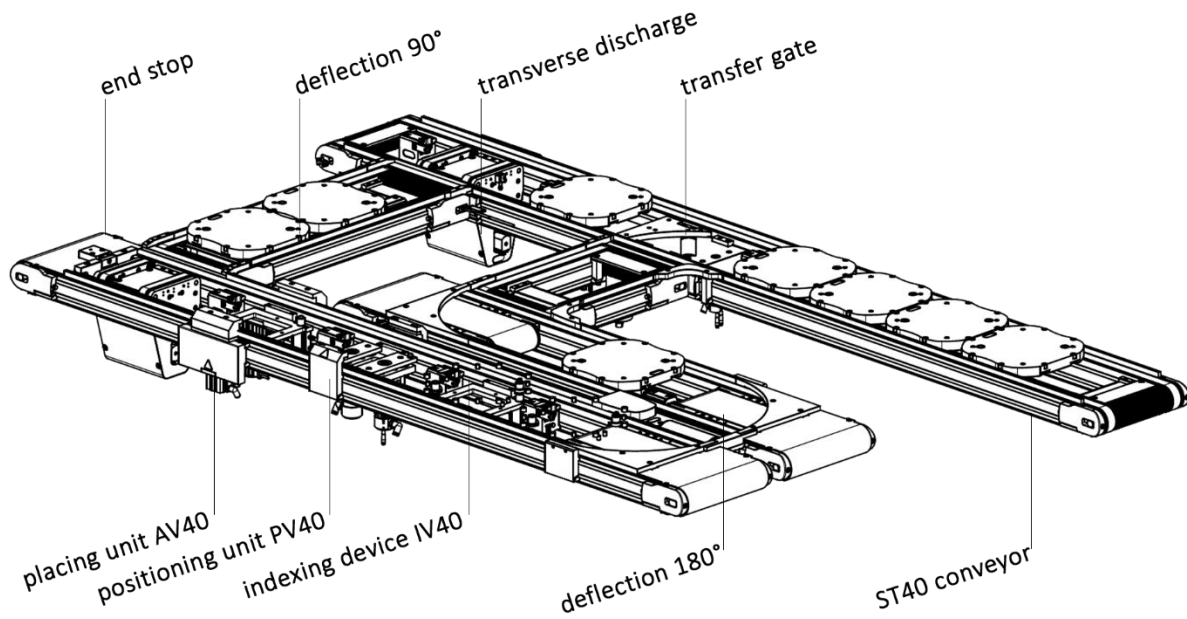


- **Compact design, minimal interference contours**
The almost noiseless drive is integrated into the drive roller with a diameter of only 62 mm.
- **Flexible layout design requiring minimal planning effort**
Possible thanks to a standardized modular system. The individual functions such as conveying, diverting and positioning are standardized in units. For the individual conveyor line, one makes use of this modular system and flexibly combines these units according to the requirements.
- **Efficient assembly by specialists**
Our specialized assembly team assembles the conveyor line incl. deflectors, positioning units etc. professionally and efficiently at the manufacturer's plant.
- **Simple and precise mounting due to dovetail clamping technology**
The many years of experience with the dovetail clamping technology of the Montech Aluminum framing system have also been incorporated into the development of the LT40 transfer system. Diverters, stoppers, positioning units, etc. are simply fixed to the conveyor via a dovetail - without any additional processing. This assembly technology allows functions to be adapted, modified or repositioned in the processing process entirely according to the system design - flexibly, quickly, easily and without any mechanical intervention.
- **Simple control**
Via analog setpoint 0-10 V.
The conveying direction is specified via a digital input.
- **Optimal cost-benefit ratio**
3 system sizes, 6 workpiece carrier sizes in 2 material versions and 3 drive variants for a tailor-made solution for the specific application
- **3 types of positioning units**
The simple one - indexing device IV40 perfect for manual workstations
The accurate one - positioning unit PV40 particularly suitable for assembly processes with required high positioning accuracy in X/Y direction and with vertical forces up to 1kN
The strong one - placing unit AV40 precise positioning in X/Y direction and simultaneous absorption of high pressing forces up to 60 kN
- **Minimal commissioning costs**
No Montech service technicians are required for final on-site assembly.
You receive the transfer system pre-assembled in segments. On site, you assemble them into the complete system and make the fine adjustments. This saves a lot of time and money.
- **3 system sizes - 6 workpiece carriers**
For each system size one can choose between a square and a rectangular workpiece carrier.
- **Workpiece carriers for applications in the electronics sector**
For most applications we recommend the workpiece carrier made of PET, but for electronic applications we also offer an ESD version
- **Warranty period 36 months***

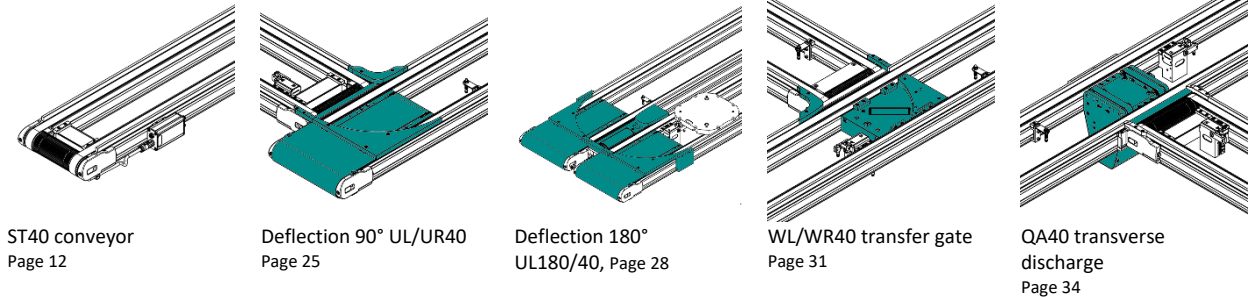
*Exceptions see GTC's

TRANSFER SYSTEM LT40 - STANDARDIZED MODULAR SYSTEM

The LT40 transfer system - a conveyor system made of the combination of components from a standardized and modular construction kit for the routing and positioning of the workpiece carriers.



Construction kit for routing



ST40 conveyor
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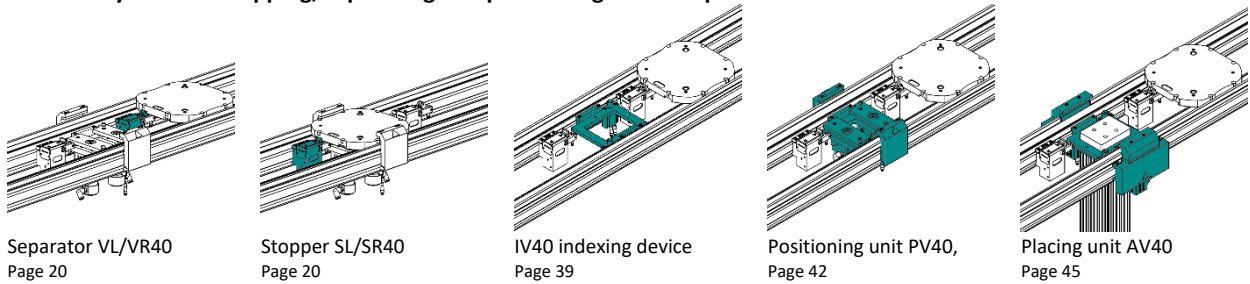
Deflection 90° UL/UR40
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Deflection 180°
UL180/40, Page 28

WL/WR40 transfer gate
Page 31

QA40 transverse
discharge
Page 34

Modular system for stopping, separating and positioning the workpiece carrier



Separator VL/VR40
Page 20

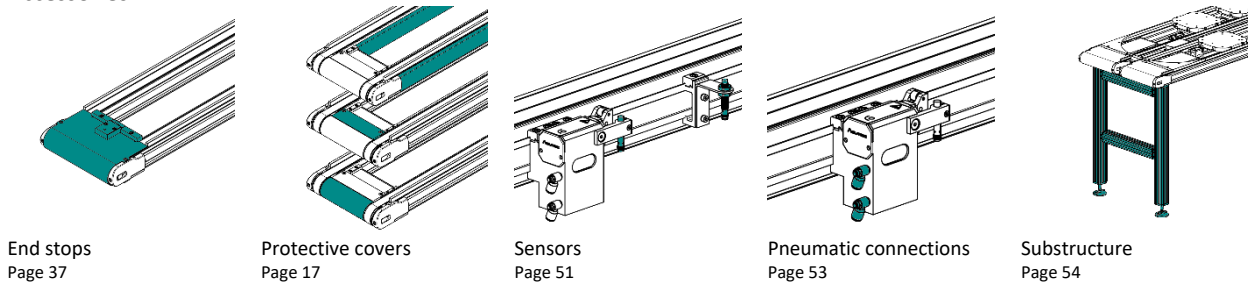
Stopper SL/SR40
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IV40 indexing device
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Positioning unit PV40,
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Accessories



End stops
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Sensors
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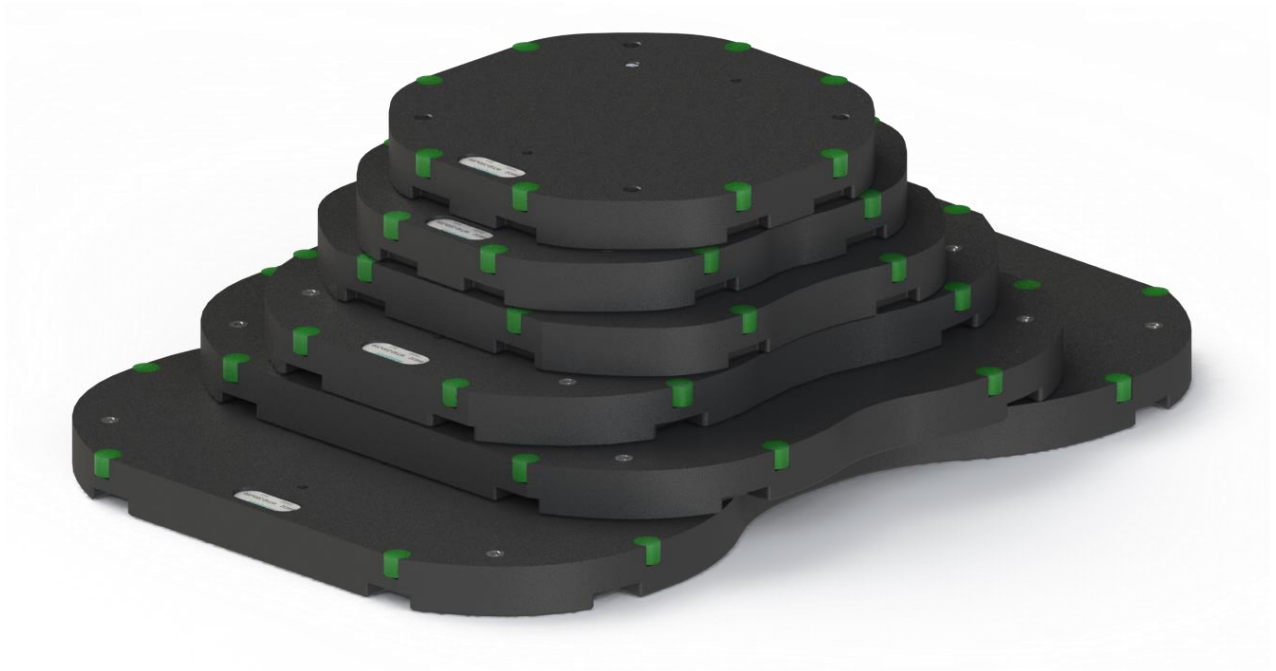
Substructure
Page 54

TRANSFER SYSTEM LT40 – TECHNICAL DATA

System sizes	200 / 240 / 320			
Conveyor drive				
Design	Integrated end drive, Ø62 mm			
Motor type	Brushless DC motor (BLDC), 24V			
Nominal power	90W	50W	2x50W	
Electronics	external	integrated	integrated	
Speed setpoint specification	analog, 0 - 10 VDC			
Max. permissible continuous load per conveyor				
Conveyor mode / accumulation mode	65 kg / 40 kg	50 kg / 30 kg	100 kg / 60 kg	
Conveying speed	5 – 20 m/min	5 – 18 m/min	5 – 18 m/min	
Speed control accuracy	±10%			
Max. conveyor length	6 m			
Drive mechanism	Toothed belt			
Workpiece carrier	Dimensions	Dead weight	Max. payload	
		PET	ESD	
	200x200 mm	1.2 kg	1.1 kg	7.0 kg
	200x240 mm	1.5 kg	1.3 kg	8.4 kg
	240x240 mm	1.8 kg	1.6 kg	8.4 kg
	240x320 mm	2.4 kg	2.1 kg	11.2 kg
	320x320 mm	3.3 kg	2.9 kg	11.2 kg
	320x480 mm	4.7 kg	4.1 kg	16.8 kg
Repeat accuracy for positioning of the workpiece carrier with				
PV40/AV40 positioning/placing unit	± 0.05 mm			
IV40 indexing device	± 0.1 mm			
Max. permissible pressing force				
in PV40 positioning unit	for WT40-200x200 and WT40-200x240	from size WT40-240x240		
with centric force application	up to 1000 N	up to 1400 N*		
in AV40 placing unit	60 kN			
Max. permissible surface pressure (workpiece carrier)	15 N/mm ²			
Ambient temperature	+10 to +40°C			
Sound pressure level	< 60 dBA			
Protection class of the assemblies	IP 42			
Operating pressure	5-6 bar			
Materials				
Workpiece carrier Basic version ESD version	Polyethylene terephthalate PET, black Sustamid 6 G ESD 90, black, antistatic			
Workpiece carrier guides Conveyors	Polyethylene PE, black, antistatic predominantly aluminum, colorless anodized			

For further technical data, please refer to the assembly instructions.

WORKPIECE CARRIER WT40 - PRODUCT DESCRIPTION



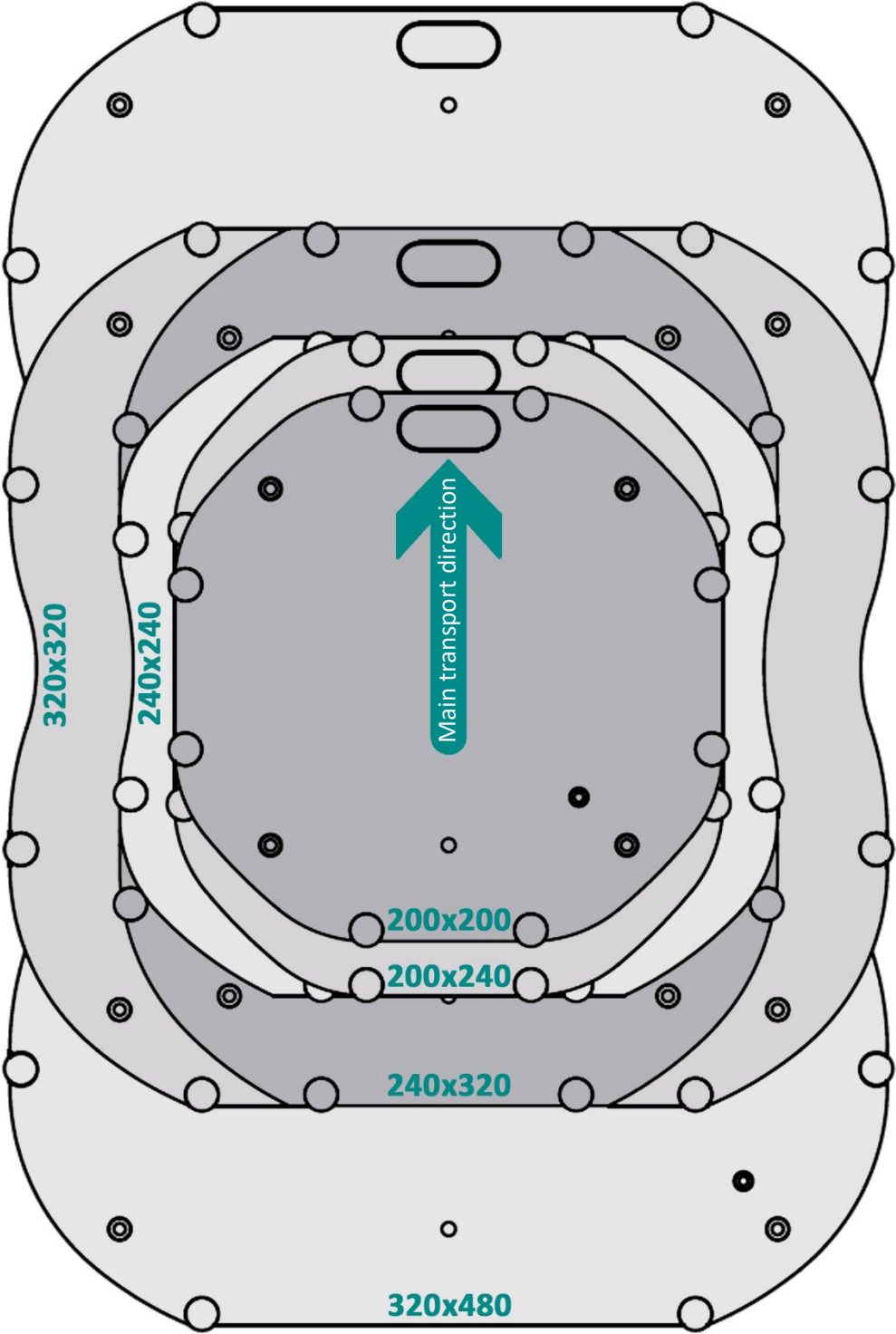
6 different dimensions - 2 different materials

As a transport carrier for your product, the LT40 transfer system gives you choices in size and material. Six sizes are available: 200x200, 200x240, 240x240, 240x320 and 320x480. The system size results from the selection of the workpiece carrier size.

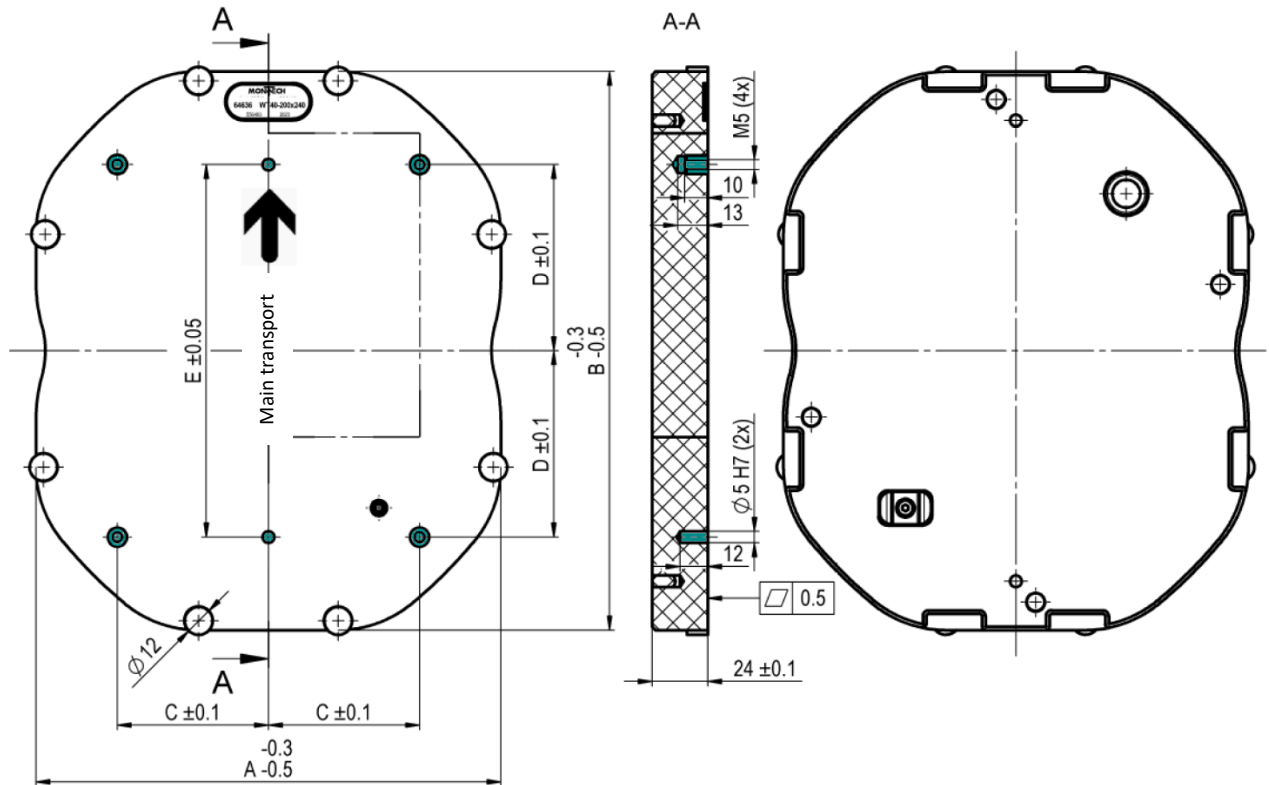
For most applications we recommend the PET workpiece carrier, but for sensitive electronic parts we also offer an ESD workpiece carrier.

Depending on the size of the workpiece carrier, a payload per carrier of 7-16.8 kg is possible. Holes and threaded inserts are provided for positioning and fixing the product holder, saving you subsequent machining of the workpiece carrier.

WORKPIECE CARRIER WT40 - VERSIONS



WORKPIECE CARRIER WT40 - DIMENSION DRAWING



Green marking: Positioning holes and threaded bushings as interface to the product holder

Type		WT40-200x200	WT40-200x240	WT40-240x240	WT40-240x320	WT40-320x320	WT40-320x480
System size		200		240		320	
Item no.							
Basic PET version		64632	64636	64644	64646	64638	64641
ESD version		68571	68573	68575	68577	68579	68581
A workpiece carrier width	[mm]	200	200	240	240	320	320
B workpiece carrier length	[mm]	200	240	240	320	320	480
C	[mm]	65	65	80	80	120	120
D	[mm]	65	80	80	120	125	240
E	[mm]	130	160	160	240	250	410
Weight workpiece carrier	[kg]	1.2	1.5	1.8	2.4	3.3	4.7
Max. permissible payload	[kg]	7	8.4	8.4	11.2	11.2	16.8
Weight total permissible	[kg]	8.2	9.9	10.2	13.6	14.5	21.5



NOTE

Any machining on the workpiece carrier, such as cut-outs and feed-throughs, is only permissible after consultation with and approval by Montech. Otherwise the warranty claim expires.

WORKPIECE CARRIER WT40 - PRODUCT DIMENSION, POSITION OF THE PRODUCT CENTER OF GRAVITY

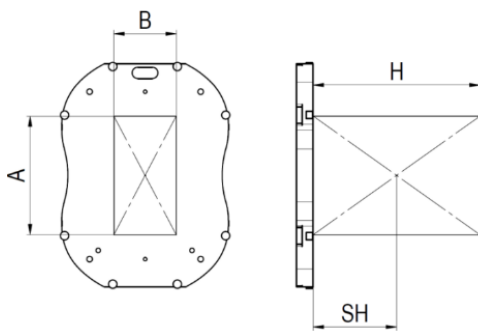


NOTE

For trouble-free transport, the **product dimensions** and the **position of the product center of gravity** must be observed.

- The product and product holder must not protrude beyond the workpiece carrier.
For further restrictions, refer to the information on the positioning units.
- Maximum permissible product height H = workpiece carrier width
- Maximum permissible height of product center of gravity $SH = \frac{1}{2} \times$ workpiece carrier length

The center of gravity of the product on the workpiece carrier should be as centered as possible, but at least it must lie within the area $A \times B$



Workpiece carrier dimension	[mm]	200x200	200x240	240x240	240x320	320x320	320x480
H max. permissible product height	[mm]	200	200	240	240	320	320
SH max. permissible height product center of gravity	[mm]	100	120	120	160	160	240
A Limit range in longitudinal direction	[mm]	50	90	90	170	170	330
B Limit range in transverse direction	[mm]	50	50	90	90	170	170

CONVEYOR ST40 – PRODUCT DESCRIPTION






The heart of the **transfer system LT40** is the **conveyor with integrated 24VDC drive**. Different drive types allow an optimal cost-benefit ratio for the specific application. Control is via analog setpoint 0-10 V. The drive mechanisms are two toothed belts with optimized coefficients of friction. The conveyor length of up to 6 m flexibly adjusts to the layout of the conveyor line.

Dovetail profiles on both the inside and outside of the conveyor allow easy and precise linking of several belts at right angles to one another and the attachment of diverters, stoppers, positioning units, etc. Thanks to the dovetail profile on the underside of the conveyor, the toothed belt is covered with the matching aluminum profile as required.

CONVEYOR ST40 – DRIVE VERSIONS

The drive version and the design of the belt inlet and outlet must be selected in accordance with the performance requirements and the layout of the conveyor line:

Drive version*	Belt load	Conveying speed
90W incl. external controller 	65 kg in conveying mode 40 kg in accumulation mode	5 – 20 m/min ($\pm 10\%$)
50W , controller integrated 	50 kg in conveying mode 30 kg in accumulation mode	5 – 18 m/min ($\pm 10\%$)
2x50W , controller integrated Belt infeed and outfeed driven 	100 kg in conveying mode 60 kg in accumulation mode	5 – 18 m/min ($\pm 10\%$)

*for detailed information on the drive versions, please refer to the MA-100029 assembly instructions

CONVEYOR ST40 - DESIGNS

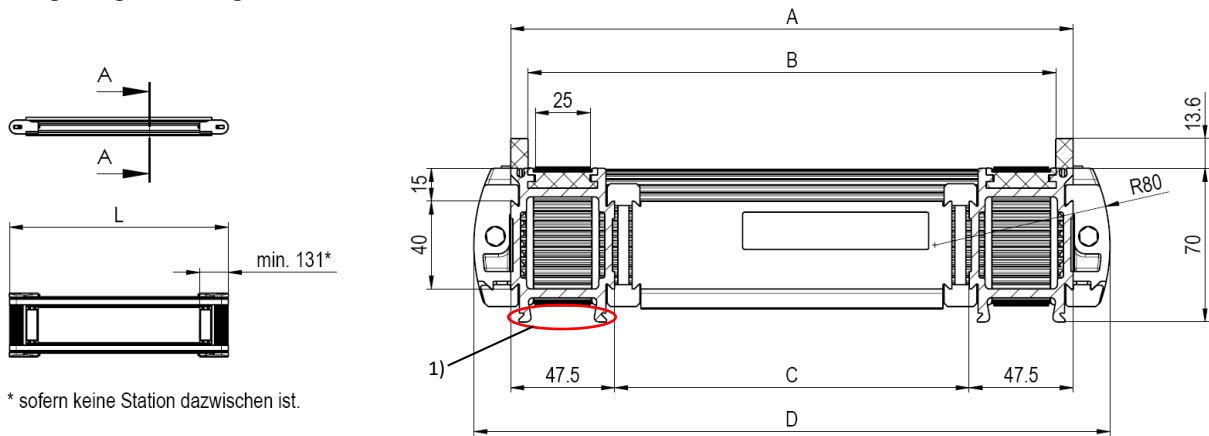
Designs	Application
<p>Longitudinal lug L00</p> 	<p>End-to-end alignment of two ST40 conveyors</p>
<p>Transverse lug Q10</p> 	<p>Cross connection for deflection and transfer gate conveyor height offset 1 mm</p>
<p>Transverse lug Q65</p> 	<p>Transverse connection for transverse discharge Height offset of the conveyors 6.5 mm</p>

CONVEYOR ST40 – DESIGNATION KEY

Designation key	
ST40/□□□□/□□□□□/Z/□□/□□□-□□□	
ST40/□□□□/□□□□□/Z/□□/□□□-□□□	ST40 conveyor
ST40/□□□□/□□□□□/Z/□□/□□□-□□□	Size 0200 for WT40-200x200 or 200x240 0240 for WT40-240x240 or 240x320 (or transverse transport from WT40-200x240) 0320 for WT-40-320x320 or 320x480 (or transverse transport from WT40-240x320) 0480 for transverse transport of WT-40-320x480
ST40/□□□□/□□□□□/Z/□□/□□□-□□□	conveyor length in mm
ST40/□□□□/□□□□□/Z/□□/□□□-□□□	Toothed belt as a drive mechanism
ST40/□□□□/□□□□□/Z/□□/□□□-□□□	Drive version 01 = 90W incl. external controller 02 = 50W (integrated electronics) 03 = 100W (2x50W, integrated electronics)
ST40/□□□□/□□□□□/Z/□□/□□□-□□□	Lug type discharge side (drive side) L00 = Longitudinal lug Q10 = Transverse lug, 1 mm height offset Q65 = Transverse lug, 6.5 mm height offset
ST40/□□□□/□□□□□/Z/□□/□□□-□□□	Lug type inlet side L00 = Longitudinal lug Q10 = Transverse lug, 1 mm height offset between belts Q65 = Transverse lug, 6.5 mm height offset between belts
Example: ST40/0200/01000/Z/01/L00-L00	ST40 conveyor Size 200 Length conveyor 1000 mm Toothed belt as a drive mechanism 90W drive with external controller Longitudinal belt inlet lug Longitudinal belt discharge lug

ST40 CONVEYOR - DIMENSION DRAWING

Design longitudinal lug

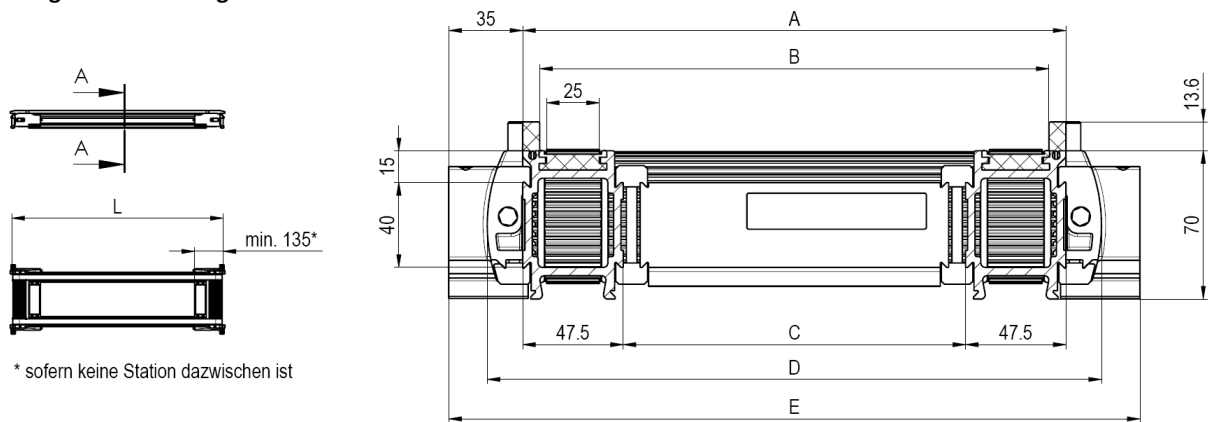


* sofern keine Station dazwischen ist.

A-A

Size		200	240	320
corresponds to the width of the workpiece				
A Total conveyor width	[mm]	216.5	256.5	336.5
B Conveying width ± 0.5 mm	[mm]	200.5	240.5	320.5
C	[mm]	122.0	162.0	242.0
D	[mm]	250.0	290.0	370.0
L Belt length	[mm]	min. 400 mm, max. 6 m		

Design transverse lug



* sofern keine Station dazwischen ist

A-A


Size		200	240	320	480
corresponds to the width of the workpiece carrier					
A Total conveyor width	[mm]	216.5	256.5	336.5	496.5
B Conveying width ± 0.5 mm	[mm]	200.5	240.5	320.5	480.5
C	[mm]	122.0	162.0	242.0	402.0
D	[mm]	250.0	290.0	370.0	530.0
E	[mm]	286.5	326.5	406.5	566.5
L Belt length	[mm]	min. 400 mm, max. 6 m			

¹⁾ For cable guide KFE-40 to cover toothed belt (see page 18).

Unsuitable for clamping of any kind. Use the lateral dovetail profiles to support the conveyor.


CONVEYOR ST40 – ACCESSORIES

A selection of accessories is available for the ST40 conveyor, such as connection cables and components to increase work safety.

Transitional cladding	Size	Item no.
	200	66646
	240	66647
	320	66648




As pinch protection between the rollers of two in-line aligned conveyors, this accessory significantly increases work safety. It simultaneously acts as a bridge over the lateral guide opening at the transition of both belts.

End section finger protection.	Size	Item no.
	200	65539
	240	65542
	320	65544
	480	65546



Pinch protection between toothed roller, connecting support and toothed belt at the belt infeed and outfeed. In freely accessible areas of the plant, it is essential to provide for increased occupational safety.

Roller tooth cover	Size	Item no.
	200	69388
	240	69390
	320	69391
	480	69392



Covering of freely accessible toothed rollers to increase work safety. Combinable with the transitional cladding or the end section finger protection.



CAUTION

To increase work safety, it is essential to provide the finger guard and the roller tooth cover on freely accessible areas of the system.

CONVEYOR ST40 – ACCESSORIES

Matching the different drive versions of the ST40 conveyors, signal and power cables are available in various lengths for connection to the control system.

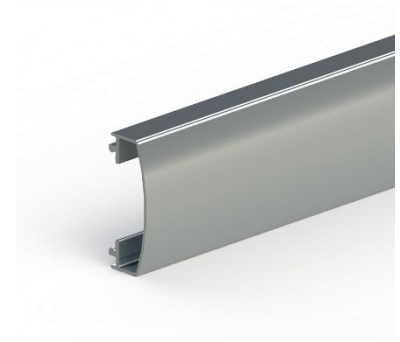
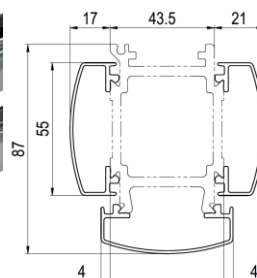
Connection cable for 90W drive version		Item no.
Power	5 m	66935
	10 m	66936
single-sided angled female connector M12-S, 3-polig+FE (4x1.5 mm ² , AWG16)		
Signal	3 m	70095
	5 m	70096
	10 m	70097
single-sided straight female connector M12, 5-pin (3/5m: 5x0.25 mm ² , AWG24 / 10M: 5x0.34 mm ² AWG22), shielded		



Connecting cable for 50W drive version		Item no.
Power and signal	3 m	522683
	5 m	522684
	10 m	522685
single-sided straight female connector M12, 5-pin (5x0.52 mm ² , AWG20), shielded		



Cable guide KFE-40	Item no.
L = 2000 mm	62447/2000



A multifunctional aluminum profile:

- Cable duct along the ST40 conveyor
- Dovetail guide cover
- Toothed belt cover underneath the conveyor (collection of abrasion)

CONVEYOR ST40 – ACCESSORIES

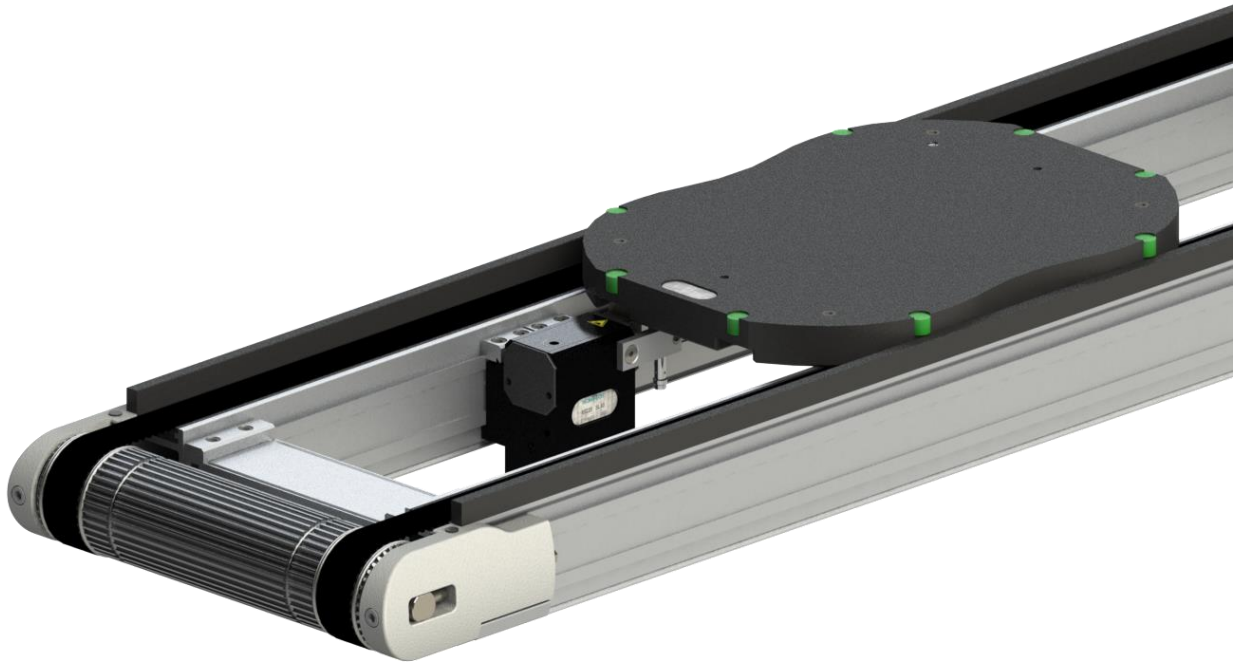
For the maintenance of LT40 equipment:

Toothed belt impregnation	Item no.
<p style="text-align: center;">Impregnation set</p> <p>Manual roller and collecting tray for impregnating agent, for easy and even application reusable</p>	69785
<p style="text-align: center;">Impregnating agent, 2.5 liters</p> <p>is sufficient for impregnation of approx. 75 m of belt section</p>	69883



For regular re-impregnation of the toothed belts of the ST40 conveyor. Contamination and wear of the toothed belt negatively influence the frictional interfaces between the workpiece carrier and the toothed belt. The post-impregnation increases the service life of toothed belts and drives and ultimately reduces the maintenance costs of the transfer system.

STOPPER SL/SR40 AND SEPARATOR VL/VR40 – PRODUCT DESCRIPTION



Gentle stopping at a defined position of one or more accumulating workpiece carriers with **damped stoppers** and **separators** of the LT40 transfer system – perfect for impact-sensitive products. The impact of the incoming workpiece carrier is damped vibration-free until the end position is reached. The stop remains in the end position without counterforce. This enables precise positioning even without additional indexing (but without guaranteed repeatability). The required damping force can be simply and easily adjusted to the mass to be stopped during fine adjustment of the system. The pneumatic stoppers/separators are double-acting and have an electronic interrogation facility for the position of the stop. They are positioned on the inside of the conveyor using dovetail clamping technology; this enables precise clamping and subsequent shifting.

STOPPER SL/SR40 AND SEPARATOR VL/VR40 – FUNCTIONAL DESCRIPTION



Stopper SL40 – with hardened steel stop
for damped stopping of a workpiece carrier
e.g. in a positioning unit



Separator VL40 – with pawl with spring reset
for stopping and separating accumulating workpiece carriers
e.g. as a pre-stopper upstream from a positioning unit

Damping force adjustment screw
for stepless adjustment of pneumatic
cushioning on the workpiece carrier weight

Tilt stop with spring return
for separating
for stopper hardened steel stop

Hard anodized aluminum housing

Dovetail clamping system
for fixing on the conveyor

Mounting tapped hole for sensor
holder
Sensor holder see accessories

T-slot for electronic position sensing
top and bottom
magnetic cylinder sensors available as
accessories

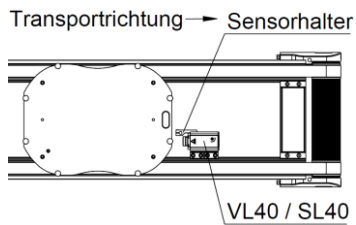
Pneumatic connection screw
plugs

front or rear selectable
Delivery state according to illustration
Pneumatic connections available as
accessories

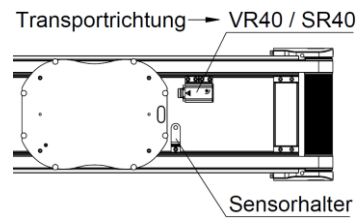
STOPPER SL/SR40 AND SEPARATOR VL/VR40 – DESIGN VARIANTS

Both the stopper and the separator are available in left-hand and right-hand versions. The side on which this is placed on the conveyor is not specified. However, if space permits, the left-hand variant is to be preferred. The reason for this is the positioning of the sensor for the workpiece carrier presence check.

Version variant left



Version variant right



Technical data

Workspace

Conveying speed	[m/min]	6	9	12	15	18	21
Permissible accumulation load	[kg]	60	40	35	32	30	27
Mass of workpiece carrier incl. payload							

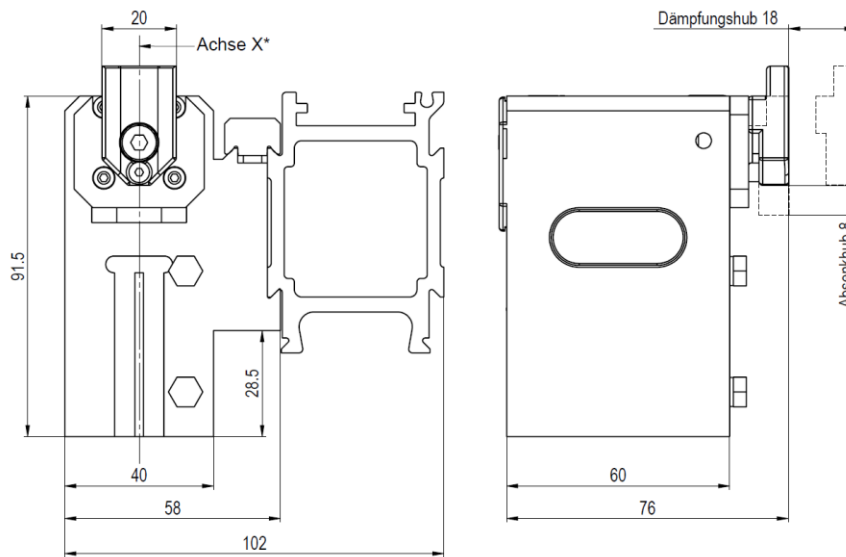
Pneumatic cylinder

Pneumatic connection ¹⁾	M5
Functionality	double-acting

¹⁾ Not included in the scope of delivery (see page 53).

STOPPER SL/SR40 AND SEPARATOR VL/VR40 – DIMENSION DRAWING

Stopper SL40



For SR40 Stopper dimension drawing mirrored on X axis

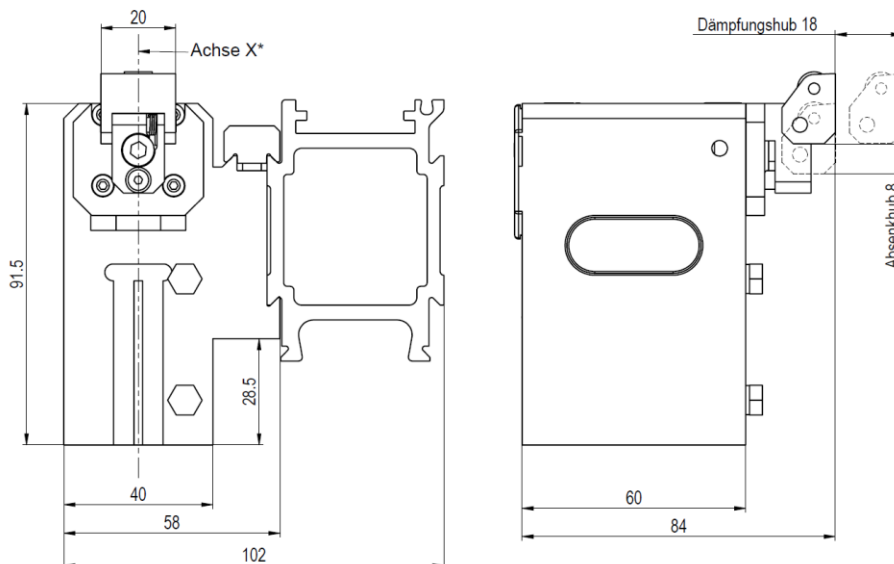
Stopper

Item no.

Version left SL40
Version right SR40

65220
65221

Separator VL40



For separator VR40 dimension drawing mirrored on X axis

Separator

Item no.

Version left VL40
Version right VR40

65173
65174

STOPPER SL/SR40 AND SEPARATOR VL/VR40 – ACCESSORIES

Sensor holder for stopper SL40	Item no.
	66309

For direct mounting on the SL40 stopper. Additional alignment to the switching position on the workpiece carrier is no longer necessary.

Accessories:

Inductive sensor \varnothing 6.5, **Article no. 521885***



Sensor holder for separator VL40	Item no.
	66308

For direct mounting on the separator VL40. Additional alignment to the switching position on the workpiece carrier is no longer necessary.

Accessories:

Inductive sensor \varnothing 6.5, **Article no. 521885***



Sensor holder	Item no.
	64658

For checking the presence of the workpiece carrier in combination with stopper SR and separator VR, or as release of a jam-monitored area for the passing of the next workpiece carrier.

Accessories:

Inductive sensor M8, **Article no. 522686***



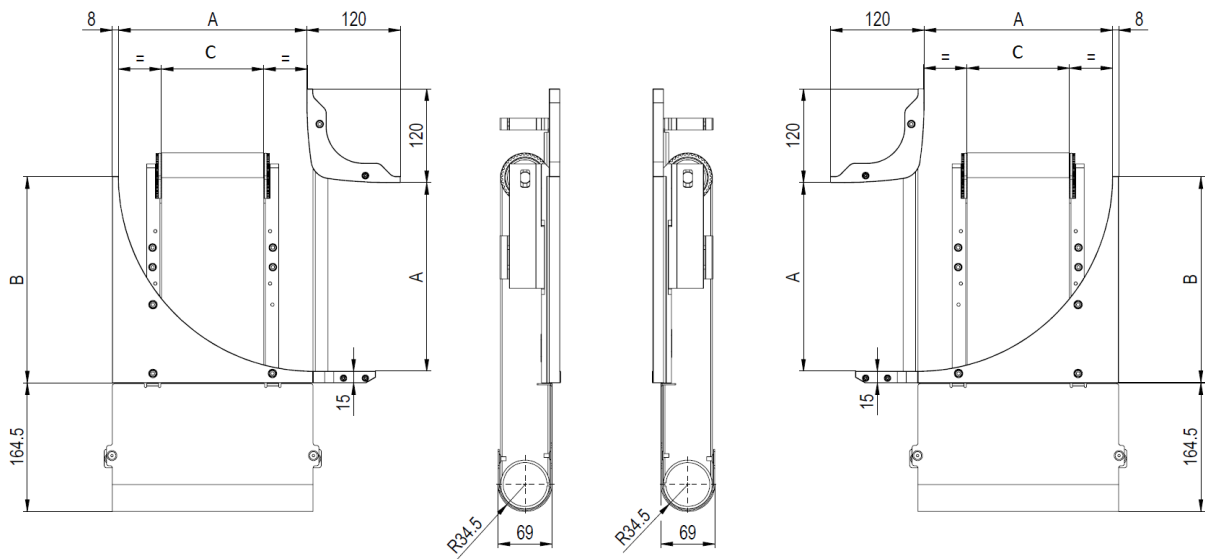
*For details on sensor technology, see from page 51

DEFLECTION 90° UL40 / UR40 - PRODUCT DESCRIPTION



The **90° deflection** diverts the workpiece carriers from a longitudinal section to a transverse section. The unit is integrated at the belt discharge (drive side) of the ST40 conveyor. It is driven directly by the conveyor drive, so it does not require an additional drive.

DEFLECTION 90° UL40 / UR40 – DIMENSION DRAWING



Version left UL40

Version right UR40

Type		UL40-200 / UR40-200	UL40-240 / UR40-240	UL40-320 / UR40-320
System size		200	240	320
Item no.		66158 / 66156	66174 / 66175	66183 / 66185
A	[mm]	201	241	321
B	[mm]	225	264	324.5
C	[mm]	91	131	91

DEFLECTION 90° UL40 / UR40 – ACCESSORIES



NOTE

To ensure trouble-free transport, an accumulation monitoring system must be provided in the deflection.

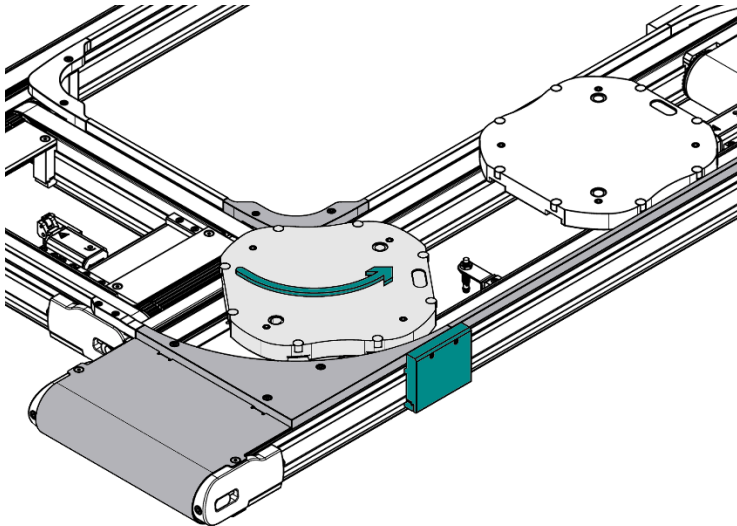
- Separator upstream from deflection, Article no. 65173 or 65174
- Holder for exit sensor, Art.No. 64658 for releasing the deflection area for the next workpiece carrier

Details on the mounting situation can be found on page 60.

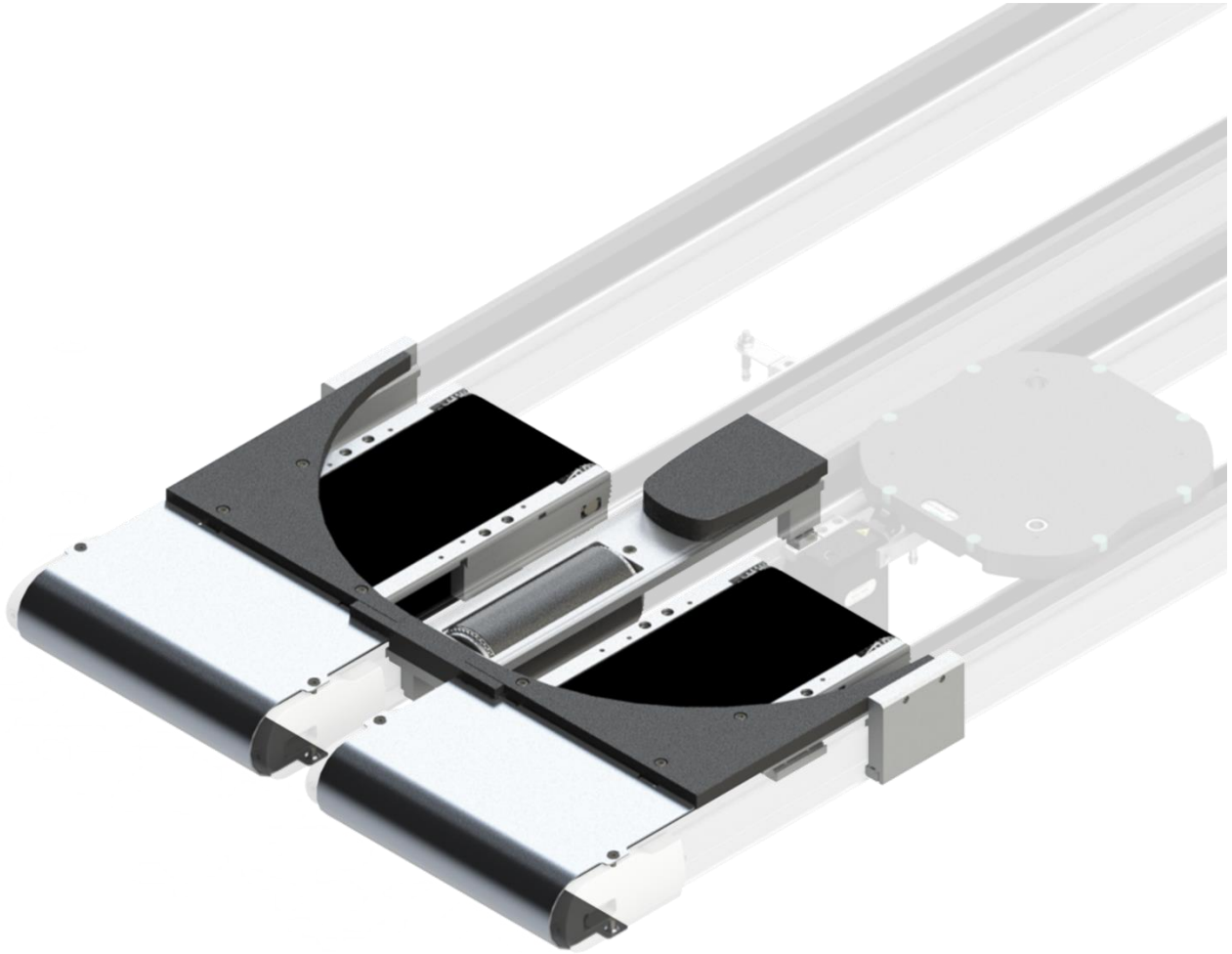
If the workpiece carrier is deflected in the direction of the lateral guide (see following figure), the stop, Art. no. 65504, MUST be provided as an accessory for support.

Stop	Item no.
	65504

For lateral support of the deflection in the following situation:



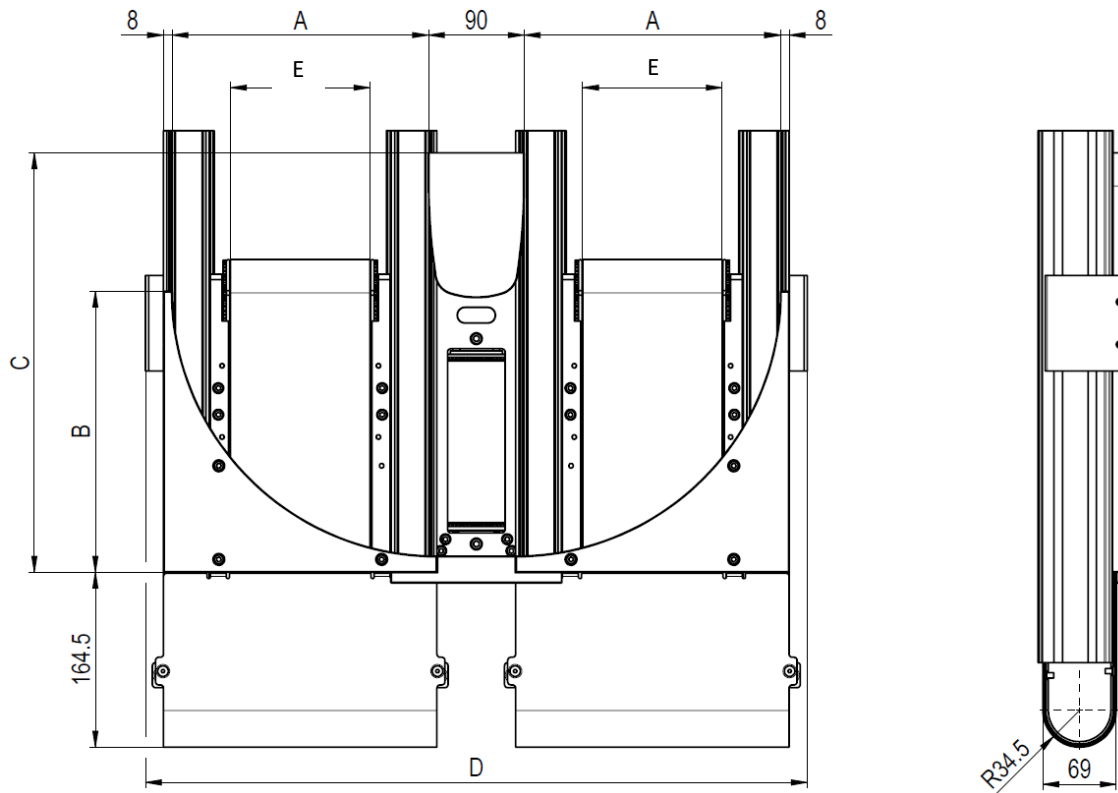
DEFLECTION 180° UL180/40 – PRODUCT DESCRIPTION



The **deflection in 180° version** connects two parallel conveyor sections. It basically consists of two 90° deflections and an intermediate piece with a 24V auxiliary drive. The 90° deflections are integrated into the conveyors and driven by means of the conveyor drive. The compact roller drive in the intermediate piece ensures a process-safe transition from the first deflection to the second. Analogous to the 90° deflection, it must also be ensured for the 180° variant that there is only one workpiece carrier in the deflection at a time.

To control the 24V auxiliary drive with integrated controller, all that is required is an analog speed setpoint 0-10V and a digital signal to specify the direction of rotation.

DEFLECTION 180° UL180/40 - DIMENSION DRAWING



Type		UL180/40-200	UL180/40-240	UL180/40-320
System size		200	240	320
Item no.		66154	66176	66186
A	[mm]	201	241	321
B	[mm]	225	264	342.5
C	[mm]	354	394	484
D	[mm]	542	622	782
E	[mm]	91	131	91

DEFLECTION 180° UL180/40 – ACCESSORIES



NOTE

To ensure trouble-free transport, an accumulation monitoring system must be provided in the deflection.

- Separator upstream from deflection, Article no. 65173 or 65174
- Holder for exit sensor, Art.No. 64658 for releasing the deflection area for the next workpiece carrier

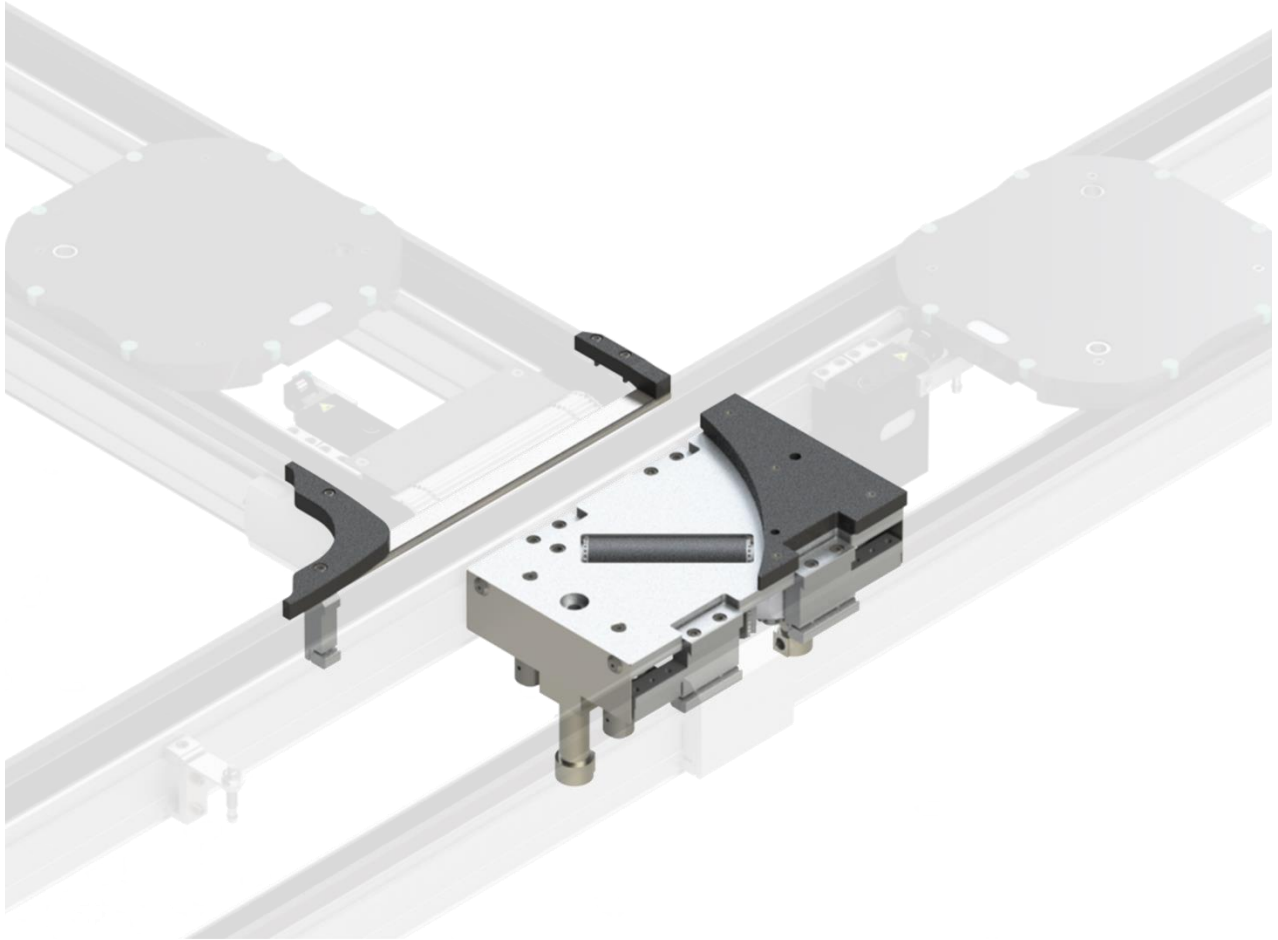
Details on the mounting situation can be found on page 61.

Connection cable for auxiliary drive	Item no.
3 m	522683
5 m	522684
10 m	522685

single-sided straight female connector
M12, 5-pin (5x0.52 mm², AWG20), shielded



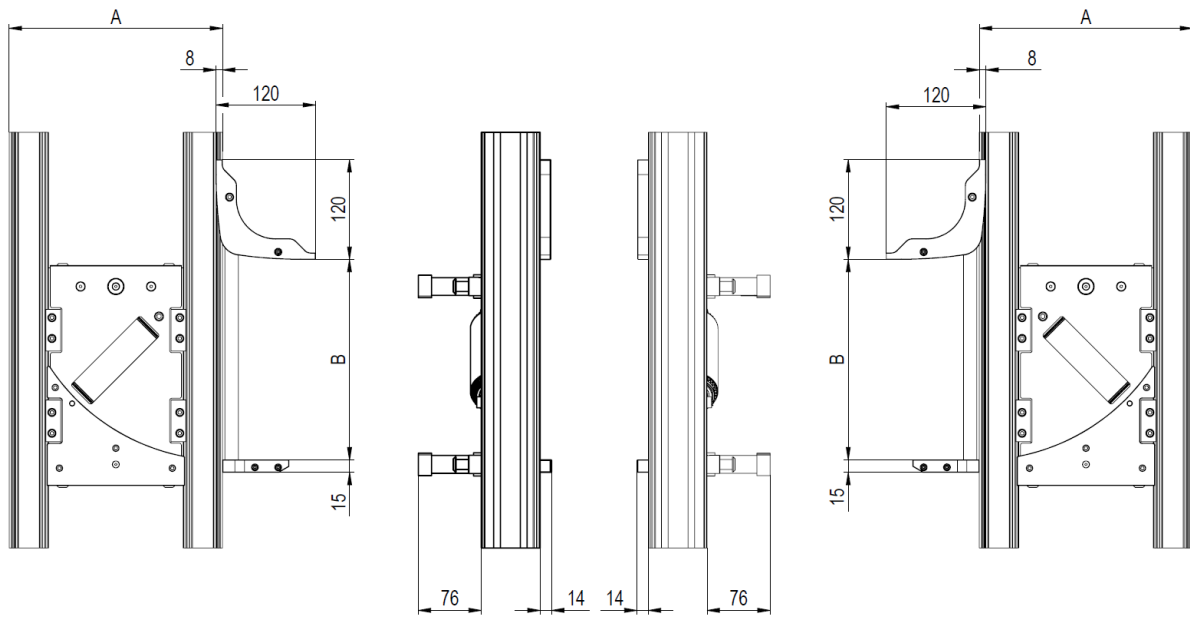
TRANSFER GATE WL40/WR40 - PRODUCT DESCRIPTION



The **transfer gate** enables the workpiece carriers to be diverted out of the main transfer line into a bypass or diverting from a bypass area back onto the main line. Workpiece carriers that are not to be fed in/out can pass the transfer gate without deflection. Integrated pneumatic lifting cylinders are used to activate the deflection. An auxiliary drive integrated in a roller ensures process-reliable deflection.

To control the 24V auxiliary drive with integrated controller, all that is required is an analog speed setpoint 0-10V and a digital signal to specify the direction of rotation.

WL40/WR40 TRANSFER GATE – DIMENSION DRAWING



Version left WL40

Version right WR40

Type	WR40-200 / WL40-200	WR40-240 / WL40-240	WR40-320 / WL40-320
System size	200	240	320
Item no.	65486 / 65476	64493 / 64496	64494 / 64497
A [mm]	217	257	337
B [mm]	201	241	321

Pneumatic cylinder

Number of cylinders	2
Pneumatic connection*	G1/8"
Functionality	double-acting

*Not included in the scope of delivery (see page 53).

WL40/WR40 TRANSFER GATE – ACCESSORIES



NOTE

To ensure trouble-free transport, an accumulation monitoring system must be provided for the transfer gate.

- Separator upstream from transfer gate, Article no. 65173 or 65174
- Holder for exit sensor, Art.No. 64658 for releasing the deflection area for the next workpiece carrier

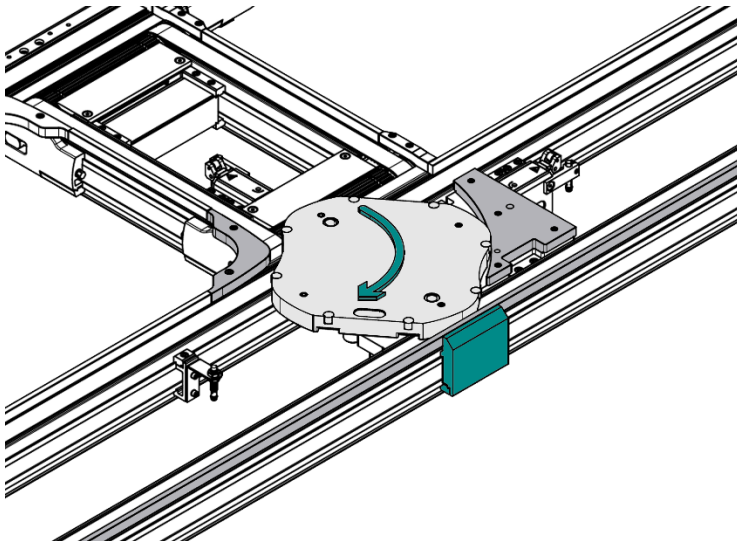
Details on the mounting situation can be found on page 63.

The pneumatic connections as well as the sensors incl. the mounting kits for controlling and monitoring the lifting cylinders are not included in the scope of delivery of the transfer gate, see page 51.

If the workpiece carrier is deflected in the direction of the lateral guide (see following figure), the stop, Art. no. 65400, MUST be provided as an accessory for support.

Stop	Item no.
	65400

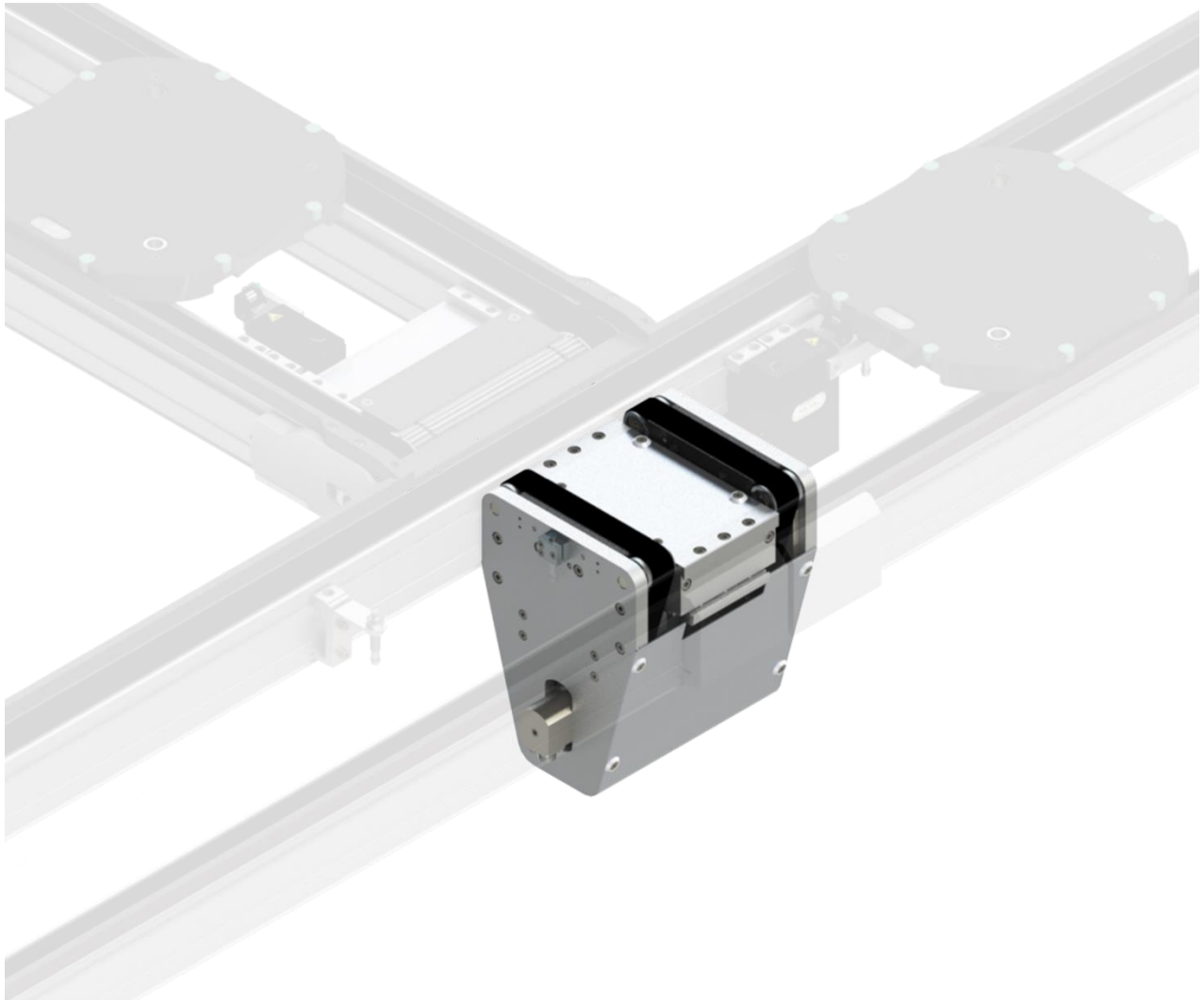
For lateral support of the lateral guide in the following situation:



Connection cable for auxiliary drive	Item no.
	3 m 522683
	5 m 522684
	10 m 522685
single-sided straight female connector M12, 5-pin (5x0.52 mm ² , AWG20), shielded	



TRANSVERSE DISCHARGE QA40 – PRODUCT DESCRIPTION

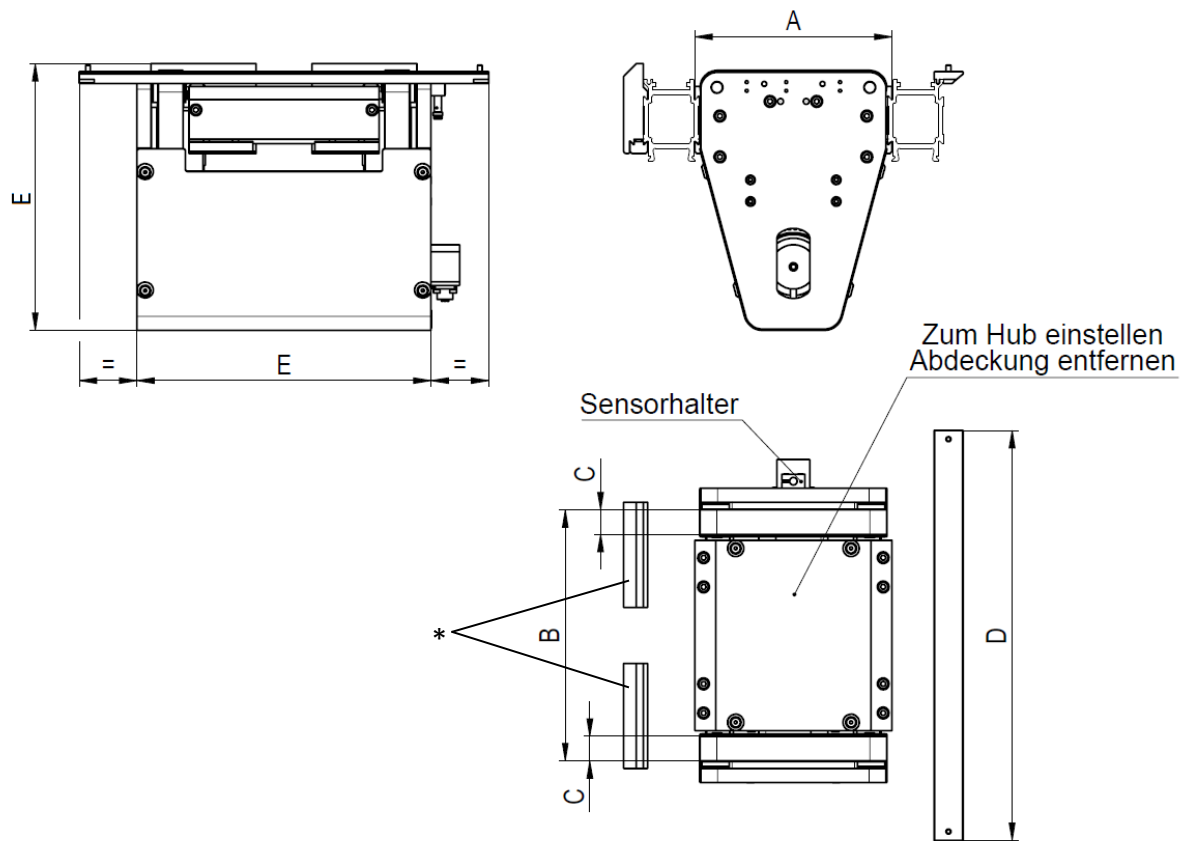


Analogous to the transfer gate, the **transverse discharge** enables the diversion of workpiece carriers from the main conveyor section into a bypass or a transfer from the bypass back into the main section – the main difference here, however, is the orientation of the workpiece carrier/product to the conveying direction. While the workpiece carrier retains its orientation when diverted by a transfer gate, it is conveyed further at right angles to the conveying direction by the transverse discharge. After reinsertion, the alignment is again in line with the main conveying direction.

It is placed between the two conveyor strands of a conveyor to save space. Integrated pneumatic lifting cylinders raise the unit so that the workpiece carrier lifts off the conveyor. The transverse movement is then provided by an auxiliary drive in the transverse discharge until the workpiece carrier is taken over by the transverse belt.

To control the 24V auxiliary drive with integrated controller, an analog speed setpoint 0-10V and a digital signal for specifying the direction of rotation are also required.

TRANSVERSE DISCHARGE QA40 – DIMENSION DRAWING



* Stops necessary as accessories depending on the layout situation

Type		QA40-200x200	QA40-200x240	QA40-240x240	QA40-240x320	QA40-320x320	QA40-320x480
System size		200		240		320	
Item no.		64891	65416	65441	65425	65408	64922
A	[mm]	129	129	169	169	249	249
B	[mm]	119	159	149	215	220.5	380
C	[mm]	16	16	21	21	25	25
D	[mm]	231	271	271	351	351	511
E	[mm]	202.45	202.45	228.3	228.3	218.32	218.32

Pneumatic cylinder

Pneumatic connection*	M5
Functionality	double-acting

* already included in the scope of delivery

TRANSVERSE DISCHARGE QA40 – ACCESSORIES



NOTE

To ensure trouble-free transport, an accumulation monitoring system must be provided in the deflection.

- Separator upstream from deflection, Article no. 65173 or 65174
- Holder for exit sensor, Art.No. 64658 for releasing the deflection area for the next workpiece carrier

Details on the mounting situation can be found on page 62.

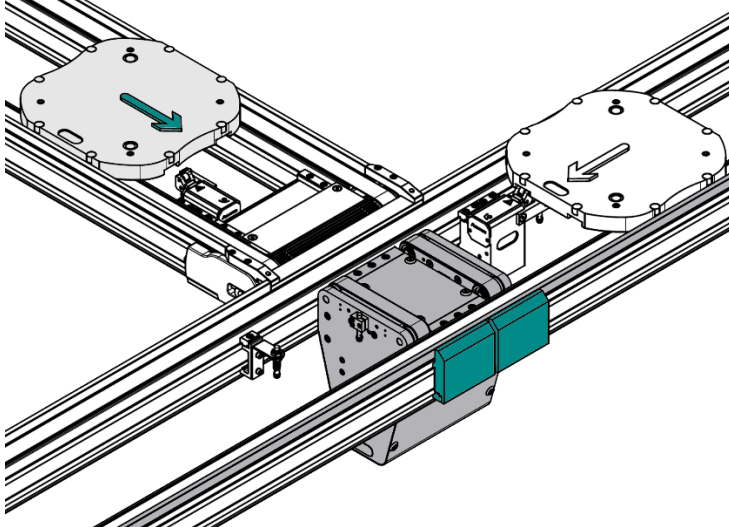
The sensor system incl. the mounting kits for controlling and monitoring the lifting cylinders and the workpiece carrier presence are not included in the scope of delivery of the transverse discharge system, see page 51.

When transferring a workpiece carrier from the transverse transport to the main line, it is essential to provide the stop, Art. no. 65400 as an accessory. This provides additional support for the lateral guide in the event of impact of the workpiece carrier.

Stop	Item no.
For lateral support of the lateral guide, wherever the workpiece carrier runs onto the lateral guide during infeed onto the conveyor.	65400



For lateral support of the lateral guide in the following situation:



From size 240, two stops per QA40 are required.

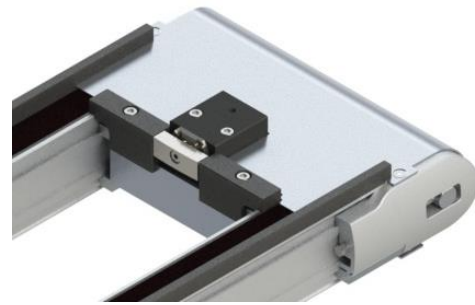
Connection cable for auxiliary drive	Item no.
3 m	522683
5 m	522684
10 m	522685
single-sided straight female connector M12, 5-pin (5x0.52 mm ² , AWG20), shielded	



STOP DAMPED / FIXED – PRODUCT DESCRIPTION



Fixed stop AF40

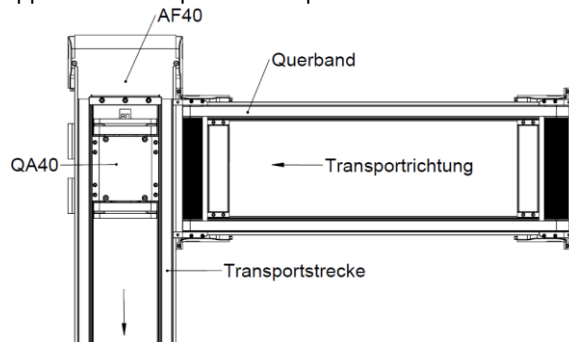


Damped stop AD40

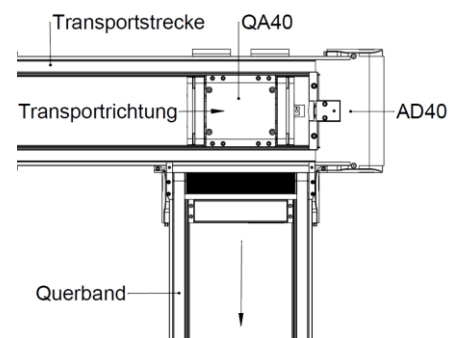
The **stop** is used to stop the workpiece carrier and as a lateral guide at the end of conveyors. The component encloses the drive roller with cladding and thus guarantees a hazard-free termination of the conveyor.

To stop accumulating workpiece carriers, the damped stop is always to be preferred to the fixed stop.

Application example fixed stop



Application example damped stop



Damped stop working range

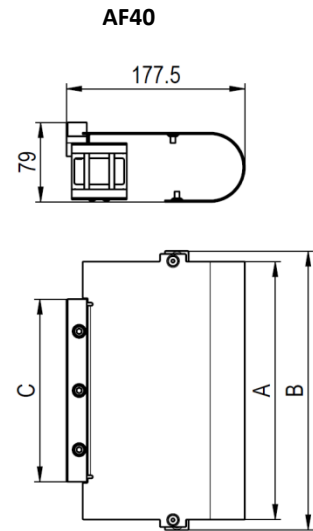
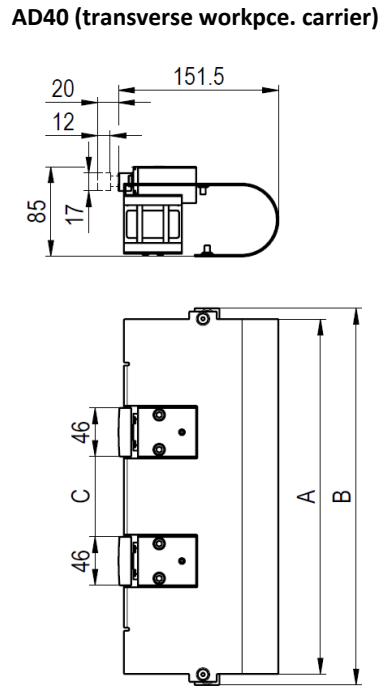
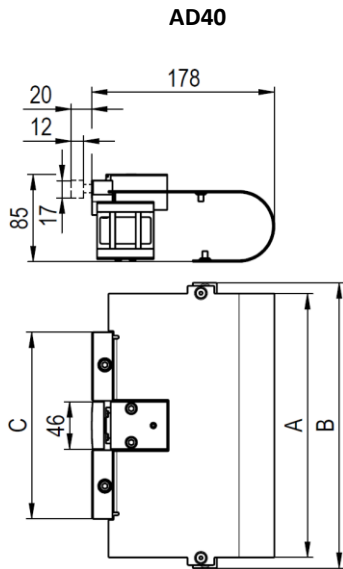
Conveying speed	[m/min]	6	9	12	15	18	21
permissible accumulation load	[kg]	60	40	35	32	30	27
Mass of workpiece carrier incl. payload							

Pneumatic cylinder

Pneumatic connection ¹⁾	M5
Functionality	single-acting

¹⁾ Not included in the scope of delivery of the stop (see page 53).

STOP DAMPED / FIXED – DIMENSION DRAWING

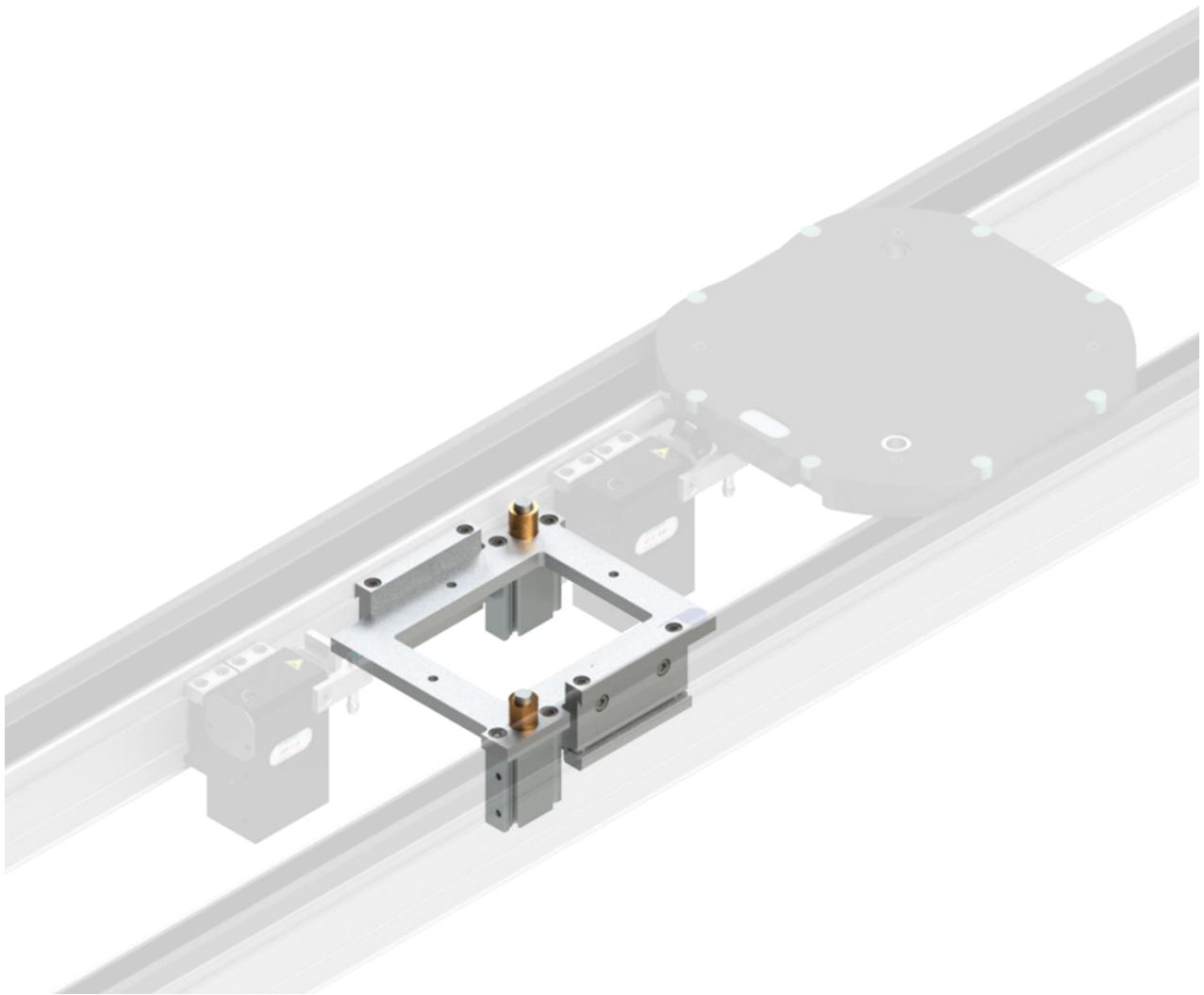


Type	AD40-200	AD40-240	AD40-320
Item no.	65195	65196	65224
A [mm]	217	257	337
B [mm]	238	278	358
C [mm]	142	182	262

Type	AD40-320 transverse	AD40-480 transverse
Item no.	65197	65198
A [mm]	337	497
B [mm]	358	518
C [mm]	76.5	247

Type	AF40-200	AF40-240	AF40-320	AF40-480
Item no.	65213	65214	65215	65216
A [mm]	217	257	337	497
B [mm]	238	278	358	518
C [mm]	142	182	262	422

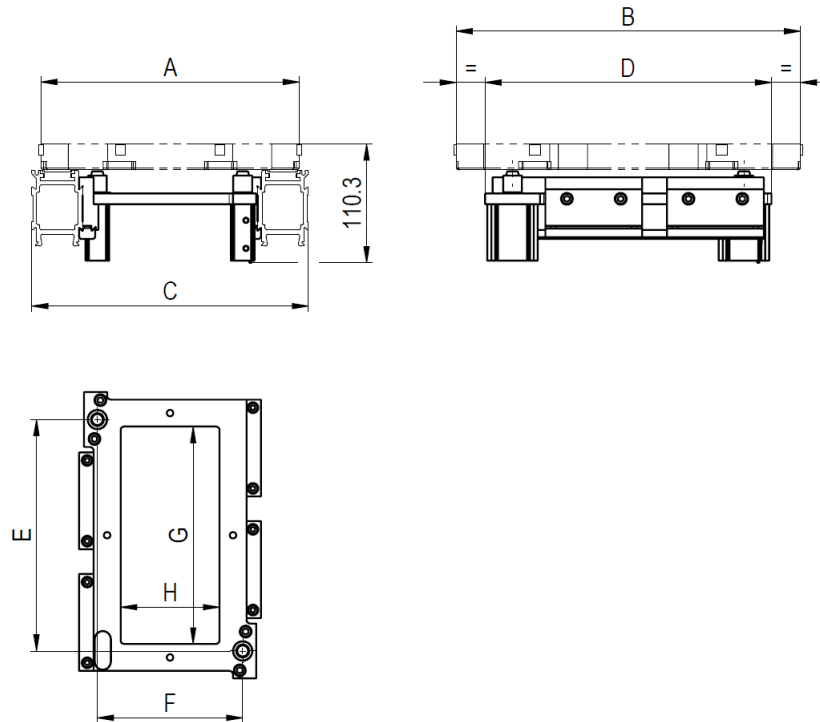
INDEXING DEVICE IV40 – PRODUCT DESCRIPTION



Does your manufacturing process require manual inspection or control steps along the transport route? Then the Montech LT40 **indexing device** is the ideal solution. This device – preferably placed outside the main conveyor line – positions the workpiece carrier in the horizontal plane with a repeatability of ± 0.1 mm and secures it against shifting*; ideal for work processes at manual workstations. Hold-down devices as accessories prevent the workpiece carrier from lifting off the conveyor line. Another advantage is that the simple mechanics of the indexing device are inexpensive and require little space.

* Movement of the workpiece carrier in the positioning clearance still possible

INDEXING DEVICE IV40 – DIMENSION DRAWING



Type	IV40-200x200	IV40-200x240	IV40-240x240	IV40-240x320	IV40-320x320	IV40-320x480
System size	200		240		320	
Item no.	65338	65341	65349	65347	65345	65343
A [mm]	200	200	240	240	320	320
B [mm]	200	240	240	320	320	480
C [mm]	217	217	257	257	337	337
D [mm]	146	186	186	266	266	426
E [mm]	95	135	135	215	215	375
F [mm]	95	95	135	135	215	215
G [mm]	116	156	122	202	192	352
H [mm]	68	68	92	92	162	162

Pneumatic cylinder

Number of cylinders	2
Pneumatic connection*	M5
Functionality	double-acting

* not included in scope of delivery (see page 53)



NOTE

The workpiece carrier is not decoupled from the toothed belt in the indexing device. Vertical process forces require a PV40 positioning device or AV40 placing unit.

Movement of the workpiece carrier in the positioning clearance is still possible in the locked state.

INDEXING DEVICE IV40 – ACCESSORIES



NOTE

Stoppers and separators must be planned as accessories for the indexing device.

- Separator upstream from the device, Art.No. 65173 or 65174
- Stopper to stop the workpiece carrier above the device, Art.No. 65220 or 65221
- Sensor holder for presence check see Stopper/Separator Accessories page 24

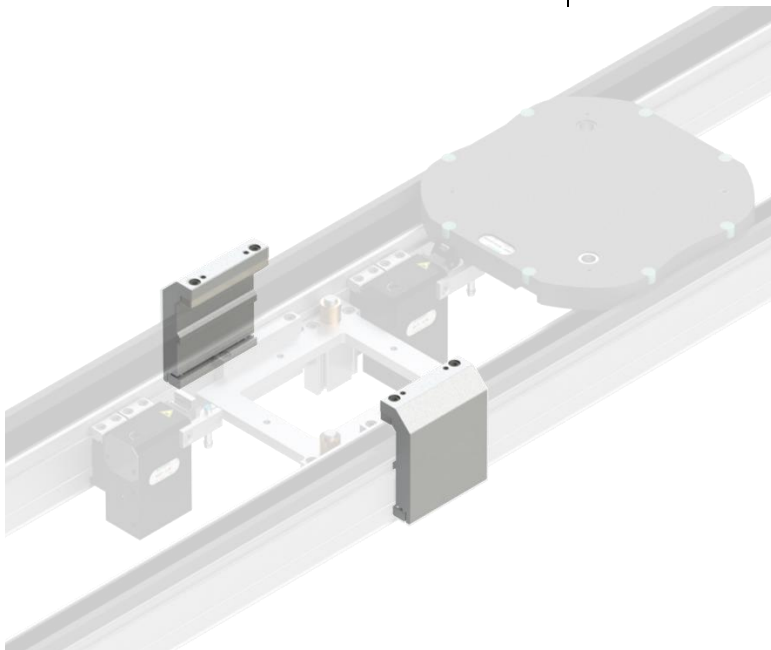
Details on the mounting situation can be found on page 64.

The sensor system incl. the mounting kits for controlling and monitoring the lifting cylinders and the workpiece carrier presence are not included in the scope of delivery, see page 51.

Hold down for IV40

Item no.

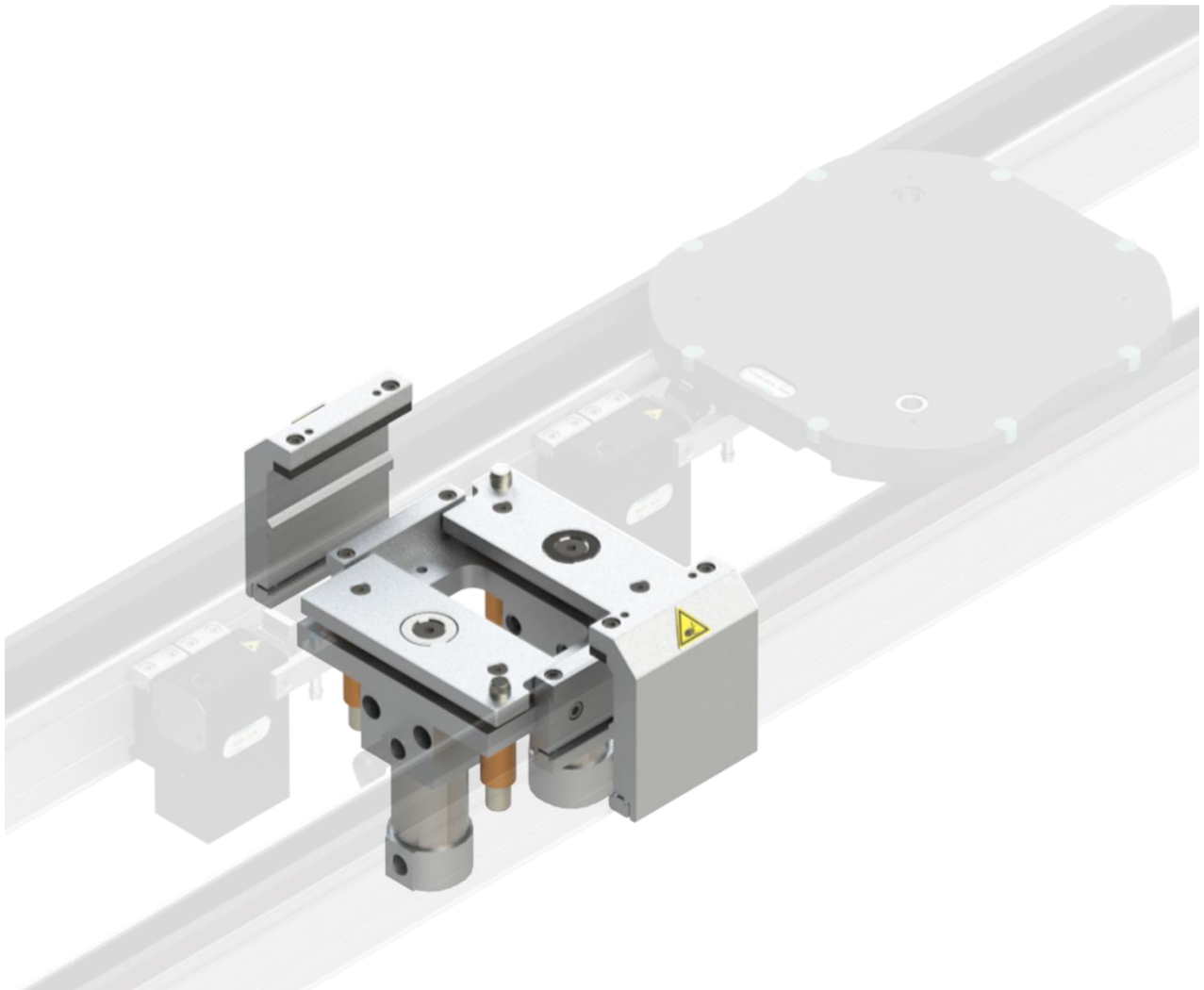
65381



Prevents the workpiece carrier from lifting off the conveyor e.g. at manual workstations. The desired clearance between workpiece carrier and hold-down is adjustable via the adjustable stop jaw.

If required, 2 hold-down devices must be planned for each fixture, from workpiece carrier size 240x320, 4 each.

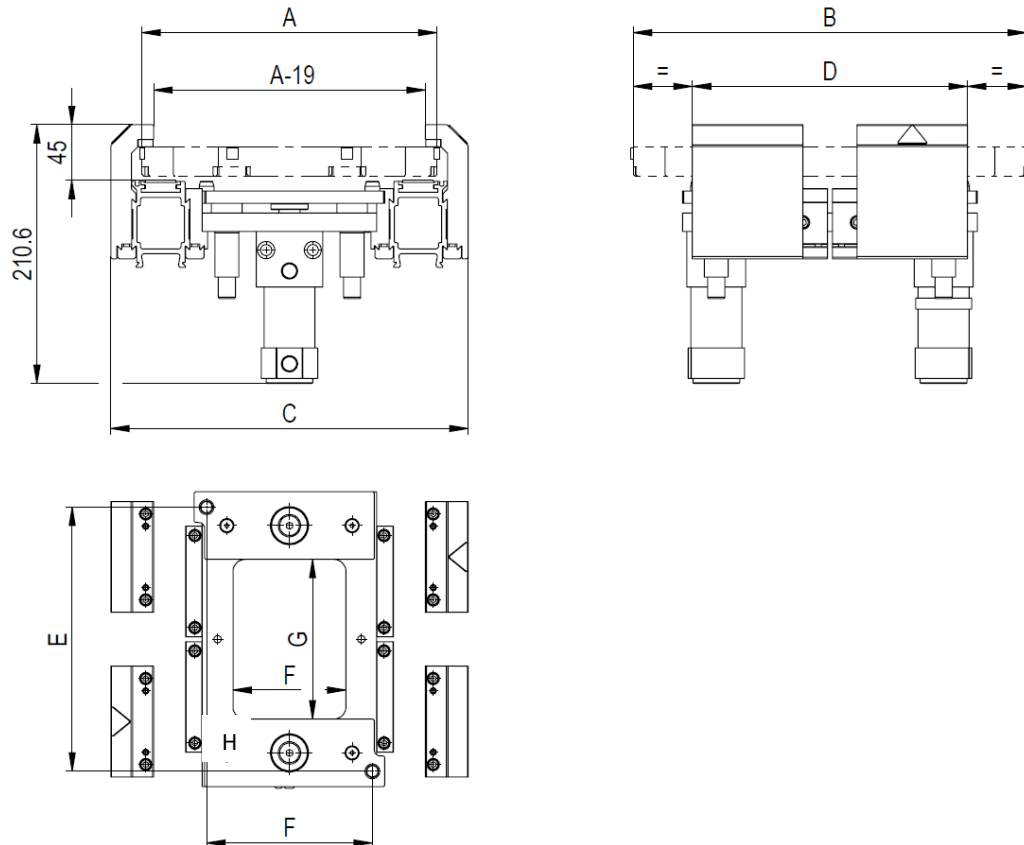
POSITIONING UNIT PV40 - PRODUCT DESCRIPTION



The **positioning unit** lifts the workpiece carrier off the conveyor by a few millimeters and brings it into a defined position. The stop position in Z-direction is defined by adjustable hold-downs, in X/Y-direction a repeatability of ± 0.05 mm is guaranteed. Decoupling the workpiece carrier from the conveyor relieves the load on the toothed belt. This allows a machining or assembly process to be performed without stopping the transfer line – pressing forces of up to 1400 N are permissible.

The positioning unit is also placed between the two conveyor strands of the conveyor and positioned and fixed using the dovetail clamping technique. Subsequent relocation of the workstation is possible without any problems.

POSITIONING UNIT PV40 – DIMENSION DRAWING



Type	PV40-200x200	PV40-200X240	PV40-240X240	PV40-240X320	PV40-320X320	PV40-320X480
System size	200		240		320	
Item no.	64358	64455	65227	64431	65228	64397
A [mm]	200	200	240	240	320	320
B [mm]	200	240	240	320	320	480
C [mm]	251	251	291	291	371	371
D [mm]	90	90	90	224	216	376
E [mm]	95	135	135	215	215	375
F [mm]	--	--	135	135	215	215
G [mm]	--	--	50	130	130	290
H [mm]	--	--	92	92	162	162

Pneumatic cylinder

Number of cylinders ¹⁾	2
Pneumatic connection ²⁾	G1/4"
Functionality	double-acting

¹⁾ Only one cylinder for size 200x200

²⁾ Not included in scope of delivery (see page 53)


NOTE

Stoppers and separators must be planned as accessories for the positioning unit.

- Separator upstream from the device, Art.No. 65173 or 65174
- Stopper to stop the workpiece carrier above the device, Art.No. 65220 or 65221
- Sensor holder for presence check see Stopper/Separator Accessories page 24

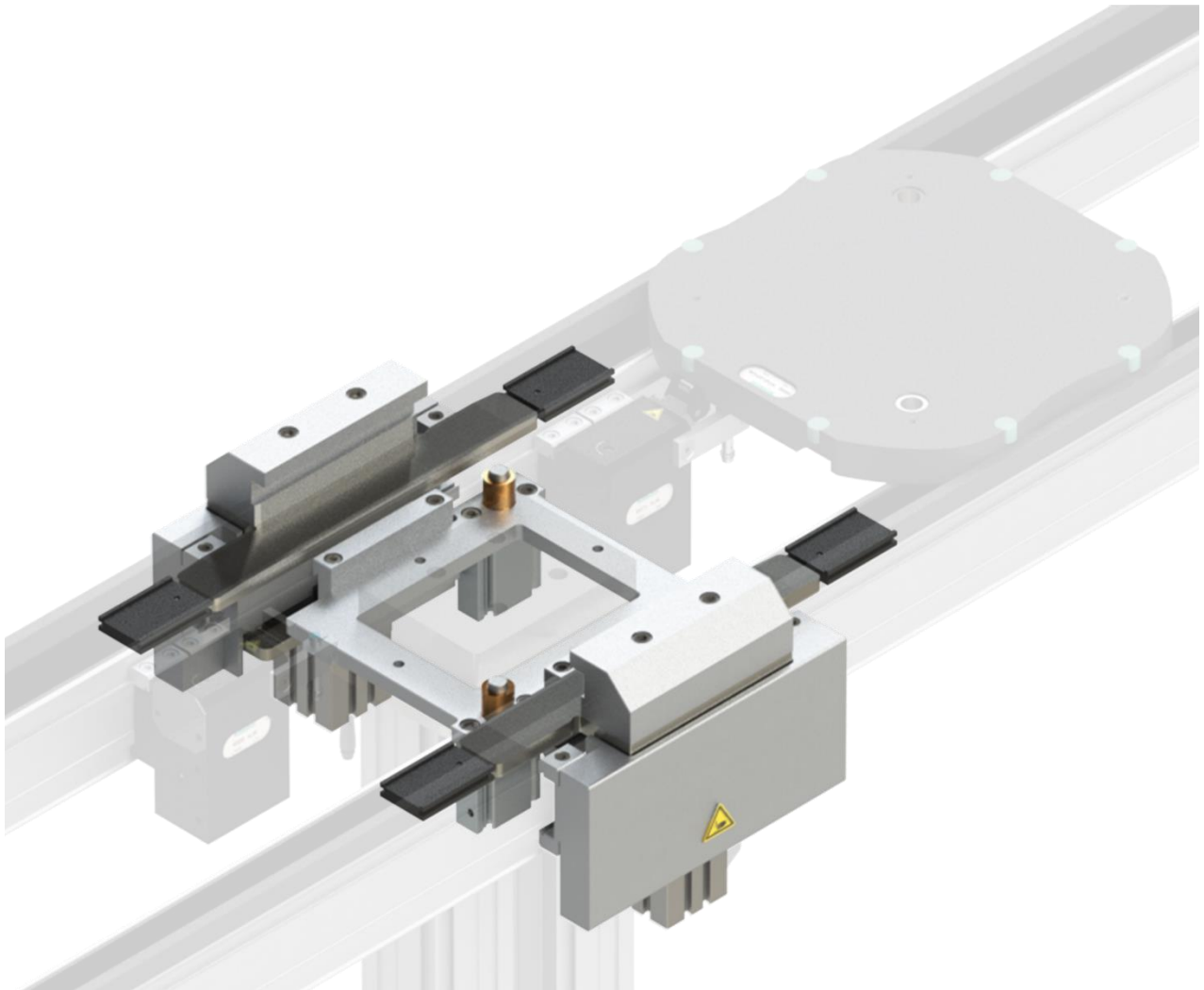
Details on the mounting situation can be found on page 64 **Fehler! Textmarke nicht definiert..**

The sensor system incl. the mounting kits for controlling and monitoring the lifting cylinders and the workpiece carrier presence are not included in the scope of delivery, see page 51.


CAUTION

It is mandatory to use throttle fittings for the lifting cylinders in order to throttle the lifting movement in accordance with the moving mass.

PLACING UNIT AV40 – PRODUCT DESCRIPTION

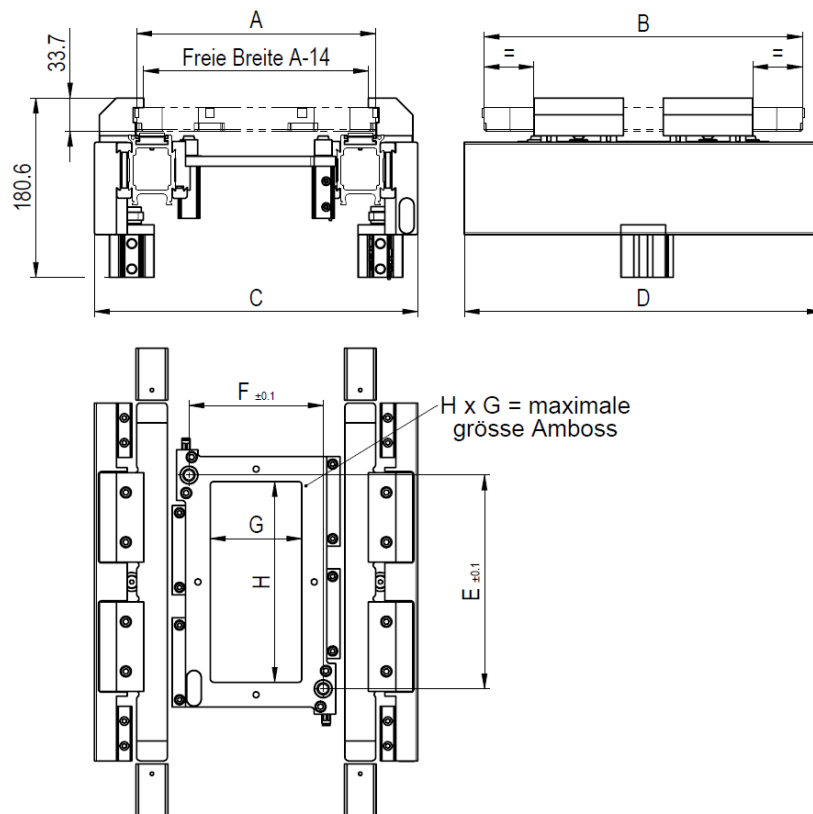


The **placing unit** takes on a **vertical load of up to 60 kN** and is thus clearly the strongest of the Montech positioning units. For this, however, it requires an anvil* to support the workpiece carrier.

The workpiece carrier is positioned in the X/Y plane by means of the two centering cylinders with a repeat accuracy of ± 0.05 mm. For the pressing process on the workpiece carrier, the sliding guides below the toothed belts can be lowered by lifting cylinders. This prevents jamming of the toothed belts and saves stopping the conveyor line for the work process. However, this lowering mechanism requires mechanical processing in the profile of the conveyor strands – which we will of course be happy to do for you.

* Not included in the scope of delivery

PLACING UNIT AV40 – DIMENSION DRAWING



Type		AV40-200x200	AV40-200X240	AV40-240X240	AV40-240X320	AV40-320X320	AV40-320X480
Item no.		66260	66261	66262	66265	66264	66267
A	[mm]	200	200	240	240	320	320
B	[mm]	200	240	240	320	320	480
C	[mm]	285	285	325	325	405	405
D	[mm]	190	190	190	360	360	390
E	[mm]	95	135	135	215	215	375
F	[mm]	95	95	135	135	215	215
G	[mm]	68	68	92	92	162	162
H	[mm]	116	156	122	202	192	352

Pneumatic cylinder

Number of cylinders	total 4 (2 and 2)
Pneumatic connection*	G1/8" and M5
Functionality	double-acting

* not included in scope of delivery (see page 53)


NOTE

Stoppers and separators for the placing unit must be planned as accessories.

- Separator upstream from the device, Art.No. 65173 or 65174
- Stopper to stop the workpiece carrier above the device, Art.No. 65220 or 65221
- Sensor holder for presence check see Stopper/Separator Accessories page 24

Details on the mounting situation can be found on page 65.

The sensor system incl. the mounting kits for controlling and monitoring the lifting cylinders and the workpiece carrier presence are not included in the scope of delivery, see page 51.

Process forces are only permitted in the area supported by the anvil.

LIFT – PRODUCT DESCRIPTION



The **lift** literally lifts the LT40 transfer system to another level – a transfer system on several floors becomes possible. Also suitable for space-saving systems by placing the return line below the production line. The lift moves up to two workpiece carriers simultaneously vertically with a level difference of up to 5.6 meters. Variable approach and braking ramps of the lift axis allow a smooth lifting motion even for sensitive transport goods.

For enclosing the lift area, the Montech Aluminum framing system offers an extremely flexible solution. You will receive a customized lift frame with inlet and outlet tunnels entirely according to your wishes and requirements.

LIFT – TECHNICAL DATA

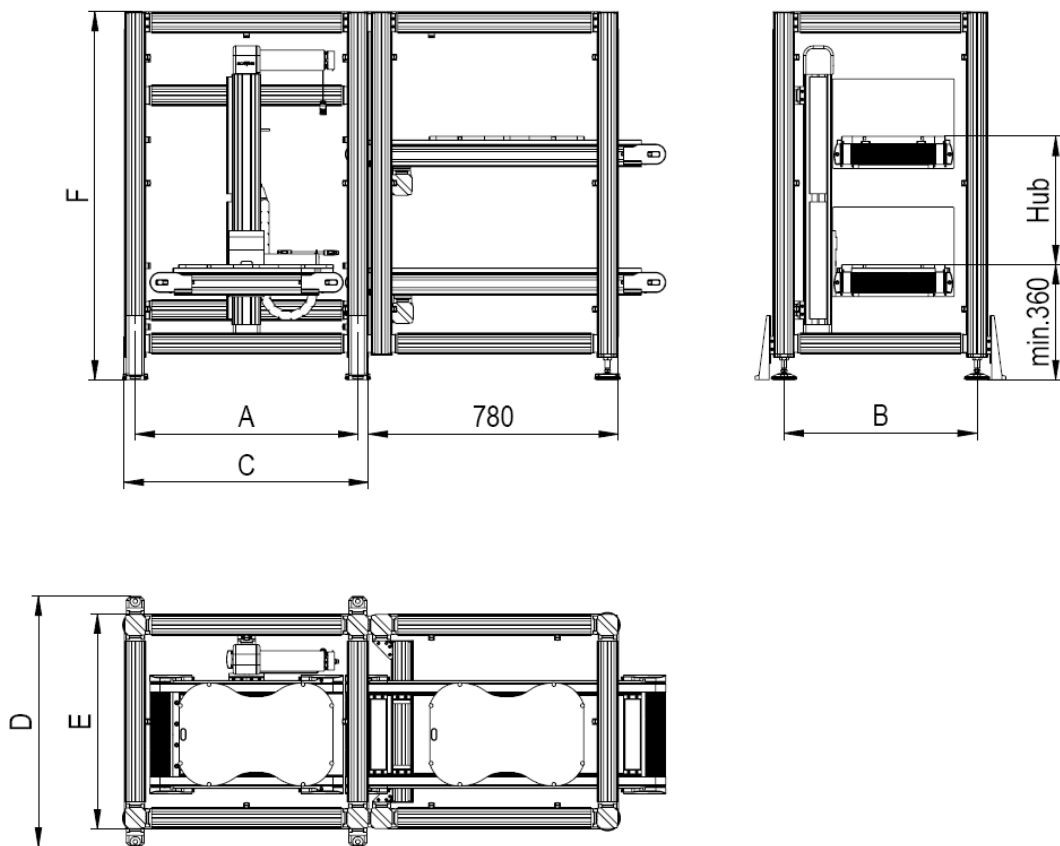
Lift	
Ambient temperature	+10 to +40 °C
Relative humidity	< 85% (without condensation)
Air purity level	Normal workshop atmosphere
Stroke	400 mm – 5600 mm
Payload¹	
Weight workpiece carrier (WT)	
200x200	1.2 kg
200x240	1.5 kg
240x240	1.8 kg
240x320	2.4 kg
320x320	3.3 kg
320x480	4.7 kg
Max. Payload for workpiece carrier	
200x200	7 kg
200x240	8.4 kg
240x240	8.4 kg
240x320	11.2 kg
320x320	11.2 kg
320x480	16.8 kg
max. weight workpiece carriers incl. payload	21.5 kg
Weight belt path	approx. 10.0 kg
Maximum attachment weight	32.0 kg
Motor	
Protection rating	IP40
Motor type	BLDC
Rated voltage	24VDC
Rated current	12.5A
Input power in nominal operation	300W
Rated power output	250W
Duty cycle	100%



CAUTION

The maximum attachment weight of 32 kg must not be exceeded under any circumstances. The attachment weight includes the max. weight of all workpiece carriers incl. payload on the lift belt, the lift belt and all other attachments such as actuators and sensors.

LIFT – DIMENSION DRAWING



STROKE = 400 - 5600 MM

1 WORKPIECE CARRIER ON LIFT BELT

Type		200x200	200x240	240x240	240x320	320x320	320x480
A	[mm]	414	454	454	534	534	694
B	[mm]	482	482	522	522	602	602
C	[mm]	482	522	522	602	602	762
D	[mm]	662	662	702	702	782	782
E	[mm]	550	550	590	590	670	670

2 WORKPIECE CARRIERS ON LIFT BELT

Type		200x200	200x240	240x240
A	[mm]	618	698	698
C	[mm]	686	766	766

SENSORS – OVERVIEW

Item no.	Image	Description	WR40 / WL40	QA40		IV40	PV40		AV40	VL40	VR40	SL40	SR40
				up to 200x240	from 240x240		up to 200x240	from 240x240					
521885		Inductive sensor Ø 6.5		3	3					1		1	
66309		Sensor holder for SL										1	
66308		Sensor holder for VL							1				
522686		Proximity switch M8									1		1
64658		Sensor holder									1		1
510100		Magnetic cylinder sensor	2				2	2		1-2*	1-2*	1-2*	1-2*
510101		Magnetic cylinder sensor				2			4				
521897		Mounting kit					2						
521929		Mounting kit	2										
521907		Mounting kit						2					

* It is recommended to use two sensors so that the upper and lower end position of the stopper / separator can be checked.

SENSORS – TECHNICAL DATA

Inductive proximity switch	Item no.
<p>Design: cylindrical, \varnothing 6.5</p> <p>Switching distance: 4 mm</p> <p>Installation type: non-flush</p> <p>Switching output: PNP</p> <p>Output function: Normally open contact</p> <p>Connection type: M8 plug, 3-pin</p> <p>Protection class: IP67</p>	<p>521885</p>



Proximity switch M8	Item no.
<p>Design: cylindrical with thread</p> <p>Sensor length: 46 mm</p> <p>Switching distance: 6 mm</p> <p>Installation type: non-flush</p> <p>Switching output: PNP</p> <p>Output function: Normally open contact</p> <p>Connection type: M8 plug, 3-pin</p> <p>Protection class: IP67</p>	<p>522686</p>



Magnetic cylinder sensor	Item no.
<p>Type: for T-slot</p> <p>Switching output: PNP</p> <p>Output function: NO contact</p> <p>Connection type: cable with plug M8, 3-pin, 0.3 m</p> <p>Protection class: IP67</p>	<p>510100</p>



Magnetic cylinder sensor	Item no.
<p>Type: for C-slot</p> <p>Switching output: PNP</p> <p>Output function: NO contact</p> <p>Connection type: cable with plug M8, 3-pin, 0.3 m</p> <p>Protection class: IP67</p>	<p>510101</p>



PNEUMATIC CONNECTIONS – OVERVIEW

Item no.		QA40		IV40	PV40		AV40	VL40	VR40	SL40	SR40	AD40	
		WR40 / WL40	up to 200x240		from 240x240	up to 200x240						from 240x240	Workpiece carrier
521620		4					4						
504928				4			4						
521895					2								
506319						4*							
521932													
505024								2	2	2	2	1	2
521958			2*										

*Already included in the scope of delivery of the QA40

Pneumatic connection	Item no.	
Angle screw-in connection 1/8" pluggable ø6 mm	521620	
Screw-in connection M5, pluggable ø4 mm	504928	
Exhaust air throttle fitting 1/4" pluggable ø8 mm	521895	
Angle screw-in connection M5 pluggable ø4 mm	506319	
Angle screw-in connection 1/4" pluggable ø8 mm	521932	
Exhaust air throttle fitting M5 pluggable ø6 mm	505024	
Throttle check valve M5 pluggable ø4 mm	521958	

SUBSTRUCTURE

LT40 conveyor clamp adapter for LP-66-40	Ref. No.
	65709

Conveyor clamp for floor stand narrow. The conveyor clamp can be screwed front-sided on a LP-66-40 profile.

Further quick-set components can be found on www.montech.com.



LT40 Conveyor clamp QS	Ref. No.
	66850

Conveyor clamp for floor stand wide. The conveyor clamp can be flexibly installed on quick-set substructures with the dovetail guide on the bottom side of the conveyor clamp.

Further quick-set components can be found on www.montech.com.



LT40 Conveyor clamp M6	Ref. No.
	66126

The conveyor can be mounted directly on a flat surface using the fixation hole M6 of the conveyor clamp.

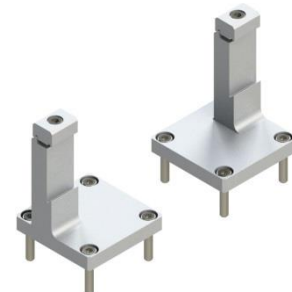
Further quick-set components can be found on www.montech.com.



LT40 conveyor clamp adapter 20mm for LP-66-40	Ref. No.
left	66807
right	66809

Conveyor clamp for floor stand narrow. The conveyor clamp can be screwed front-sided on a LP-66-40 profile.

Further quick-set components can be found on www.montech.com.



LT40 Conveyor clamp 20mm	Ref. No.
left	66811
right	66813

Conveyor clamp for floor stand wide. The conveyor clamp can be flexibly installed on quick-set substructures with the dovetail guide on the bottom side of the conveyor clamp.

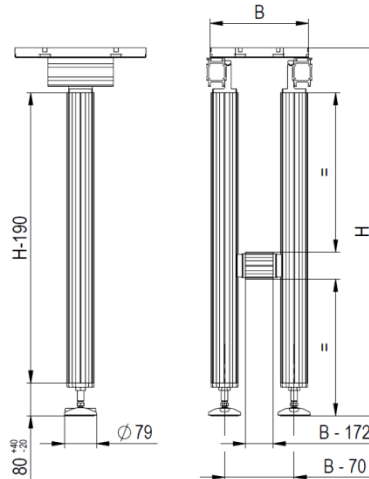
Further quick-set components can be found on www.montech.com.



SUBSTRUCTURE – FLOOR STANDS

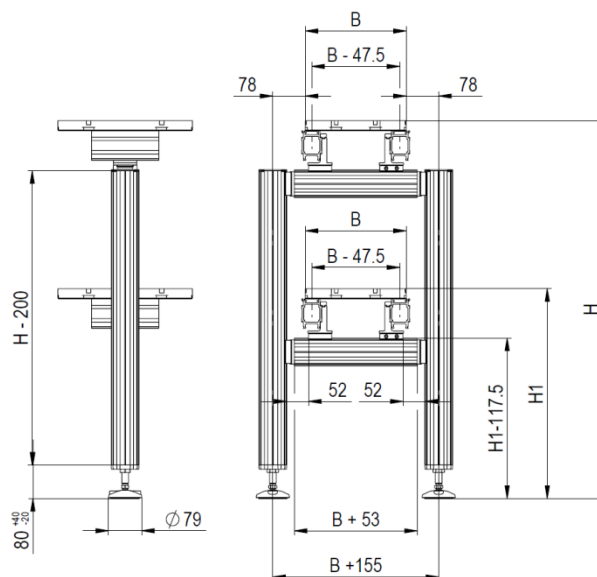
Floor stand narrow	Type	B [mm]	H [mm]	Ref. No.
	ST40-200	200	250-1500*	65930/0000
	ST40-240	240	250-1500*	65931/0000
	ST40-320	320	250-1500*	65932/0000
	ST40-480	480	250-1500*	65933/0000

With LT40 conveyor clamp adapter for LP-66-40
(Ref. No. 65709)



Floor stand wide	Type	B [mm]	H [mm]	Ref. No.
	ST40-200	200	250-1500*	65934/0000
	ST40-240	240	250-1500*	65935/0000
	ST40-320	320	250-1500*	65936/0000
	ST40-480	480	250-1500*	65937/0000

With LT40 Conveyor clamp QS
(Ref. No. 66850)

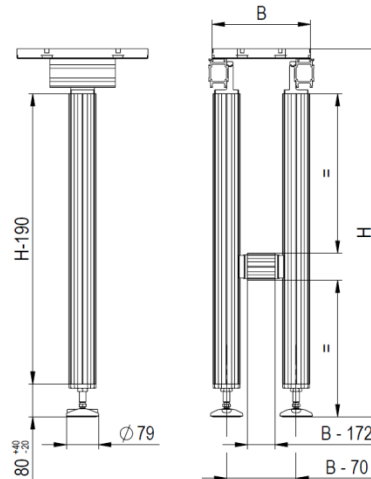


SUBSTRUCTURE – FLOOR STANDS

Floor stand narrow	Type	B [mm]	H [mm]	Ref. No.
	ST40-200	200	250-1500*	66855/0000
	ST40-240	240	250-1500*	66856/0000
	ST40-320	320	250-1500*	66857/0000
	ST40-480	480	250-1500*	66858/0000

With LT40 conveyor clamp adapter 20mm for LP-66-40 (Ref. No. 66807; 66809)

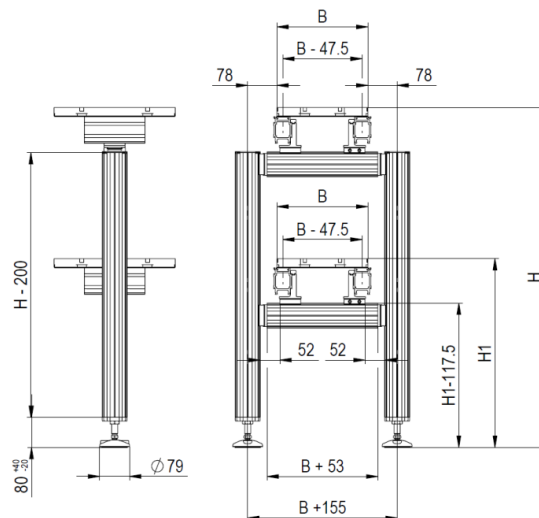
Note: It is only to use in that case, when a floor stand with conveyor clamp adapter for LP-66-40 is not installable.



Floor stand wide	Type	B [mm]	H [mm]	Ref. No.
	ST40-200	200	250-1500*	66851/0000
	ST40-240	240	250-1500*	66852/0000
	ST40-320	320	250-1500*	66853/0000
	ST40-480	480	250-1500*	66854/0000

With LT40 conveyor clamp adapter 20mm for LP-66-40 (Ref. No. 66807; 66809)

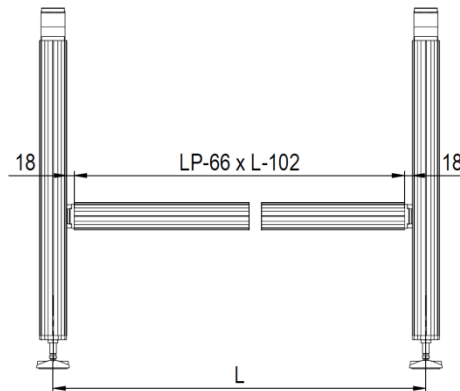
Note: It is only to use in that case, when a floor stand with conveyor clamp adapter for LP-66-40 is not installable.



SUBSTRUCTURE – STABILISATION EQUIPMENT

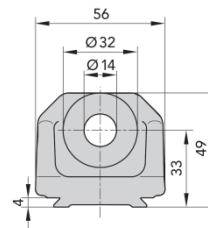
Longitudinal bracing LP-66-40	L [mm]	Ref. No.
	500-2000	67104/0000

Longitudinal bracing can be used as a bracing between two floor stands.



Floor anchor bracket FW40	Ref. No.
	46201N

For fixing the floor stand to the floor.
The bore diameter is $\varnothing 14$ mm.



Further quick-set components can be found on www.montech.com.

Clamping element, longitudinal/longitudinal SLL-55-40	Ref. No.
	40201N

Connector for joining longitudinal bracing or floor anchor bracket.

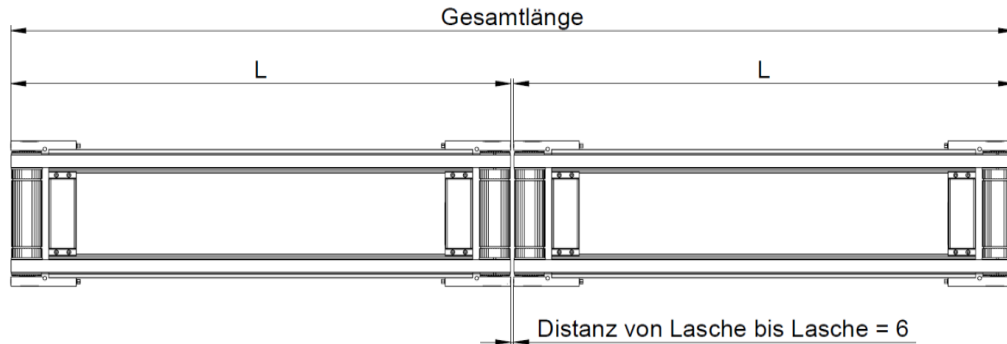
Further quick-set components can be found on www.montech.com.



NOTES ON LAYOUT PROJECT PLANNING – CONVEYOR

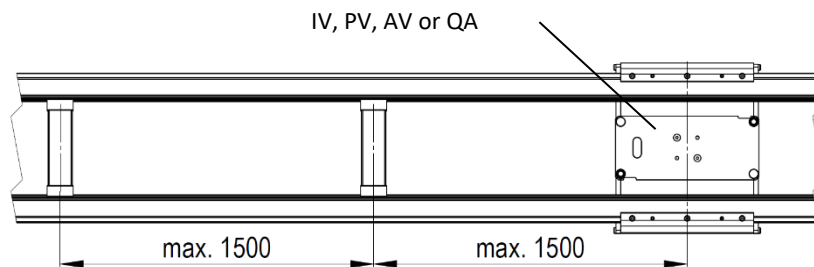
CONVEYORS IN SERIES

A gap of 6 mm must be provided between serially arranged conveyors. The transition between two conveyors must be closed with the transition cladding, see page 17.



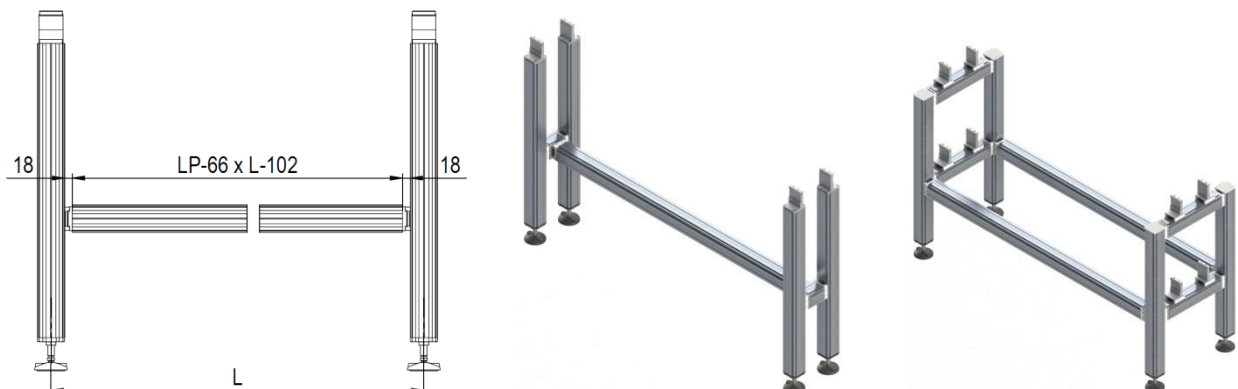
CONNECTING SUPPORTS TO THE CONVEYOR

Connecting supports give the conveyor the necessary stability for the application. Indexing, positioning, placing units or transverse discharges can compensate for the connecting supports as stability supports.



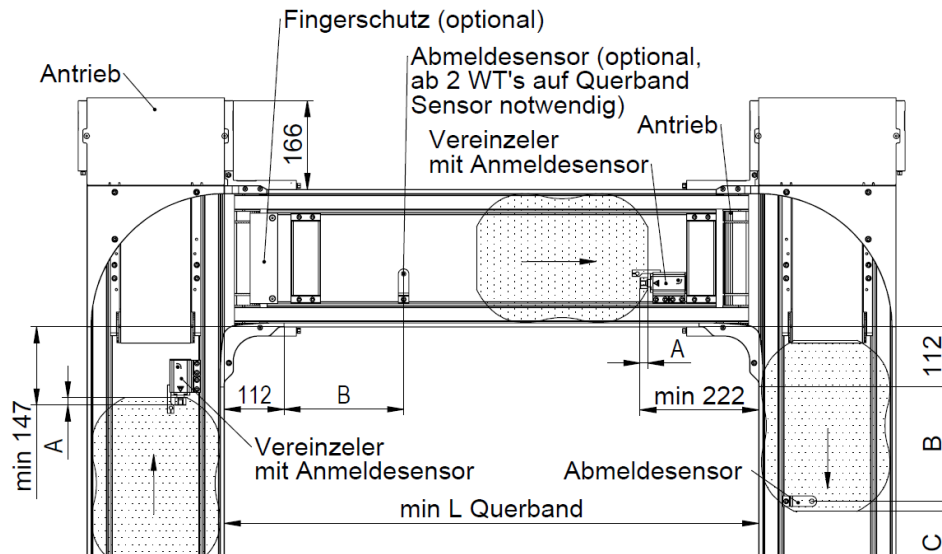
NOTES ON LAYOUT PROJECT PLANNING – FLOOR STAND

To stabilize the substructure, connect the floor stands with longitudinal struts. We recommend not to exceed a distance of 1500 mm between the floor stands.



NOTES ON LAYOUT PROJECT PLANNING – DEFLECTION 90°

For process reliability, a separator must be installed upstream of the 90° deflection so that no jam/accumulation situation occurs in the deflection. By means of an inductive sensor at the output (sign-off sensor), the deflection area can be released again for the next workpiece carrier.



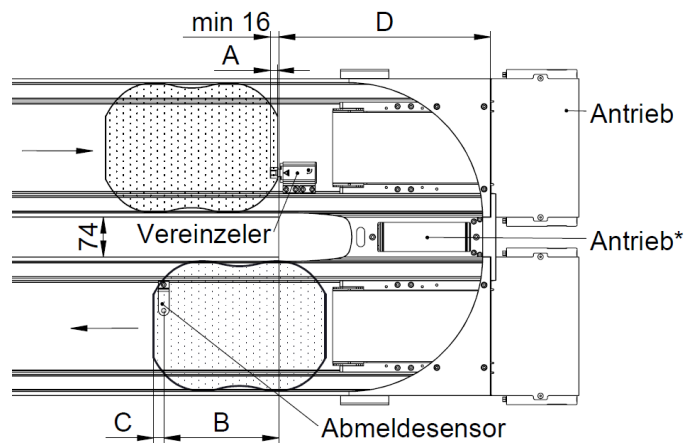
Type		UL40-200 / UR40-200		UL40-240 / UR40-240		UL40-320 / UR40-320	
		WT-200x200	WT-200x240	WT-240x240	WT-240x320	WT-320x320	WT-320x480
A	[mm]	7	7	7	14	14	14
B	[mm]	118	158	163	214	214	374
C	[mm]	12	12	12	19	19	19

Minimum length of the transverse belt for a workpiece carrier: $\text{min L transverse belt} = \text{length workpiece carrier} + D + 222\text{mm}$

Minimum length of the transverse belt from 2 workpiece carriers: $\text{min L transverse belt} = \text{number workpiece carriers} \times \text{length workpiece carriers} + D + 222\text{mm}$

NOTES ON LAYOUT PROJECT PLANNING – DEFLECTION 180°

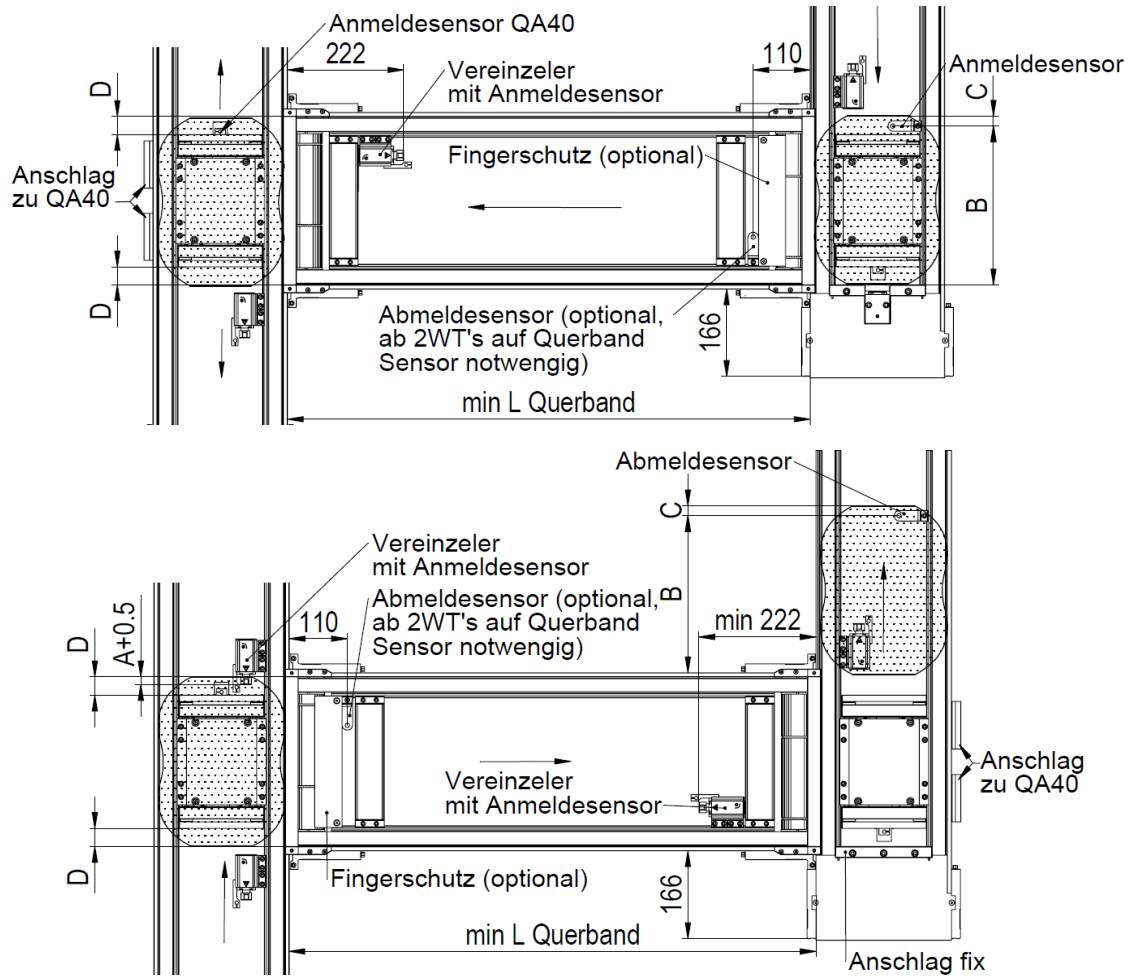
Analogous to the 90° deflection, a jam monitoring system with separator and sign-off sensor must also be provided for the 180° deflection.



Type		UL180/40-200		UL180/40-240		UL180/40-320	
		WT-200x200	WT-200x240	WT-240x240	WT-240x320	WT-320x320	WT-320x480
A	[mm]	7	7	7	14	14	14
B min.	[mm]	118	158	163	214	214	374
C	[mm]	12	12	12	19	19	19
D min.	[mm]	354	354	394	394	484	484

Drive*: Control of auxiliary drive via analog speed setpoint 0-10V and digital signal for running direction.

NOTES ON LAYOUT PROJECT PLANNING – TRANSVERSE DISCHARGE QA



NOTE

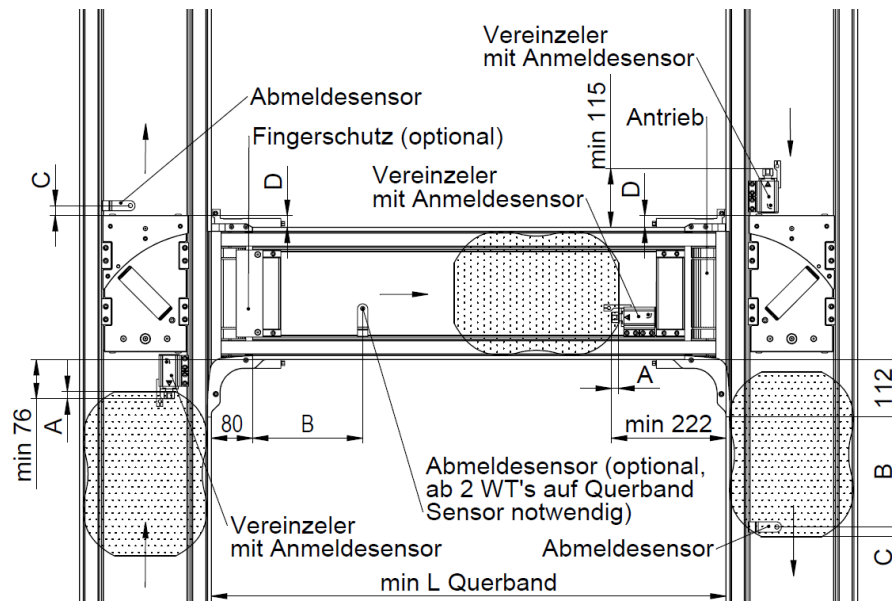
Positioning units (IV40, PV40, AV40) cannot be used on the transverse belt with transverse discharge.

Type		QA40-200x200	QA40-200x240	QA40-240x240	QA40-240x320	QA40-320x320	QA40-320x480
A	[mm]	7	7	7	14	14	14
B	[mm]	188	228	228	301	301	461
C	[mm]	12	12	12	19	19	19
D	[mm]	27.5	27.5	34.5	34.5	34.5	34.5

Minimum length of the transverse belt for a workpiece carrier: $\text{min L transverse belt} = \text{width workpiece carrier} + D + 222\text{mm}$

Minimum length of the transverse belt from 2 workpiece carriers: $\text{min L transverse belt} = \text{number workpiece carriers} \times \text{width workpiece carriers} + D + 222\text{mm}$

NOTES ON LAYOUT PROJECT PLANNING – WL/WR40 TRANSFER GATE

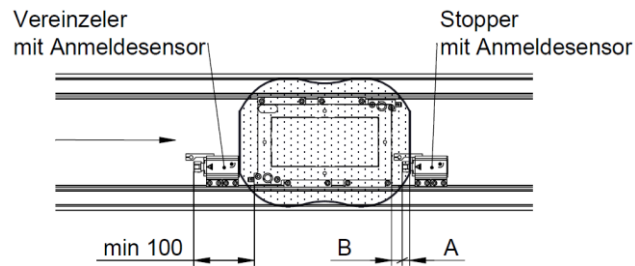


Type		WR40-200 / WL40-200		WR40-240 / WL40-240		WR40-320 / WL40-320	
		WT40-200x200	WT40-200x240	WT40-240x240	WT40-240x320	WT40-320x320	WT40-320x480
A	[mm]	7	7	7	14	14	14
B	[mm]	118	158	163	214	214	374
C	[mm]	12	12	12	19	19	19
D	[mm]	6.5	6.5	23	23	7	7

Minimum length of the transverse belt for a workpiece carrier: $\text{min L transverse belt} = \text{length workpiece carrier} + D + 222\text{mm}$

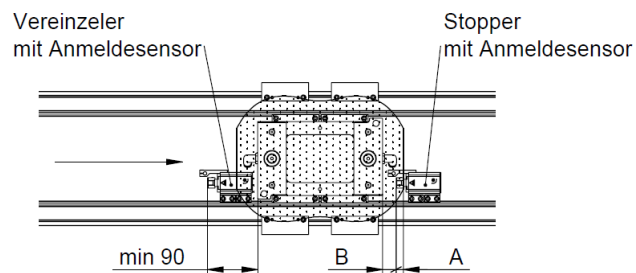
Minimum length of the transverse belt from 2 workpiece carriers: $\text{min L transverse belt} = \text{number workpiece carriers} \times \text{length workpiece carriers} + D + 222\text{mm}$

NOTES ON LAYOUT PROJECT PLANNING – INDEXING DEVICE IV40



Type		IV40-200x200	IV40-200x240	IV40-240x240	IV40-240x320	IV40-320x320	IV40-320x480
Item no.		65338	65341	65349	65347	65345	65343
A	[mm]	7	7	7	14	14	14
B	[mm]	20	20	27.5	20.5	20.5	20.5

NOTES ON LAYOUT PROJECT PLANNING – POSITIONING UNIT PV40



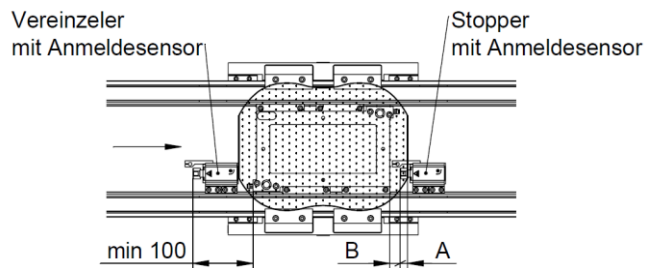
Type		PV40-200x200	PV40-200x240	PV40-240x240	PV40-240x320	PV40-320x320	PV40-320x480
Item no.		64358	64455	65227	64431	65228	64397
A	[mm]	7	7	7	14	14	14
B		20	20	27.5	20.5	20.5	20.5



NOTE

If several stations are arranged in series without a gap of at least one workpiece carrier length, the separator upstream of the station can be dispensed with. This applies to both the indexing device and the positioning unit.

NOTES ON LAYOUT PROJECT PLANNING – PLACING UNIT AV40



Type		AV40-200x200	AV40-200x240	AV40-240x240	AV40-240x320	AV40-320x320	AV40-320x480
Item no.		66260	66261	66262	66265	66264	66267
A	[mm]	7	7	7	14	14	14
B	[mm]	20	20	27.5	20.5	20.5	20.5



NOTE

If several stations are arranged in series without a gap of at least one workpiece carrier length, the separator upstream of the station can be dispensed with. This applies to both the indexing device and the positioning unit.

For the placing unit, mechanical processing is required in the conveyor strands of the conveyor. The position of the placing unit cannot therefore be changed subsequently without effort.

NOTES ON LAYOUT PROJECT PLANNING – PROTECTIVE COVERS

The transition cladding between two conveyors arranged in series must always be mounted. For freely accessible areas, finger guards and roller teeth covers must also always be provided. In areas where the system is operated exclusively behind the protective device, this can be dispensed with.

See conveyor accessories page 17.

