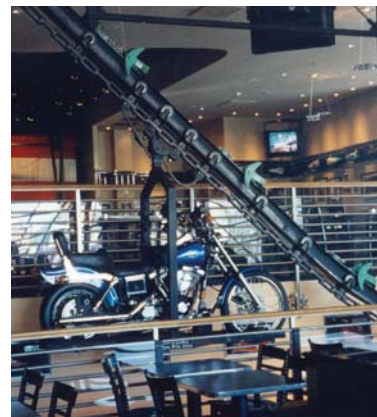


UNIBEAM™

Conveyor Components & Accessories



Why Unibeam?

The industry leader for I-beam conveyor systems since 1919

When the job calls for a tough, heavy-duty conveyor system, one name stands the test of time: Unibeam.

The Jervis B. Webb Company, a worldwide leader in material handling solutions and a subsidiary of Daifuku Co.,Ltd., helped revolutionize mass production in 1919 when founder Jervis B. Webb developed the forged rivetless chain conveyor for Ford Motor Company. Today, Webb's Unibeam conveyors remain the top choice for companies in all industries seeking a durable conveyor that delivers reliable results.

Webb also offers a complete line of quality, cost-effective 3" and 4" I-beam conveyor components and accessories. Whether you need a complete system or replacement parts for an existing conveyor, Webb and its wide network of channel partners stand behind the Unibeam brand.

Don't leave quality to chance. Choose Webb's Unibeam, the pioneer of heavy-duty conveyor systems and components.



Check out our quality Unibeam conveyor components including:

- Tracks made from C-1045 steel
- Trolleys forged from carbon steel and held together with a rugged two-bolt connection
- Traction wheels made with retainer plate to contain wheels
- Roller turns made with high carbon I-beam track and sealed-for-life rollers
- Drives that utilize rotary design and limit switch cut-off
- Take-ups with travel greater than 8"
- One piece oven expansion joints





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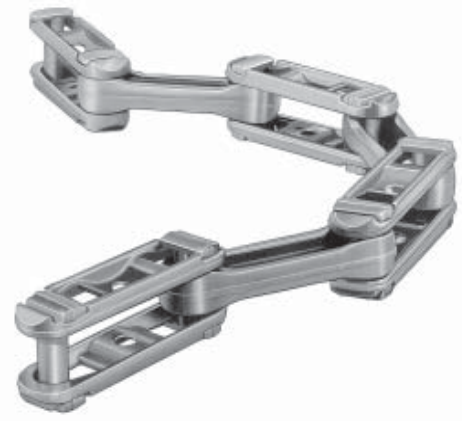
Rivetless Chain Features

Quality Forged - Years of service and thousands of installations demonstrate the success of Webb rivetless chain.

Chain components are drop-forged from high strength carbon steel, precision forged and finished. Webb rivetless chain provides the smoothest forged chain pin bearing surface in the industry, minimizing the initial break-in period.

Performance - Quality materials and construction minimize chain stretch and maximize service life.

All chain parts are hardened to increase resistance to wear, corrosion, abrasive action and shock loads.

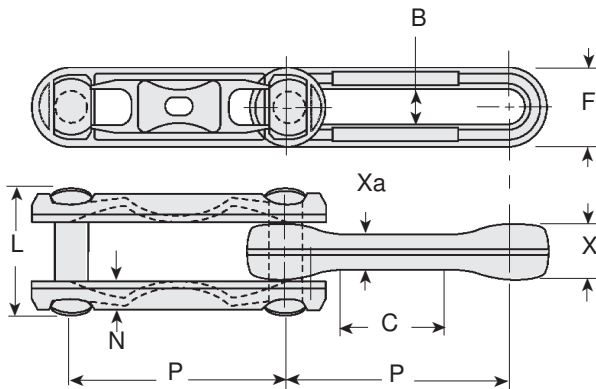


All chain can be magnafluxed upon request.

Rivetless chain is also available in AISI 8642 Alloy steel.

Custom plating can be provided on any size or style chain.

Other chain sizes are available.



Assembled Weight & Ultimate Strength

Chain	Part No.	Part No. Includes:		Assy Wt	Avg. Ult. Str.*
X-348	17447	4264..... Pin	LB	2.25	40,000 lb
		7605..... Side Link			
		7604..... Center Link	KG	1.02	18,144 kg
X-458	17449	13183..... Pin	LB	3.10	68,000 lb
		5098..... Side Link			
		5498..... Center Link	KG	1.40	30,845 kg
X-678	13443	13442..... Pin	LB	6.5	125,000 lb
		13440..... Side Link			
		13441..... Center Link	KG	2.94	56,700 kg

Legend

P.....Nominal pitch

X.....Height of center link

F.....Width of chain

Xa.....Height of chain at center of link

L.....Overall length of pin

D.....Diameter of pin

C.....Length of flat on center link

B.....Inside width of center link

N.....Thickness of side link

Chain Dimensions

Chain	Part No.	P	X	F Max.	Xa	L	D	C	B	N
X-348	17447	3"	3/4"	1-5/64"	1/2"	1-3/4"	1/2"	1-11/16"	17/32"	3/8"
X-458	17449	4"	1"	1-27/64"	5/8"	2-1/4"	5/8"	2"	21/32"	15/32"
X-678	13443	6"	1-9/32"	2"	27/32"	3-1/8"	7/8"	3-1/4"	31/32"	3/4"
METRIC										
X-348	17447	76	19	27	13	44	13	43	13	10
X-458	17449	102	25	36	16	57	16	51	17	12
X-678	13443	152	32	51	21	79	22	83	25	19

* Average ultimate strength values are arithmetical averages determined from current tensile test data.



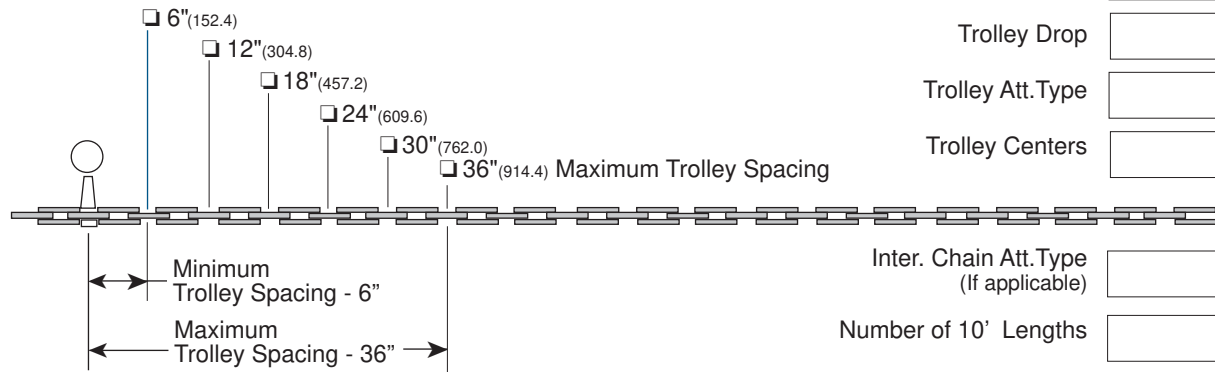
To Order a Chain Assembly:

Complete the information requested below.

Refer to section 1 for chain load ratings and intermediate chain attachments and sections 2 & 3 for trolley specifications and trolley attachments.

X-348 Chain: ☐ Quote ☐ Order

A 10' section has 40 Side Links and 20 Center Links



Trolley Size

Trolley Drop

Trolley Att.Type

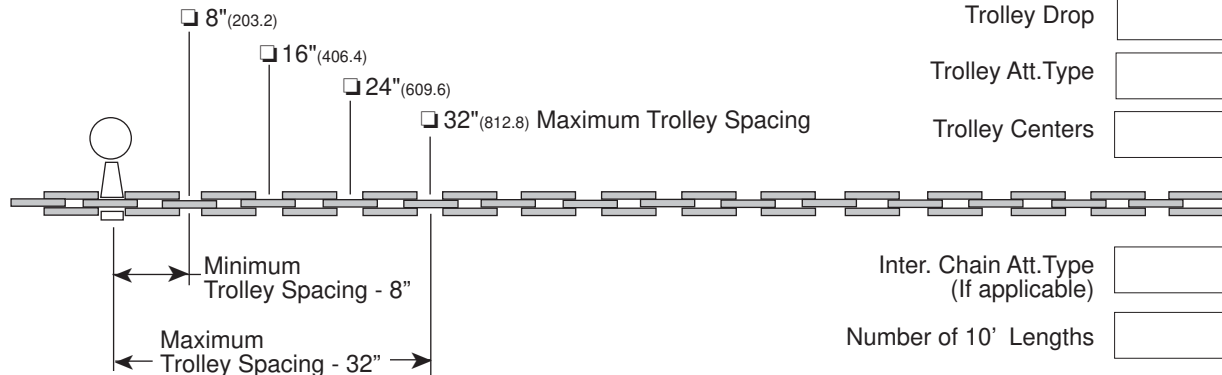
Trolley Centers

Inter. Chain Att.Type
(If applicable)

Number of 10' Lengths

X-458 Chain: ☐ Quote ☐ Order

A 10' section has 30 Side Links and 15 Center Links



Trolley Size

Trolley Drop

Trolley Att.Type

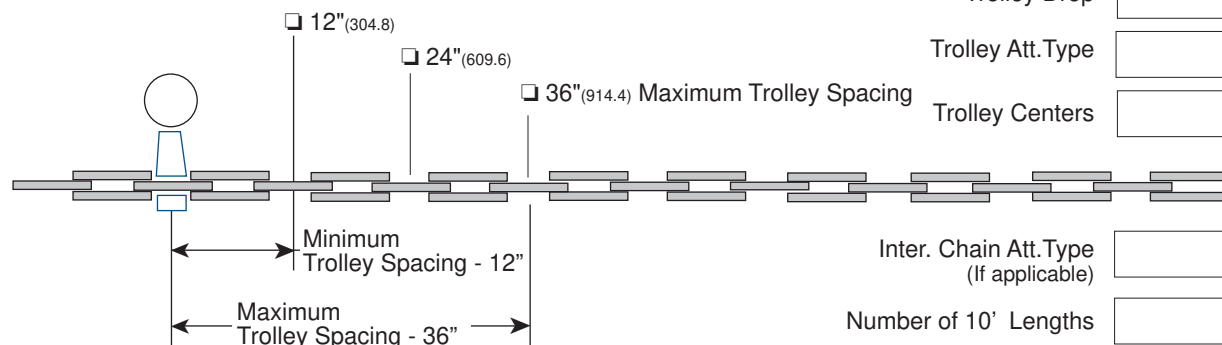
Trolley Centers

Inter. Chain Att.Type
(If applicable)

Number of 10' Lengths

X-678 Chain: ☐ Quote ☐ Order

A 10' section has 20 Side Links and 10 Center Links



Trolley Size

Trolley Drop

Trolley Att.Type

Trolley Centers

Inter. Chain Att.Type
(If applicable)

Number of 10' Lengths



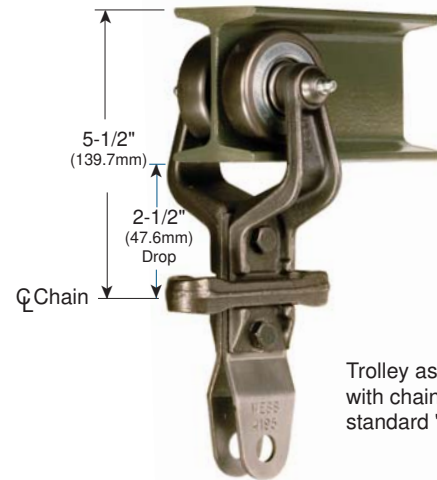
3" Trolley with 2-1/2" Drop

Chain size..... X-348
 Trolley Center Spacing 6" min. (152mm)
 36" max.(914mm)

Single Trolley Load Capacity 200lb (91kg)

Load Capacity W/Load Bar..... 400lb 181kg)

- Forged carbon steel brackets
- Standard triple labyrinth seal construction
- Rugged 2 bolt attachment connection
- Pressure type grease fittings
- Trolley wheels are riveted to the trolley bracket



Trolley assembly shown with chain center link and standard "H" attachment

Trolley Assembly Part No.	1/2 Trolley Bracket w/Full Complement Wheel	Bracket Bolts and Nuts	Inner Cap	Triple Labyrinth Seal
252086	14631	Included	Yes	Yes
252087	69600	Included	No	No
252088	75916	Included	Yes	No

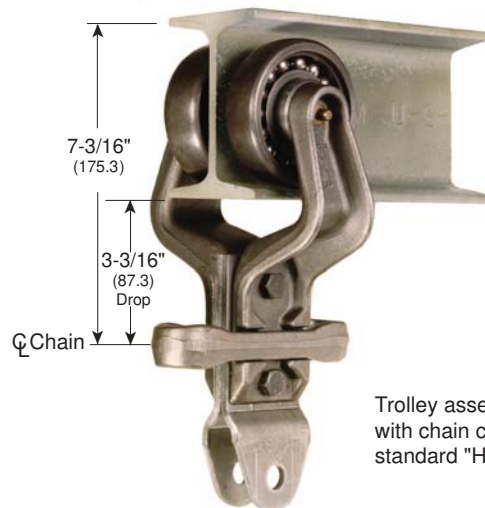
4" Trolley with 3-3/16" Drop

Chain Size X-458
 Trolley Center Spacing 8" min. (202)
 32" max. (813)

Single Trolley Load Capacity 400lb (181kg)

Load Capacity W/Load Bar..... 800lb (363kg)

- Forged carbon steel brackets
- Standard triple labyrinth seal construction
- Rugged 2 bolt attachment connection
- Pressure type grease fittings
- Trolley wheels are swaged to bracket
- Optional Red Seal Guard full contact high-temp (Viton) grease seal



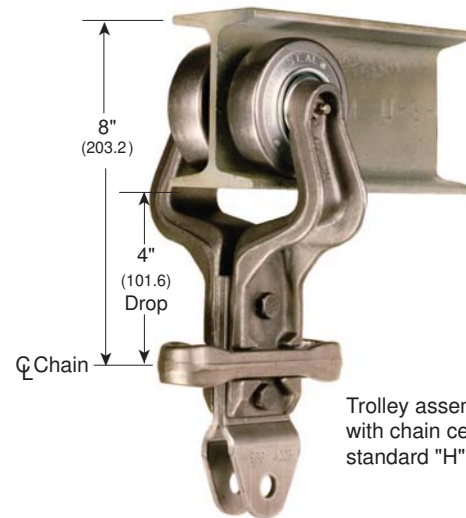
Trolley assembly shown with chain center link and standard "H" attachment

Trolley Assembly Part No.	1/2 Trolley Bracket w/Full Complement Wheel	Bracket Bolts and Nuts	Inner Cap	Triple Labyrinth Seal
252089	15308M1	Included	Yes	Yes
252090	15309	Included	No	No
252091	15308	Included	Yes	No



4" Trolley with 4" Drop

- Chain Size X-458
- Trolley Center Spacing 8" min. (203.2)
32" max. (812.8)
- Load Capacity..... 400lb (181kg)
- Load Capacity W/Load Bar..... 800lb (363kg)
- Forged carbon steel brackets
 - Standard triple labyrinth seal construction
 - Rugged 2 bolt attachment connection
 - Pressure type grease fittings
 - Trolley wheels are swaged to bracket
 - Optional Red Seal Guard full contact high-temp (Viton) grease seal

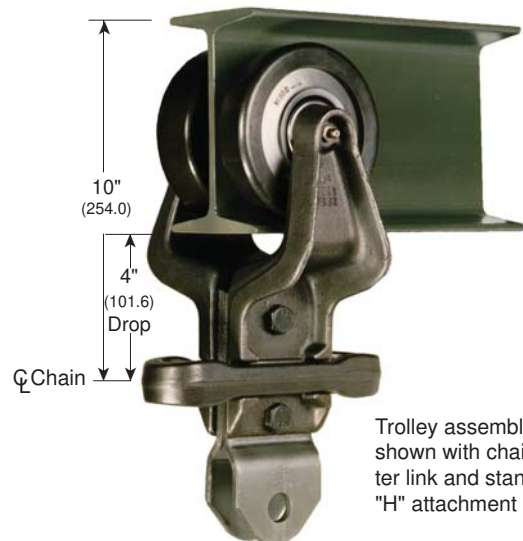


Trolley assembly shown with chain center link and standard "H" attachment

Trolley Assembly Part No.	1/2 Trolley Bracket w/Full Complement Wheel	Bracket Bolts and Nuts	Inner Cap	Triple Labyrinth Seal
252092	14282	Included	Yes	Yes
252093	86183	Included	No	No
252094	87858	Included	No	Yes

6" Trolley with 4" Drop

- Chain Size X-678
- Trolley Center Spacing 12" min. (304.8)
36" max. (914.4)
- Load Capacity..... 1,200lb (544kg)
- Load Capacity W/Load Bar..... 2,400lb (1088kg)
- Forged carbon steel brackets
 - Standard triple labyrinth seal construction
 - Rugged 2 bolt attachment connection
 - Pressure type grease fittings
 - Trolley wheels are swaged to the trolley bracket
 - Optional Red Seal Guard full contact high-temp (Viton) grease seal



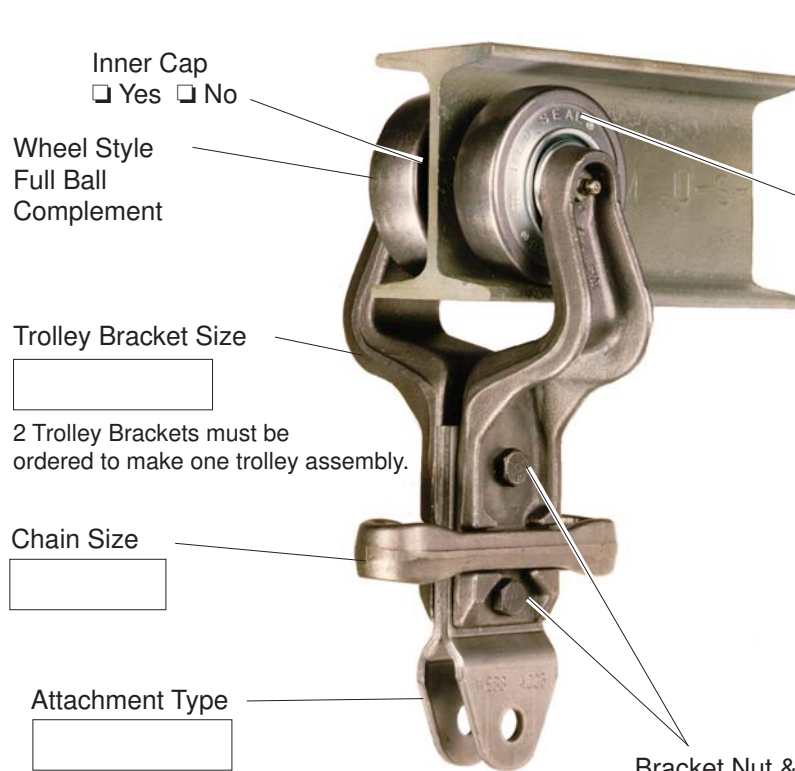
Trolley assembly shown with chain center link and standard "H" attachment

Trolley Assembly Part No.	1/2 Trolley Bracket w/Full Complement Wheel	Bracket Bolts and Nuts	Inner Cap	Triple Labyrinth Seal
252095	100504	Included	Yes	Yes
252096	100504M2	Included	No	No
252097	100504M1	Included	Yes	No



How to Order

Overhead Trolley Assembly



Inner Cap
☐ Yes ☐ No

Wheel Style
Full Ball
Complement

Trolley Bracket Size

2 Trolley Brackets must be ordered to make one trolley assembly.

Chain Size

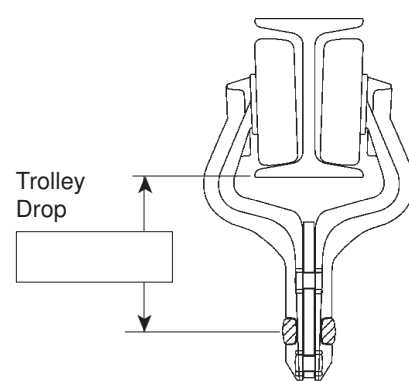
Attachment Type

"H" Attachment shown.
See section 2.4 - 2.5 for a complete trolley attachment listing

I-beam size

Optional Red Seal Guard & Full Contact Grease Seal ☐ Yes ☐ No

Bracket Nut & Bolt
2 Nut & Bolt assemblies must be ordered to make one Trolley assembly.

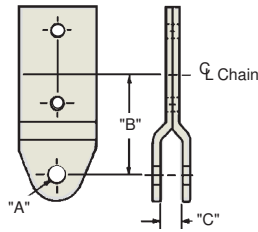


Trolley Drop



"H" Attachment:

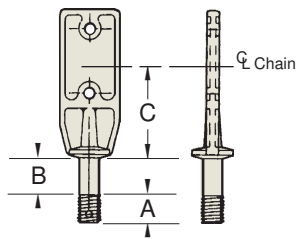
This is the most widely used type of trolley attachment. It consists of two pieces of formed steel and is suitable for suspending almost any type of hook, tray or rack.



Part No.	Chain	"A"	"B"	"C"
4195	3"	17/32"dia.	3 1/8"	9/16"
4223	4"	17/32"dia.	2 7/8"	11/16"
4246	6"	17/32"dia.	3 5/8"	13/16"

"B" Attachment:

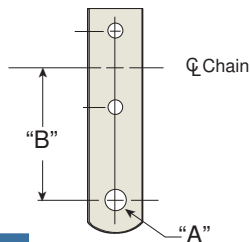
Normally used to support a load bar from a pair of trolleys but may also be used for many other applications. Attachment is steel forged with a threaded stud.



Part No.	Chain	"A"	"B"	"C"
4196	3"	1/2"	15/16"	2-7/16"
4221	4"	5/8"	1 1/4"	2-15/16"
241065	6"	1 3/8"	1 5/8"	3-1/8"

"C" Attachment

Used when a carrier design includes a clevis. It can also be used with a bent rod hook to carry light parts.

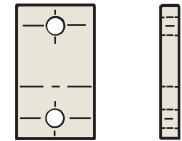


Part No.	Chain	"A"	"B"
4193	3"	17/32"dia	3 1/8"
4222	4"	9/16"dia	2 7/8"
4245	6"	13/16"dia	2 5/8"

"I" Attachment:

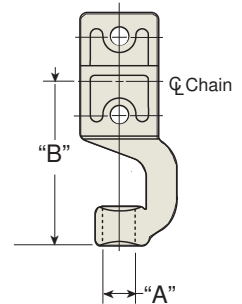
This attachment is used as a filler on intermediate trolleys that do not carry a load.

Part No.	Chain
4194	3"
4224	4"
4247	6"



15579 "J" Attachment

Used for suspending 5/8" diameter rods permitting periodic rotation of rod carriers.



Part No.	Chain	"A"	"B"
15579	4"	41/64"dia	4 5/16"

Bracket Bolt and Nut:

High strength bolts are secured with locknut and fused with high-strength two part epoxy.

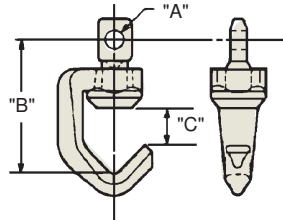


Bolt		Nut	
Part No.	Chain	Part No.	Chain
13434	3"	57212	3"
11979	4"	56494	4"
13464	6"	56495	6"



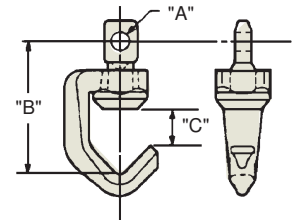
Many applications require a hook that permits rotating the item carried by the conveyor.

Indexing Swivel Hook Assembly



Part No.	Chain	Cap.	"A"	"B"	"C"
252104	3"/4"	125 lb	17/32"dia.	4 1/8"	1 1/4"
252102	4"/6"	200 lb	41/64"dia.	5 1/2"	1 7/8"

Non-Indexing Swivel Hook Assembly

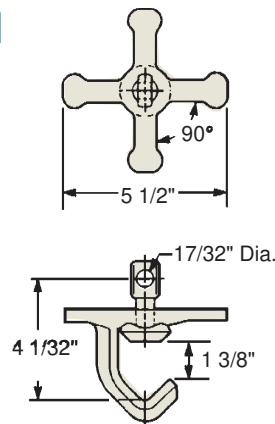


Part No.	Chain	Cap.	"A"	"B"	"C"
252099	3"/4"	125 lb	17/32"dia.	3 15/16"	1 1/4"

Star Wheel Swivel Hook Assembly

125 pound capacity rating and is used with "H" attachments.

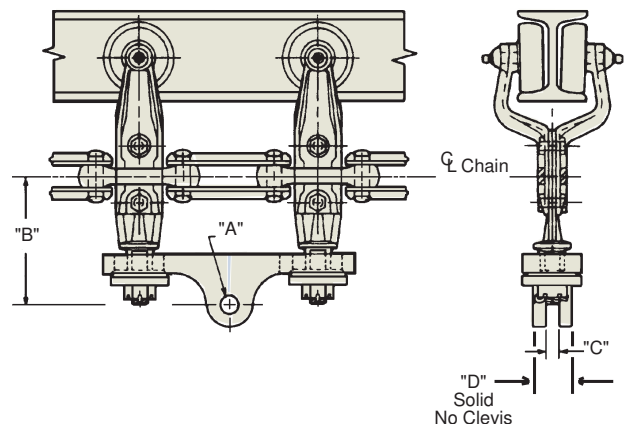
Part No.	Chain
252101	3"
252101	4"



Load Bar Assembly

Use of this load bar permits pairing of trolleys and thereby doubles their weight carrying capacity. "B" attachments are used to suspend the load bar from two trolleys.

Part No.	Chain	Cap.	"A"	"B"	"C"	"D"
252098	3"	400 lb	9/16"dia.	4 1/4"	9/16"	—
252105	4"	800 lb	11/16"dia.	4 7/8"	11/16"	—
252103	6"	2400lb	25/32"	5 5/8"	—	2 3/8"



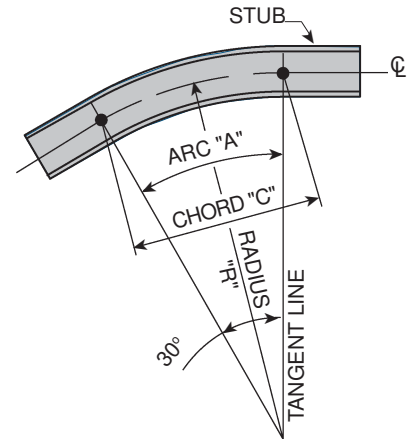


Single Vertical Curves (SVC)

These curves are used to make the upper and lower parts of reverse and compound vertical curves.

Standard Single Vertical Curves

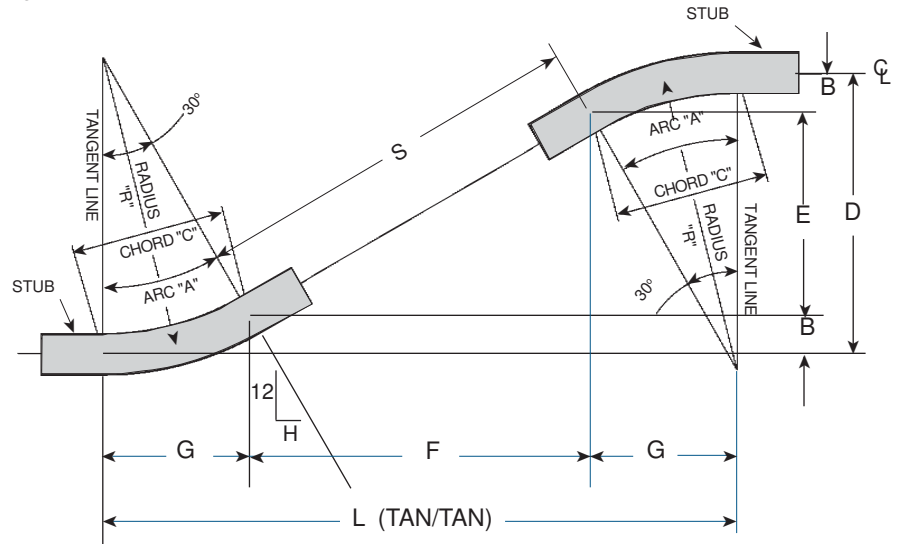
Part No.	I Beam	Angle	Radius	A	C	Stub
17699	3"	30°	96"	49 1/2"	48 15/16"	18 3/8"
17700	3"	45°	96"	74 1/4"	72 5/16"	22 5/16"
102253	4"	30°	96"	49 3/16"	48 11/16"	24"
102254	4"	45°	96"	73 13/16"	71 15/16"	24"
102255	4"	30°	120"	61 13/16"	61 1/16"	24"
102256	4"	45°	120"	92 11/16"	90 5/16"	24"



Single bend, reverse & compound vertical curve assemblies can be custom built to suit customer needs. Contact Webb Sales for availability and delivery.

Compound Vertical Curves

These curves consist of two single vertical curves and the necessary connecting straight track assembled to accomplish a change in elevation.



- D Overall change in elevation of vertical curve assembly.
- L Overall length of vertical curve assembly - tangent to tangent.
- A True length of any single bend at centerline of track.
- C Straight length across any single bend at centerline - workpoint to workpoint.
- B Height or vertical change in elevation of any single bend.
- G Horizontal length of any single bend.
- H Run length of curve angle.
- S Section of track connecting two single bends to create a compound vertical curve.
- E Height or vertical change in elevation of straight section.
- F Horizontal length of straight section.

Recommended (Rec.) Vertical Curves Based on Trolley Spacing

Trolley Spacing	3" System Min	3" System Rec.	4" System Min	4" System Rec.
8"	-	-	3'-6"	6'-0"
12"	4'-0"	5'-0"	-	-
16"	-	-	5'-6"	8'-0"
18"	5'-0"	6'-6"	-	-
24"	6'-6"	8'-0"	7'-0"	10'-0"
30"	7'-8"	10'-0"	-	-
32"	-	-	9'-0"	12'-0"
36"	9'-0"	12'-0"	-	-



Compound Vertical Curve Chart

UNIBEAM

8' Radius (2.34m)

Angle - 30°

Arc - 4' 2-1/4" (1.28m)

Chord - 4' 1-11/16" (1.26m)

When ordering vertical curves you must specify:

- Radius
- Vertical Drop
- Degree of Turn
- I-Beam Size

INCH				METRIC			
Vertical Drop	Straight Track	True Length	Tan/Tan Length	Vertical Drop	Straight Track	True Length	Tan/Tan Length
26.00	0.56	101.06	96.50	660.40	14.29	2566.99	2451.10
27.00	2.56	103.06	98.19	685.80	65.09	2617.79	2493.96
28.00	4.56	105.06	99.94	711.20	115.89	2668.59	2538.41
29.00	6.56	107.06	101.69	736.60	166.69	2719.39	2582.86
30.00	8.56	109.06	103.44	762.00	217.49	2770.19	2627.31
31.00	10.56	111.06	105.13	787.40	268.29	2820.99	2670.18
32.00	12.56	113.06	106.88	812.80	319.09	2871.79	2714.63
33.00	14.56	115.06	108.63	838.20	369.89	2922.59	2759.08
34.00	16.56	117.06	110.31	863.60	420.69	2973.39	2801.94
35.00	18.56	119.06	112.06	889.00	471.49	3024.19	2846.39
36.00	20.56	121.06	113.19	914.40	522.29	3074.99	2874.96
37.00	22.56	123.06	115.56	939.80	573.09	3125.79	2935.29
38.00	24.56	125.06	117.25	965.20	623.89	3176.59	2978.15
39.00	26.56	127.06	119.00	990.60	674.69	3227.39	3022.60
40.00	28.56	129.06	120.75	1016.00	725.49	3278.19	3067.05
41.00	30.56	131.06	122.44	1041.40	776.29	3328.99	3109.91
42.00	32.56	133.06	124.19	1066.80	827.09	3379.79	3154.36
43.00	34.56	135.06	125.94	1092.20	877.89	3430.59	3198.81
44.00	36.56	137.06	127.69	1117.60	928.69	3481.39	3243.26
45.00	38.56	139.06	129.38	1143.00	979.49	3532.19	3286.13
46.00	40.56	141.06	131.13	1168.40	1030.29	3582.99	3330.58
47.00	42.56	143.06	132.88	1193.80	1081.09	3633.79	3375.03
48.00	44.56	145.06	134.56	1219.20	1131.89	3684.59	3417.89
49.00	46.56	147.06	136.31	1244.60	1182.69	3735.39	3462.34
50.00	48.56	149.06	138.06	1270.00	1233.42	3786.12	3506.79
51.00	50.56	151.06	139.75	1295.40	1284.22	3836.92	3549.65
52.00	52.56	153.06	141.50	1320.80	1335.02	3887.72	3594.10
53.00	54.56	155.06	143.25	1346.20	1385.82	3938.52	3638.55
54.00	56.56	157.06	145.00	1371.60	1436.62	3989.32	3683.00
55.00	58.56	159.06	146.69	1397.00	1487.42	4040.12	3725.86
56.00	60.56	161.06	148.44	1422.40	1538.22	4090.92	3770.31
57.00	62.56	163.06	150.19	1447.80	1589.02	4141.72	3814.76
58.00	64.56	165.06	151.88	1473.20	1639.82	4192.52	3857.63
59.00	66.56	167.06	153.63	1498.60	1690.62	4243.32	3902.08
60.00	68.56	169.06	155.38	1524.00	1741.42	4294.12	3946.53
61.00	70.56	171.06	157.13	1549.40	1792.22	4344.92	3990.98
62.00	72.56	173.06	158.81	1574.80	1843.02	4395.72	4033.84
63.00	74.56	175.06	160.56	1600.20	1893.82	4446.52	4078.29
64.00	76.56	177.06	162.31	1625.60	1944.62	4497.32	4122.74
65.00	78.56	179.06	164.00	1651.00	1995.42	4548.12	4165.60
66.00	80.56	181.06	165.75	1676.40	2046.22	4598.92	4210.05
67.00	82.56	183.06	167.50	1701.80	2097.02	4649.72	4254.50
68.00	84.56	185.06	169.25	1727.20	2147.82	4700.52	4298.95
69.00	86.56	187.06	170.94	1752.60	2198.62	4751.32	4341.81
70.00	88.56	189.06	172.69	1778.00	2249.42	4802.12	4386.26
71.00	90.56	191.06	174.44	1803.40	2300.22	4852.92	4430.71
72.00	92.56	193.06	176.13	1828.80	2351.02	4903.72	4473.58
73.00	94.56	195.06	177.88	1854.20	2401.82	4954.52	4518.03



Compound Vertical Curve Chart

UNIBEAM

8' Radius (2.34m)

Angle - 30°

Arc - 4' 2-1/4" (1.28m)

Chord - 4' 1-11/16" (1.26m)

When ordering vertical curves you must specify:

- Radius
- Vertical Drop
- Degree of Turn
- I-Beam Size

INCH				METRIC			
Vertical Drop	Straight Track	True Length	Tan/Tan Length	Vertical Drop	Straight Track	True Length	Tan/Tan Length
74.00	96.56	197.06	179.63	1879.60	2452.62	5005.32	4562.48
75.00	98.56	199.06	181.38	1905.00	2503.42	5056.12	4606.93
76.00	100.56	201.06	183.06	1930.40	2554.22	5106.92	4649.79
77.00	102.56	203.06	184.81	1955.80	2605.02	5157.72	4694.24
78.00	104.56	205.06	186.56	1981.20	2655.82	5208.52	4738.69
79.00	106.56	207.06	188.25	2006.60	2706.62	5259.32	4781.55
80.00	108.56	209.06	190.00	2032.00	2757.42	5310.12	4826.00
81.00	110.56	211.06	191.75	2057.40	2808.22	5360.92	4870.45
82.00	112.56	213.06	193.50	2082.80	2859.02	5411.72	4914.90
83.00	114.56	215.06	195.19	2108.20	2909.82	5462.52	4957.76
84.00	116.56	217.06	196.94	2133.60	2960.62	5513.32	5002.21
85.00	118.56	219.06	198.69	2159.00	3011.42	5564.12	5046.66
86.00	120.56	221.06	200.38	2184.40	3062.22	5614.92	5089.53
87.00	122.56	223.06	202.13	2209.80	3113.02	5665.72	5133.98
88.00	124.56	225.06	203.88	2235.20	3163.82	5716.52	5178.43
89.00	126.56	227.06	205.63	2260.60	3214.62	5767.32	5222.88
90.00	128.56	229.06	207.31	2286.00	3265.42	5818.12	5265.74
91.00	130.56	231.06	209.06	2311.40	3316.22	5868.92	5310.19
92.00	132.56	233.06	210.81	2336.80	3367.02	5919.72	5354.64
93.00	134.56	235.06	212.50	2362.20	3417.82	5970.52	5397.50
94.00	136.56	237.06	214.25	2387.60	3468.62	6021.32	5441.95
95.00	138.56	239.06	216.00	2413.00	3519.42	6072.12	5486.40
96.00	140.56	241.06	217.75	2438.40	3570.22	6122.92	5530.85
97.00	142.56	243.06	219.44	2463.80	3621.02	6173.72	5573.71
98.00	144.56	245.06	221.19	2489.20	3671.82	6224.52	5618.16
99.00	146.56	247.06	222.94	2514.60	3722.62	6275.32	5662.61
100.00	148.56	249.06	224.63	2540.00	3773.42	6326.12	5705.48
101.00	150.56	251.06	226.38	2565.40	3824.22	6376.92	5749.93
102.00	152.56	253.06	228.13	2590.80	3875.02	6427.72	5794.38
103.00	154.56	255.06	229.88	2616.20	3925.82	6478.52	5838.83
104.00	156.56	257.06	231.56	2641.60	3976.62	6529.32	5881.69
105.00	158.56	259.06	233.31	2667.00	4027.42	6580.12	5926.14
106.00	160.56	261.06	235.06	2692.40	4078.22	6630.92	5970.59
107.00	162.56	263.06	236.75	2717.80	4129.02	6681.72	6013.45
108.00	164.56	265.06	238.50	2743.20	4179.82	6732.52	6057.90
109.00	166.56	267.06	240.25	2768.60	4230.62	6783.32	6102.35
110.00	168.56	269.06	242.00	2794.00	4281.42	6834.12	6146.80
111.00	170.56	271.06	243.69	2819.40	4332.22	6884.92	6189.66
112.00	172.56	273.06	245.44	2844.80	4383.02	6935.72	6234.11
113.00	174.56	275.06	247.19	2870.20	4433.82	6986.52	6278.56
114.00	176.56	277.06	248.88	2895.60	4484.62	7037.32	6321.43
115.00	178.56	279.06	250.63	2921.00	4535.42	7088.12	6366.00
116.00	180.56	281.06	252.38	2946.40	4586.22	7138.92	6410.45
117.00	182.56	283.06	254.13	2971.80	4637.02	7189.72	6454.90
118.00	184.56	285.06	255.81	2997.20	4687.82	7240.52	6497.57
119.00	186.56	287.06	257.56	3022.60	4738.62	7291.32	6542.09
120.00	188.56	289.06	259.31	3048.00	4789.42	7342.12	6586.47



Compound Vertical Curve Chart

UNIBEAM

10' Radius (3.05m)

Angle - 30°

Arc - 5' 2-13/16" (1.60m)

Chord - 5' 2-1/8" (1.58m)

When ordering vertical curves you must specify:

- Radius
- Vertical Drop
- Degree of Turn
- I-Beam Size

INCH				METRIC			
Vertical Drop	Straight Track	True Length	Tan/Tan Length	Vertical Drop	Straight Track	True Length	Tan/Tan Length
32.00	0.19	125.88	120.19	812.80	4.76	3197.23	3052.76
33.00	1.69	127.38	121.44	838.20	42.86	3235.33	3084.51
34.00	3.69	129.38	123.19	863.60	93.66	3286.13	3128.96
35.00	5.69	131.38	124.94	889.00	144.46	3336.93	3173.41
36.00	7.69	133.38	126.69	914.40	195.26	3387.73	3217.86
37.00	9.69	135.38	128.38	939.80	246.06	3438.65	3260.73
38.00	11.69	137.38	130.13	965.20	296.93	3489.45	3305.18
39.00	13.69	139.38	131.88	990.60	347.73	3540.25	3349.63
40.00	15.69	141.38	133.56	1016.00	398.53	3591.05	3392.49
41.00	17.69	143.38	135.31	1041.40	449.33	3641.85	3436.94
42.00	19.69	145.38	137.06	1066.80	500.13	3692.65	3481.39
43.00	21.69	147.38	138.81	1092.20	550.93	3743.45	3525.84
44.00	23.69	149.38	140.50	1117.60	601.73	3794.25	3568.70
45.00	25.69	151.38	142.25	1143.00	652.53	3845.05	3613.15
46.00	27.69	153.38	144.00	1168.40	703.33	3895.85	3657.60
47.00	29.69	155.38	145.69	1193.80	754.13	3946.65	3700.46
48.00	31.69	157.38	147.44	1219.20	804.86	3997.45	3744.91
49.00	33.69	159.38	149.19	1244.60	855.73	4048.25	3789.36
50.00	35.69	161.38	150.94	1270.00	906.53	4099.05	3833.81
51.00	37.69	163.38	152.63	1295.40	957.33	4149.85	3876.68
52.00	39.69	165.38	154.38	1320.80	1008.13	4200.65	3921.13
53.00	41.69	167.38	156.13	1346.20	1058.93	4251.45	3965.58
54.00	43.69	169.38	157.81	1371.60	1109.73	4302.25	4008.44
55.00	45.69	171.38	159.56	1397.00	1160.53	4353.05	4052.89
56.00	47.69	173.38	161.31	1422.40	1211.33	4403.85	4097.34
57.00	49.69	175.38	163.06	1447.80	1262.13	4454.65	4141.79
58.00	51.69	177.38	164.75	1473.20	1312.93	4505.45	4184.65
59.00	53.69	179.38	166.50	1498.60	1363.73	4556.25	4229.10
60.00	55.69	181.38	168.25	1524.00	1414.53	4607.05	4273.55
61.00	57.69	183.38	169.94	1549.40	1465.33	4657.85	4316.41
62.00	59.69	185.38	171.69	1574.80	1516.13	4708.65	4360.86
63.00	61.69	187.38	173.44	1600.20	1566.93	4759.45	4405.31
64.00	63.69	189.38	175.19	1625.60	1617.73	4810.25	4449.76
65.00	65.69	191.38	176.88	1651.00	1668.53	4861.05	4492.63
66.00	67.69	193.38	178.63	1676.40	1719.33	4911.85	4537.08
67.00	69.69	195.38	180.38	1701.80	1770.13	4962.65	4581.53
68.00	71.69	197.38	182.06	1727.20	1820.93	5013.45	4624.39
69.00	73.69	199.38	183.81	1752.60	1871.73	5064.25	4668.84
70.00	75.69	201.38	185.56	1778.00	1922.53	5115.05	4713.29
71.00	77.69	203.38	187.31	1803.40	1973.33	5165.85	4757.74
72.00	79.69	205.38	189.00	1828.80	2024.13	5216.65	4800.60
73.00	81.69	207.38	190.75	1854.20	2074.93	5267.45	4845.05
74.00	83.69	209.38	192.50	1879.60	2125.73	5318.25	4889.50
75.00	85.69	211.38	194.19	1905.00	2176.53	5369.05	4932.36
76.00	87.69	213.38	195.94	1930.40	2227.33	5419.85	4976.81



Compound Vertical Curve Chart

UNIBEAM

10' Radius (3.05m)

Angle - 30°

Arc - 5' 2-13/16" (1.60m)

Chord - 5' 2-1/8" (1.59m)

When ordering vertical curves you must specify:

- Radius
- Vertical Drop
- Degree of Turn
- I-Beam Size

INCH				METRIC			
Vertical Drop	Straight Track	True Length	Tan/Tan Length	Vertical Drop	Straight Track	True Length	Tan/Tan Length
77.00	89.69	215.38	197.69	1955.80	2278.13	5470.65	5021.26
78.00	91.69	217.38	199.44	1981.20	2328.93	5521.45	5065.71
79.00	93.69	219.38	201.13	2006.60	2379.73	5572.25	5108.58
80.00	95.69	221.38	202.88	2032.00	2430.53	5623.05	5153.03
81.00	97.69	223.38	204.63	2057.40	2481.33	5673.85	5197.48
82.00	99.69	225.38	206.31	2082.80	2532.13	5724.65	5240.34
83.00	101.69	227.38	208.06	2108.20	2582.93	5775.45	5284.79
84.00	103.69	229.38	209.81	2133.60	2633.73	5826.25	5329.24
85.00	105.69	231.38	211.56	2159.00	2684.53	5877.05	5373.69
86.00	107.69	233.38	213.25	2184.40	2735.33	5927.85	5416.55
87.00	109.69	235.38	215.00	2209.80	2786.13	5978.65	5461.00
88.00	111.69	237.38	216.75	2235.20	2836.93	6029.45	5505.45
89.00	113.69	239.38	218.44	2260.60	2887.73	6080.25	5548.31
90.00	115.69	241.38	220.19	2286.00	2938.53	6131.05	5592.76
91.00	117.69	243.38	221.94	2311.40	2989.33	6181.85	5637.21
92.00	119.69	245.38	223.69	2336.80	3040.13	6232.65	5681.66
93.00	121.69	247.38	225.38	2362.20	3090.93	6283.45	5724.53
94.00	123.69	249.38	227.13	2387.60	3141.73	6334.25	5768.98
95.00	125.69	251.38	228.88	2413.00	3192.53	6385.05	5813.43
96.00	127.69	253.38	230.56	2438.40	3243.33	6435.85	5856.29
97.00	129.69	255.38	232.31	2463.80	3294.13	6486.65	5900.74
98.00	131.69	257.38	234.06	2489.20	3344.93	6537.45	5945.19
99.00	133.69	259.38	235.75	2514.60	3395.73	6588.25	5988.05
100.00	135.69	261.38	237.50	2540.00	3446.53	6639.05	6032.50
101.00	137.69	263.38	239.25	2565.40	3497.33	6689.85	6076.95
102.00	139.69	265.38	241.00	2590.80	3548.13	6740.65	6121.40
103.00	141.69	267.38	242.69	2616.20	3598.93	6791.45	6164.26
104.00	143.69	269.38	244.44	2641.60	3649.73	6842.25	6208.71
105.00	145.69	271.38	246.19	2667.00	3700.53	6893.05	6253.16
106.00	147.69	273.38	247.88	2692.40	3751.33	6943.85	6296.03
107.00	149.69	275.38	249.63	2717.80	3802.13	6994.65	6340.48
108.00	151.69	277.38	251.38	2743.20	3852.93	7045.33	6384.93
109.00	153.69	279.38	253.13	2768.60	3903.73	7096.25	6429.38
110.00	155.69	281.38	254.81	2794.00	3954.53	7147.05	6472.24
111.00	157.69	283.38	256.56	2819.40	4005.33	7197.85	6516.69
112.00	159.69	285.38	258.31	2844.80	4056.13	7248.65	6561.14
113.00	161.69	287.38	260.00	2870.20	4106.93	7299.45	6604.00
114.00	163.69	289.38	261.75	2895.60	4157.73	7350.25	6648.45
115.00	165.69	291.38	263.50	2921.00	4208.53	7401.05	6692.90
116.00	167.69	293.38	265.25	2946.40	4259.33	7451.85	6737.35
117.00	169.69	295.38	266.94	2971.80	4310.13	7502.65	6780.21
118.00	171.69	297.38	268.69	2997.20	4360.93	7553.45	6824.66
119.00	173.69	299.38	270.44	3022.60	4411.73	7604.25	6869.11
120.00	175.69	301.38	272.13	3048.00	4462.53	7655.05	6911.98



High Carbon Steel Track

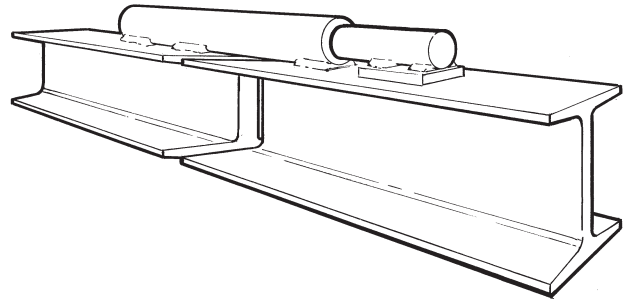
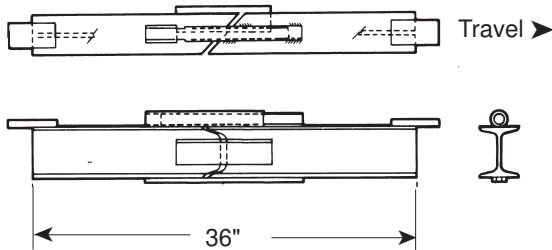
The I-beam track must sustain the entire load carried on an overhead trolley conveyor. To assure longer wear-life and greater strength characteristics, the Jervis B. Webb Company supplies I-beams of special high-carbon C-1045 steel in standard structural sections.

	3"	4"
I-beam @ 20 ft. long (unpainted mill ends)	18264	18266
I-beam @ 20 ft. long (ends squared and painted)	102263	102264



Expansion Joints

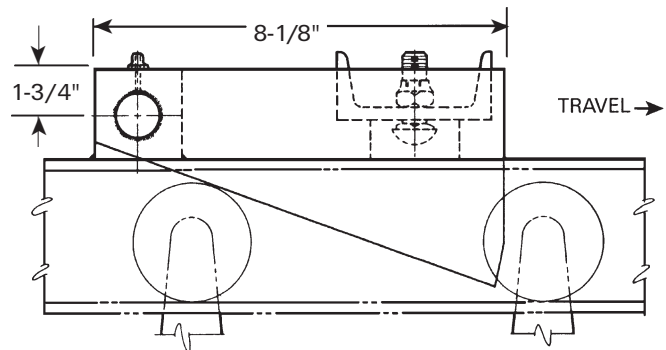
	3"	4"
Oven Expansion Joint, (36" lg.)	14174 3/8" Travel	139999 1/2" Travel



Anti-Backup

	3"	4"
Anti-Backup	8704	8702

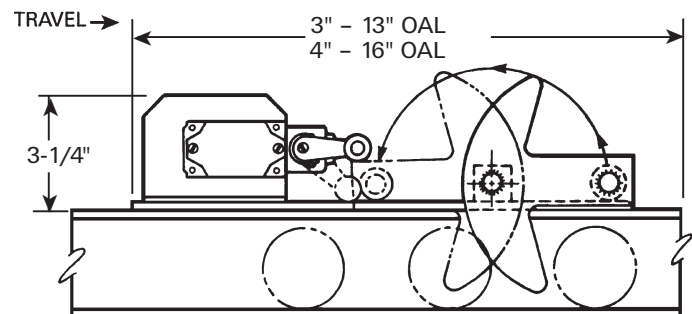
To prevent reverse conveyor travel caused by chain breakage, this anti-backup device is installed on vertical curves.



Anti-Runaway

	3"	4"
Anti-Runaway (less Limit Switch)	10717	101878
Anti-Runaway (with Limit Switch)	16787	101879

If the chain should break and begin to travel faster than normal down vertical curves, this anti-runaway device will be activated which will stop the conveyor chain. The drive motor is stopped when the limit switch is actuated by the safety device.





Traction Wheel Turn Features

This type of turn is designed to keep the power chain & trolleys in proper alignment when negotiating horizontal turns. They are available in 30°, 45°, 60°, 90° and 180° increments. Custom radii and curve increments can be fabricated upon request.

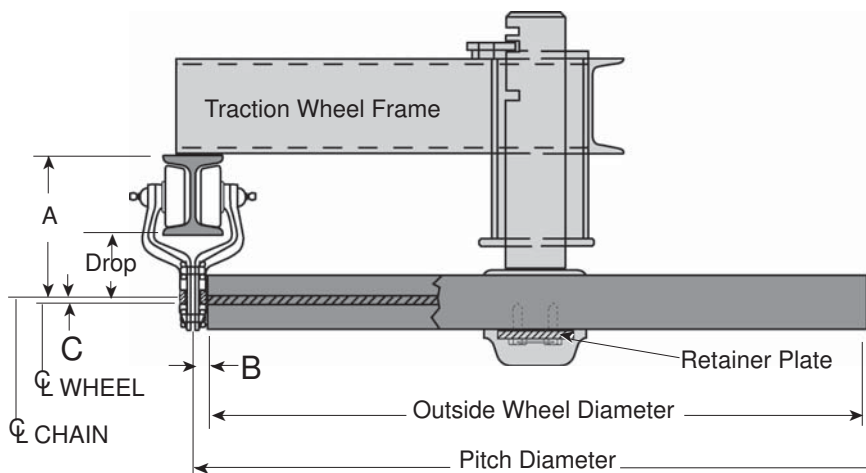
All traction wheel turns are constructed with a separate mounting frame from which both the conveyor track and the traction wheel shaft mounts are supported. All turns are made of solid plate construction for diameters up to 48" (1219.2). For diameters over 48" (1219.2) a spoke type construction is used.

Although more expensive than roller turns, traction wheels require less maintenance, provide smoother operation at higher conveyor speeds, reduce chain pull, and reduce chain wear. Roller bearing traction wheels have a single lubrication point for easy maintenance. Carbon bushed hubs are available for use in environments exceeding 270°F. Traction wheel turns are best suited for dirty, corrosive or high temperature applications.



Minimum Recommended Traction Wheel Diameters

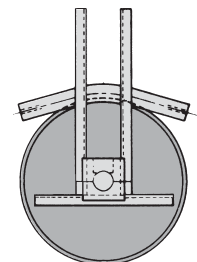
Chain Size	Recommended Trolley Spacing	Traction Wheel Dia.	Roller Turn Radius
X-348	up to 18" 24" 30"	24"	18"
		30"	18"
		36"	18"
X-458	up to 24" 32"	30"	24"
		36"	24"



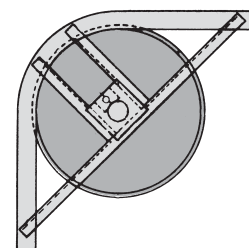
Traction Wheel Dimensions

Chain & Rail	A	B	C	Chain Drop	Plate Size	Spoke Type
3" I-beam / X348	5-1/2"	1/2"	-	2-1/2"	24" to 48"	Over 48" 1219.2
4" I-beam / X458	7-3/16"	11/16"	5/16"	3-3/16"		
4" I-beam / X458	8"	11/16"	5/16"	4"		

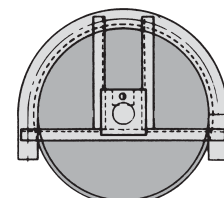
30°, 45° & 60° Turns



90° Turn



180° Turn



Special sizes and types of traction wheel turns can be furnished upon request.



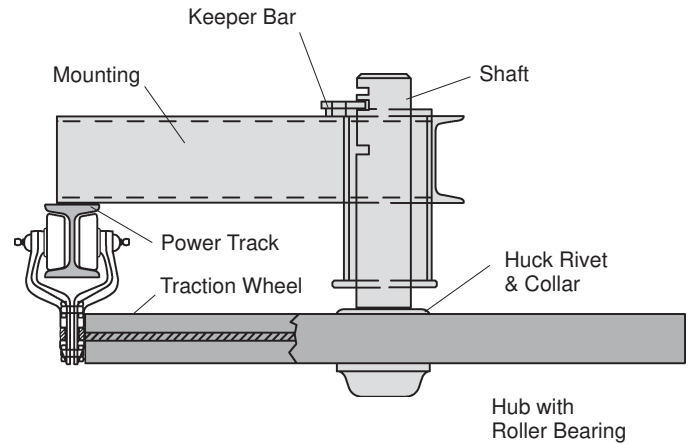
Two Bearing Styles

To cover a wide range of application requirements, traction wheels are available with either anti-friction roller bearings for normal room temperatures or carbon bushed bearings for use in ovens with temperatures up to 450°F (232.2°C).

Two ample size roller bearings are pressed into machined recesses in the traction wheel hub, and are lubricated through the hub cap. These bearings have a large storage space for lubricant that extends the time interval between required maintenance lubrications.

Bearings are protected against entrance of dirt or loss of lubricant by adequate seals. When properly lubricated, tapered roller bearing hubs will operate efficiently in temperatures up to 270°F (132.2°C).

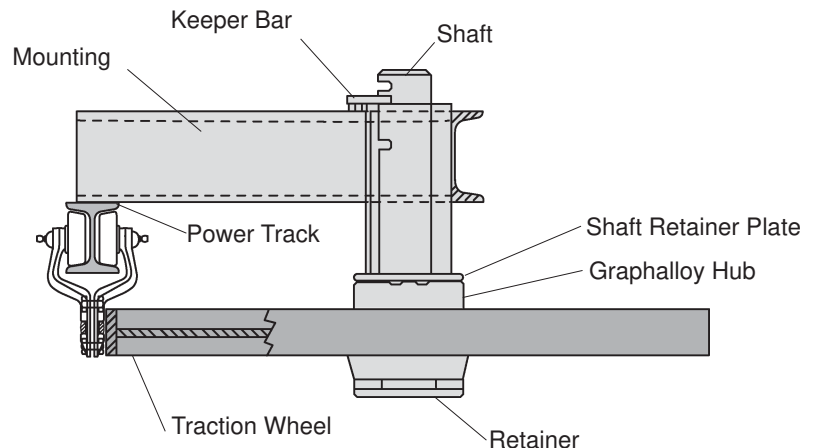
A removable shaft cast block type hub with tapered roller bearings is also available.



Webb Roller Bearing Hub

Carbon Bushed Bearing

The heavy walled, carbon bushings successfully resist temperatures up to 450°F (232.2°C) with no lubrication required, as graphite is a natural lubricant. Carbon bushed bearings are not recommended for applications below 270°F (132.2°C).



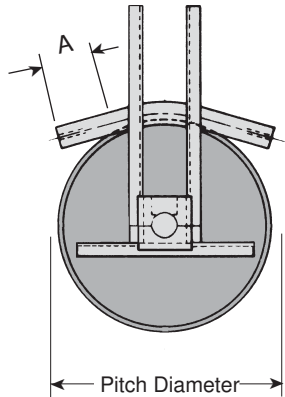


X348 Chain

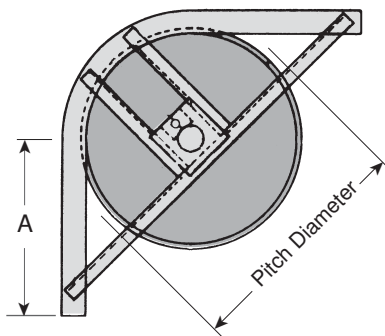
3" I-beam (76.2mm)

2-1/2" Drop (63.5mm)

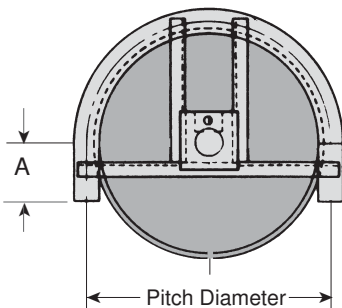
30°, 45° & 60° Turns



90° Turn



180° Turn



Pitch Diameter		Degree	Part No. Roller	Part No. Carbon	Weight Lb Kg		* A - Stub Length	
18"	457.2	30	10300	10416	270	122	7-9/16"	192.1
		45	10301	10417	275	125	11-3/8"	288.9
		60	10302	10418	280	127	10-1/4"	260.4
		90	10303	10419	285	129	22"	565.2
		180	10304	10420	290	132	16"	412.8
24"	609.6	30	10305	10421	295	134	11-3/4"	298.5
		45	10306	10422	295	134	10-1/4"	260.4
		60	10307	10423	300	136	8-11/16"	220.7
		90	10308	10424	300	136	24-1/8"	612.8
		180	10309	10425	315	143	11-5/16"	287.3
30"	762.0	30	10310	10426	325	147	11"	279.4
		45	10311	10427	330	150	9-1/16"	230.2
		60	10312	10428	330	150	12-1/8"	308.0
		90	10313	10429	335	152	28-1/4"	717.6
		180	10314	10430	350	159	16-5/8"	412.8
36"	914.4	30	10315	10431	365	166	5-1/4"	133.4
		45	10316	10432	370	168	7-7/8"	200.0
		60	10317	10433	370	168	5-9/16"	141.3
		90	10318	10434	375	170	30-1/4"	768.4
		180	10319	10435	395	179	11-7/8"	301.6
42"	1066.8	30	10320	10436	410	186	9-7/16"	239.7
		45	10321	10437	410	186	11-11/16"	296.9
		60	10322	10438	415	188	8-15/16"	227.0
		90	10323	10439	420	191	33-1/4"	844.6
		180	10324	10440	440	200	10-3/8"	263.5
48"	1219.2	30	10325	10441	440	200	8-5/8"	219.1
		45	10326	10442	460	209	5-9/16"	141.3
		60	10327	10443	465	211	7-7/16"	188.9
		90	10328	10444	470	213	36-1/4"	920.8
		180	10329	10445	495	215	10-1/2"	266.7
54"	1371.6	90	10330	10446	397	180	36"	914.4
		180	10331	10447	382	173	12"	304.8
60"	1524.0	90	10332	10448	434	197	42"	1066.8
		180	10333	10449	413	187	12"	304.8

* The stub lengths given are for reference only. They are meant to be used as a design guide.

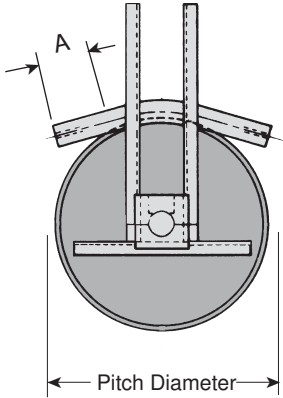


X458 Chain

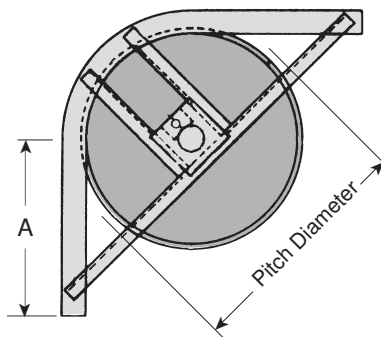
4" I-beam (101.6mm)

3-3/16" Drop (81.0mm)

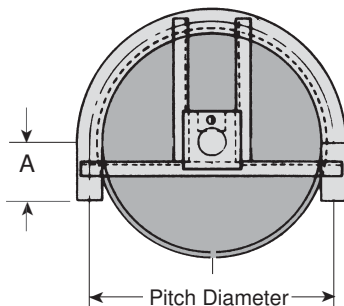
30°, 45° & 60° Turns



90° Turn



180° Turn



Pitch Diameter		Degree	Part No. Roller	Part No. Carbon	Weight		* A - Stub Length	
					Lb	Kg		
24"	609.6	30	10339	10455	231	105	12"	304.8
		45	10340	10456	233	106	12"	304.8
		60	10341	10457	234	107	12"	304.8
		90	10342	10458	266	121	24"	609.6
		180	10343	10459	254	115	12"	304.8
30"	762.0	30	10344	10460	260	118	12"	304.8
		45	10345	10461	261	119	12"	304.8
		60	10346	10462	268	121	12"	304.8
		90	10347	10463	306	139	24"	609.6
		180	10348	10464	296	134	12"	304.8
36"	914.4	30	10349	10465	302	137	12"	304.8
		45	10350	10466	305	138	12"	304.8
		60	10351	10467	307	139	12"	304.8
		90	10352	10468	359	163	30"	762.0
		180	10353	10469	342	155	12"	304.8
42"	1066.8	30	10354	10470	346	157	12"	304.8
		45	10355	10471	348	158	12"	304.8
		60	10356	10472	351	159	12"	304.8
		90	10357	10473	408	185	30"	762.0
		180	10358	10474	394	179	12"	304.8
48"	1219.2	30	10359	10475	394	179	12"	304.8
		45	10360	10476	397	180	12"	304.8
		60	10361	10477	400	181	12"	304.8
		90	10362	10478	472	214	36"	914.4
		180	10363	10479	450	204	12"	304.8
54"	1371.6	90	10364	10480	481	218	36"	914.4
		180	10365	10481	462	209	12"	304.8
60"	1524.0	90	10366	10482	527	239	42"	1066.8
		180	10367	10483	500	227	12"	304.8
66"	1676.4	90	10368	10484	564	256	42"	1066.8
		180	10369	10485	540	245	12"	304.8
72"	1828.8	90	10370	10486	609	276	48"	1219.2
		180	10371	10487	580	263	12"	304.8

* The stub lengths given are for reference only. They are meant to be used as a design guide.

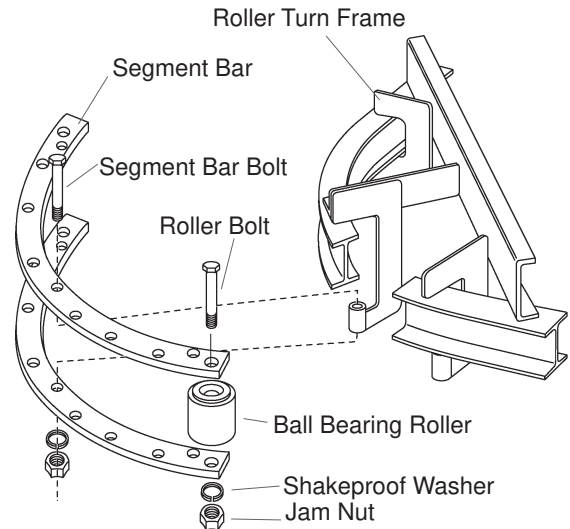
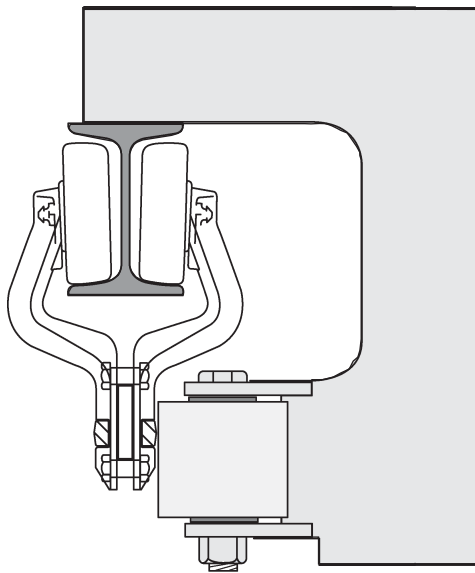
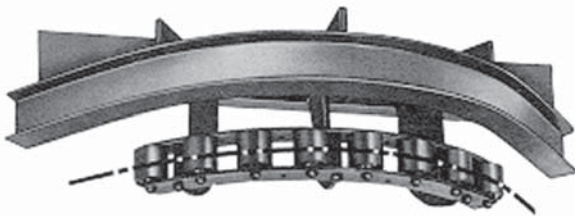


Webb Roller Turn Features

Roller turn rollers are designed to keep the power chain & trolleys in proper alignment when negotiating horizontal turns. They are available in 30°, 45°, 60°, 90° and 180° segments. Custom radii and curve segments can be fabricated upon request.

A roller turn assembly consists of a frame, I-beam rail, segment bar assembly and rollers. The frame is a welded steel construction designed to minimize deflection from chain pull. The roller segment bar assembly is bolted to the frame. This feature allows for easy replacement of either the complete roller assembly or individual rollers.

Roller turns are available with ball bearing rollers. When selecting conveyor system roller turns, be aware of load to load clearances on turns. Also, larger radii roller turns reduce friction and wear. They are recommended for systems where heavy chain pull is encountered.



Minimum Recommended Roller Turn Radii

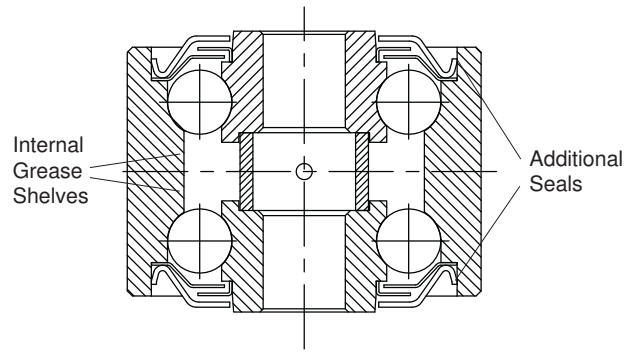
Chain Size	Recommended Trolley Spacing	Traction Wheel Dia.	Roller Turn Radius
X-348	up to 18"	24"	18"
	24"	30"	18"
	30"	36"	18"
X-458	up to 24"	30"	24"
	32"	36"	24"

Ball Bearing Roller and Hardware

Unibeam roller turn rollers are specially constructed ball bearing rollers incorporating labyrinth seals. The units are factory lubricated and considered sealed-for-life.

Labyrinth seals protect bearings from contamination.

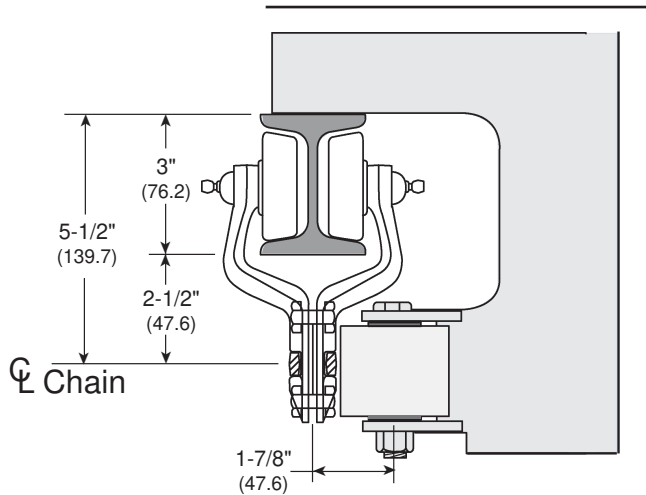
I-beam Size	Roller Turn Roller	Roller Bolt	Nut	Washer
3" Roller Turn	16493	9624	56567	57015
4" Roller Turn	16472	9577	56567	57015





X-348 Roller Turn

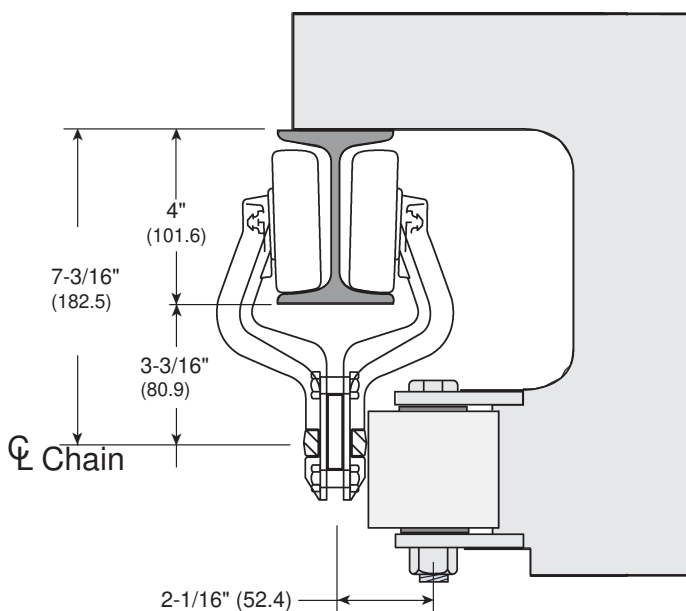
Roller Bearing Type..... Standard
Roller Bolt Dia..... 5/8" (15.7mm)
Chain Drop..... 2-1/2" (63.5)



Turn Radius	Part No.	Degree of turn	# of Rollers	Weight		Stub Length	
				lb	kg		
18"	9658	30°	2	64	29	12"	304.8
	9656	45°	3	71	32	12"	304.8
	9654	60°	4	72	33	12"	304.8
	9652	90°	6	84	38	12"	304.8
	9650	180°	12	151	68	12"	304.8
24"	9668	30°	3	76	34	12"	304.8
	9666	45°	4	83	38	12"	304.8
	9664	60°	6	96	44	12"	304.8
	9662	90°	8	110	50	12"	304.8
	9660	180°	16	198	90	12"	304.8
30"	9678	30°	4	80	36	12"	304.8
	9676	45°	5	90	41	12"	304.8
	9674	60°	7	104	47	12"	304.8
	9672	90°	10	131	59	12"	304.8
	9670	180°	20	240	109	12"	304.8
36"	9688	30°	4	80	36	12"	304.8
	9686	45°	6	98	44	12"	304.8
	9684	60°	8	119	54	12"	304.8
	9682	90°	12	149	67	12"	304.8
	9680	180°	24	278	126	12"	304.8
48"	212380	30°	6	107	48	12"	304.8
	212374	45°	8	131	59	12"	304.8
	212379	60°	12	163	74	12"	304.8
	212373	90°	16	185	84	12"	304.8
	9690	180°	32	408	185	12"	304.8

X-458 Roller Turn

Roller Bearing Type..... Standard
Roller Bolt Dia..... 5/8" (15.7mm)
A - Chain Drop..... 3-3/16" (80.9mm)



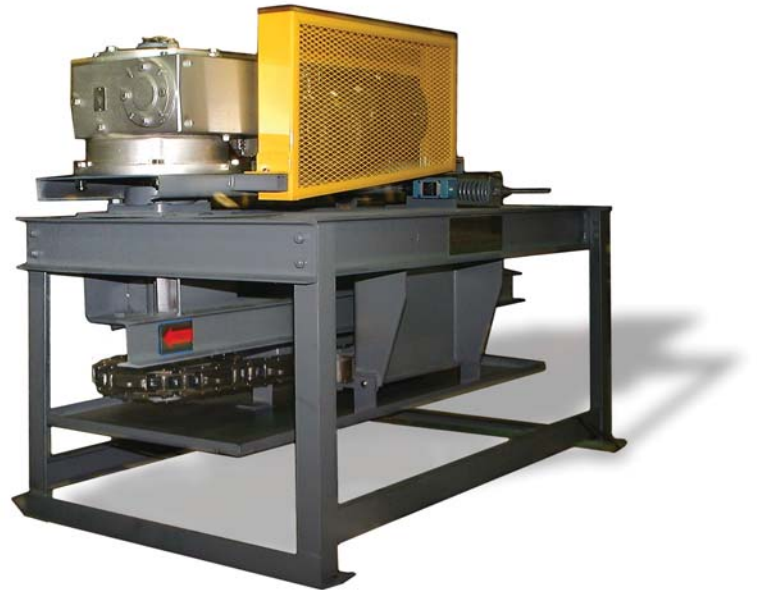
Turn Radius	Part No.	Degree of turn	# of Rollers	Weight		Stub Length	
				lb	kg		
24"	9718	30°	3	92	42	12"	304.8
	9716	45°	4	101	46	12"	304.8
	9714	60°	6	116	53	12"	304.8
	9712	90°	8	148	67	12"	304.8
	9710	180°	16	258	117	12"	304.8
30"	9728	30°	4	97	44	12"	304.8
	9726	45°	5	109	49	12"	304.8
	9724	60°	7	133	60	12"	304.8
	9722	90°	10	173	78	12"	304.8
	9720	180°	20	308	140	12"	304.8
36"	9738	30°	4	99	45	12"	304.8
	9736	45°	6	107	48	12"	304.8
	9734	60°	8	152	69	12"	304.8
	9732	90°	12	196	89	12"	304.8
	9730	180°	24	356	161	12"	304.8
48"	9758	30°	6	127	58	12"	304.8
	9756	45°	8	149	67	12"	304.8
	9754	60°	12	190	86	12"	304.8
	9752	90°	16	244	111	12"	304.8
	9750	180°	32	493	223	12"	304.8
60"	9762	90°	20	327	148	12"	304.8
72"	9772	90°	22	360	166	12"	304.8



The heart of your conveyor system...

Webb Rotary Caterpillar Drive offers many advantages over conventional linear floating drives. Webb knows your production depends on drive reliability and ease of component maintenance.

- **Rotary design** provides greater overload protection. Linear floating drives do not protect against jams within the caterpillar drive assembly.
- **Maintenance** and service is easier, simpler, and faster. A maintenance platform provides greater access. Nearly all components are freely accessible from one side without obstruction.
- **More compact** frame design is uncomplicated and rugged. The frame design is smaller and can accommodate all Webb rotary reducers.
- **Backup bar** positions the caterpillar chain in proper alignment with the conveyor chain.



#35 Caterpillar Drives

Conveyor Speed		5	10	15	20	25	30	35	40	45	50	55	60	65	70	
Horsepower		1 Horsepower					2 Horsepower					3 Horsepower				
Chain Pull Capacity		1000# Double Reduction Reducer					1000# Single Reduction Reducer									
B-600	#35 X-348 Rotary Constant Speed Caterpillar Drive. Includes V-Belt Guard and Limit Switch Overload Cut-Off. Speed Range 33 to 70 F.P.M. Less Controls, with Motor, Sheaves and V-Belt. (Single Reduction)															
B-601	#35 X-348 Rotary Constant Speed Caterpillar Drive. Includes V-Belt Guard and Limit Switch Overload Cut-Off. Speed Range 3 to 32 F.P.M. Less Controls, with Motor, Sheaves and V-Belt. (Double Reduction)															
B-605	#35 X-458 Rotary Constant Speed Caterpillar Drive. Includes V-Belt Guard and Limit Switch Overload Cut-Off. Speed Range 33 to 70 F.P.M. Less Controls, with Motor, Sheaves and V-Belt. (Single Reduction)															
B-606	#35 X-458 Rotary Constant Speed Caterpillar Drive. Includes V-Belt Guard and Limit Switch Overload Cut-Off. Speed Range 3 to 32 F.P.M. Less Controls, with Motor, Sheaves and V-Belt. (Double Reduction)															



Webb has developed a UniFrame rotary caterpillar drive assembly to satisfy the reliable performance needs of today's modern manufacturing facilities. The following are the principal features of the UniFrame Drive:

The UniFrame Drive is a rotary type unit with limit switch overload protection. The rotary design can sense jam conditions within the drive and activate the overload limit switch. Linear drives cannot sense a jam within the unit.

Time-tested subcomponents such as the Webb caterpillar chain, backup bar, and drive sprocket have been incorporated into the new design.

SEW Eurodrive gearmotors are used, eliminating the need for belts, sheaves or additional guards. The helical-gear arrangement operates with higher efficiencies and at lower temperatures than worm gear reducers. SEW also provides 24-7 parts support. (The major factor in Webb's choice of the SEW unit.)

The reducer is a hollow shaft style unit that allows simplification of the drive/reducer connection. The entire reducer can be removed by removing a few bolts without disassembling the sprocket and caterpillar chain arrangement.

The reducers/gear motor arrangement simplifies preventive maintenance by eliminating belts and sheaves, which require periodic adjustment/replacement.

Brake motors are standard on the UniFrame Drive. (Note: Brakes must be wired separately when used with VFDs).

Frames are stocked for chain pull capacities of 2000 lb and 3000 lb.

4000 lb capacity units are available by special order.

Standard units are designed for use with VFD controllers. Webb offers three speeds of 15, 45 and 60 feet per minute. Inverter duty motors can operate within 3:1 turn down ratios allowing speed ranges of 5-15, 15-45 and 20-60 feet per minute based on constant torque. Higher turn down ratios are achievable with slight variances in torque.



X-348 Systems

Conveyor Speed	5	10	15	20	25	30	35	40	45	50	55	60
Horsepower	1.5 Horsepower			3 Horsepower						5 Horsepower		
Chain Pull Capacity	2000 lb											
947159	UniFrame X-348 rotary constant speed caterpillar drive assembly 2000 lb. Chain pull capacity c/w 1.5 HP, 230/460 Volt AC, TEFC inverter duty gear motor, 3:1 turn-down ratio, 460 Volt AC brake and limit switch overload protection. Nominal speed 15 FPM.											
947158	UniFrame X-348 rotary constant speed caterpillar Drive assembly 2000 lb. Chain pull capacity c/w 3 HP, 230/460 Volt AC, TEFC inverter duty gear motor, 3:1 turn-down ratio, 460 Volt AC brake and limit switch overload protection. Nominal speed 45 FPM.											
947157	UniFrame X-348 rotary constant speed caterpillar Drive assembly 2000 lb. Chain pull capacity c/w 5 HP, 230/460 Volt AC, TEFC inverter duty gear motor, 3:1 turn-down ratio, 460 Volt AC brake and limit switch overload protection. Nominal speed 60 FPM.											



X-458 Systems

Conveyor Speed		5	10	15	20	25	30	35	40	45	50	55	60	
Horsepower		1.5 Horsepower			3 Horsepower						5 Horsepower			
Chain Pull Capacity		2000 lb												
947166	UniFrame X-458 rotary constant speed caterpillar Drive assembly 2000 lb Chain pull capacity c/w 1.5 HP, 230/460 Volt AC, TEFC inverter duty gear motor, 3:1 turn-down ratio, 460 Volt AC brake and limit switch overload protection. Nominal speed 15 FPM.													
947165	UniFrame X-458 rotary constant speed caterpillar Drive assembly 2000 lb Chain pull capacity c/w 3 HP, 230/460 Volt AC, TEFC inverter duty gear motor, 3:1 turn-down ratio, 460 Volt AC brake and limit switch overload protection. Nominal speed 45 FPM.													
947164	UniFrame X-458 rotary constant speed caterpillar Drive assembly 2000 lb Chain pull capacity c/w 5 HP, 230/460 Volt AC, TEFC inverter duty gear motor, 3:1 turn-down ratio, 460 Volt AC brake and limit switch overload protection. Nominal speed 60 FPM.													

X-458 Systems

Conveyor Speed		5	10	15	20	25	30	35	40	45	50	55	60	
Horsepower		1.5 Horsepower			5 Horsepower						7.5 Horsepower			
Chain Pull Capacity		3000 lb												
947163	UniFrame X-458 rotary constant speed caterpillar Drive assembly 3000 lb Chain pull capacity c/w 1.5 hp, 230/460 Volt AC, TEFC inverter duty gear motor, 3:1 turn-down ratio, 460 Volt AC brake and limit switch overload protection. Nominal speed 15 FPM.													
947162	UniFrame X-458 rotary constant speed caterpillar Drive assembly 3000 lb Chain pull capacity c/w 5 hp, 230/460 Volt AC, TEFC inverter duty gear motor, 3:1 turn-down ratio, 460 Volt AC brake and limit switch overload protection. Nominal speed 45 FPM.													
947133	UniFrame X-458 rotary constant speed caterpillar Drive assembly 3000 lb Chain pull capacity c/w 7.5 hp, 230/460 Volt AC, TEFC inverter duty gear motor, 3:1 turn-down ratio, 460 Volt AC brake and limit switch overload protection. Nominal speed 60 FPM.													

Caterpillar Drive Components

Standard Caterpillar Drive Chain

Special straight sidebar link keeps chain from bending backwards and keeps pressure off of the trailing dog roller. This evens the load out to the lead dog roller and helps prevent premature wear of the trailing dog roller.

Dog rollers are through hardened to a minimum Rockwell C47 hardness, increasing wearability of the rollers.

Dog faces are induction hardened to a Rockwell C55 hardness along the entire face of the dog ensuring accurate hardness levels.

4140 steel chain sidebars increase chain tensile strength.



Caterpillar Drive Chain Specifications

System	Chain Size	Dog Centers	Standard Caterpillar Chain
X-348	10'	12"	8388
X-458	10'	8"	8389



Take-up Features

These devices are used to provide a means of compensating for chain wear resulting in chain stretch.

Take-ups for overhead conveyors consist of a fixed outer frame and a moveable inner frame. The inner frame is mounted on rollers and incorporates two expansion sections in the conveyor track. The inner frame rolls within the stationary frame and is designed to take up slack in the conveyor chain due to wear or stretch.

Take-ups can be furnished with either roller turns or traction wheels. Roller turns are normally furnished with a continuous 180° arc, but are available at an optional cost as a spread take-up where two 90° arcs are employed with a section of straight track between them.

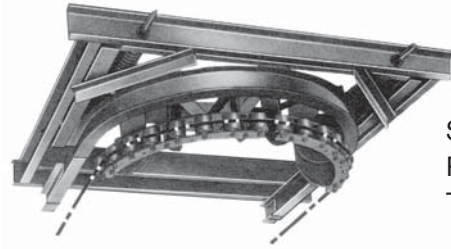
Webb take-ups are made in several styles. The most common styles are spring and air types. However, counterweight types are available upon request.

Spring Take-ups

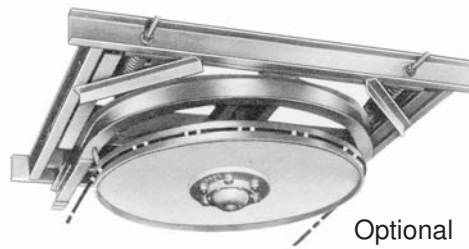
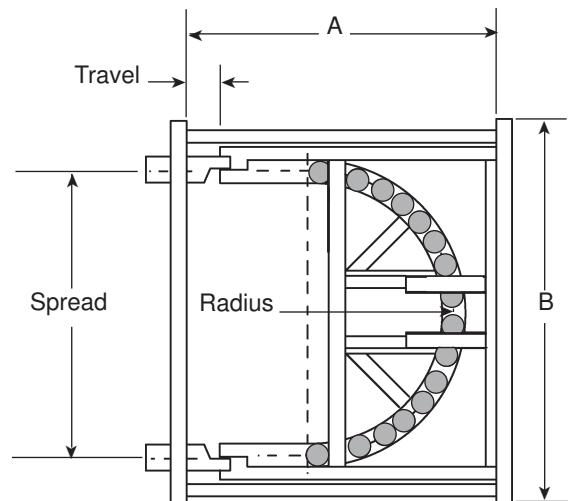
Because the spring take-up is automatic and requires very little maintenance, it is the most popular. The spring type take-up is generally satisfactory for non-reversing systems where it can be located immediately beyond the drive or where a relatively small amount of tension is required.

Air Take-ups

Air cylinder operated take-ups are recommended for conveyors that require a constant take-up tension. The tension in an air operated take-up can be readily adjusted at any time by regulating the air pressure through the use of suitable air control valves. The air operated take-up is particularly advantageous where it must be located at some distance from the unit.



Standard
Roller Turn
Take-up



Optional
Traction Wheel
Take-up
(Upon Request)



Roller Turn Takeup

Spring Operated, 8" Travel (203.2mm)

Turn Specs	Radius		Part #	A - Length		B - Width	
I-beam 3"	24"	609.6	9641	59-3/4"	1517.6	66-3/4"	1695.4
Chain 3"	36"	914.4	9643	71-3/4"	1822.4	90-3/4"	2305.0
Drop 2-1/2"							
I-beam 4"	24"	609.6	16507	59-3/4"	1517.6	66-3/4"	1695.4
Chain 4"	36"	914.4	16541	71-3/4"	1822.4	90-3/4"	2305.0
Drop 3-3/16"							

Roller Turn Takeup

Air Operated, 8" Travel

Turn Specs.	Radius		Part #	A - Length		B - Width	
I-beam 3"	24"	609.6	100871	59-3/4"	1517.6	66-3/4"	1695.4
Chain 3"	36"	914.4	100873	71-3/4"	1822.4	90-3/4"	2305.0
Drop 2-1/2"							
I-beam 4"	24"	609.6	100874	59-3/4"	1517.6	66-3/4"	1695.4
Chain 4"	36"	914.4	100876	71-3/4"	1822.4	90-3/4"	2305.0
Drop 3-3/16"							

Roller Turn Takeup

Air Operated, 30" Travel

Turn Specs.	Radius		Part #	A - Length		B - Width	
I-beam 3"	24"	609.6	100839	81-3/4"	2076.4	66-3/4"	1695.4
Chain 3"	36"	914.4	100841	93-3/4"	2381.2	90-3/4"	2305.0
Drop 2-1/2"							
I-beam 4"	24"	609.6	100842	81-3/4"	2076.4	66-3/4"	1695.4
Chain 4"	36"	914.4	100844	93-3/4"	2381.2	90-3/4"	2305.0
Drop 3-3/16"							



1/4 Ton Capacity Trolley

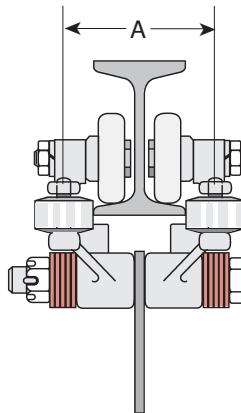
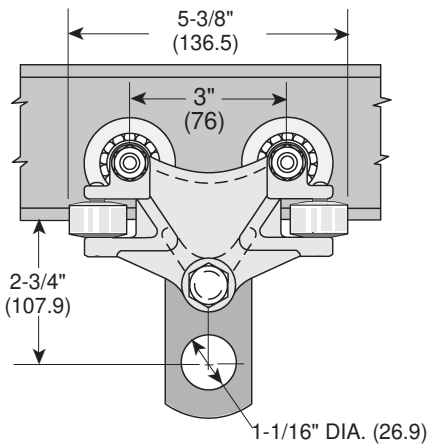
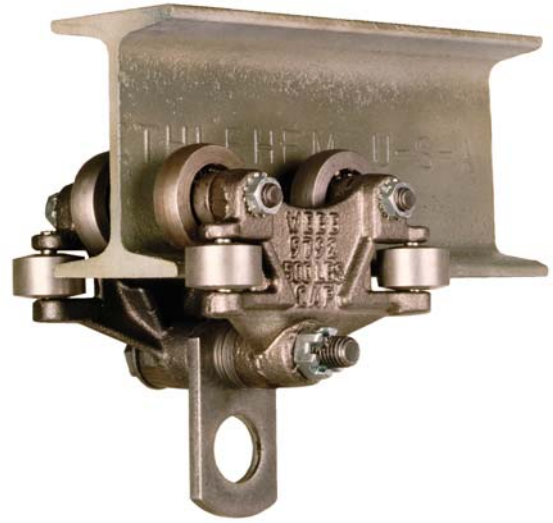
Part No. 9792

Adapts to: 2-5/8", 3" & 4" I-beams

Standard Features:

Side guide rollers prevent unnecessary wear on track and trolley.

Rugged cast iron body construction.



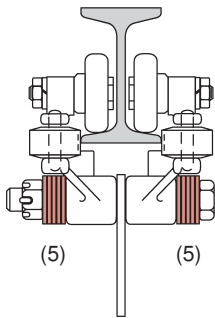
Min. horizontal radius 12" (304.8)
Dia. of load link bolt 1/2" (12.7)
Weight 8.63 pounds (3.9 kg)

I-beam Size	A	
	inch	mm
2-5/8"	3	76.2
3"	3-9/16	90.5
4"	3-7/8	98.4

Washer Placement Guide

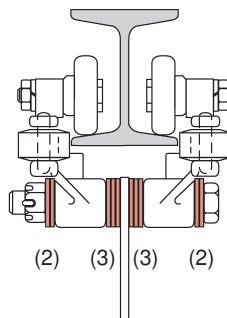
Caution: Maximum washer thickness for a 1/2" dia. (13.0) load bolt is 0.095" (2.4).

2-5/8" (67) I-beam



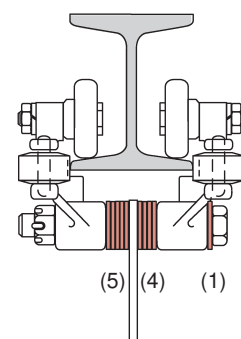
0 washers inside bolt
10 washers outside bolt

3" (76) I-beam



6 washers inside bolt
4 washers outside bolt

4" (102) I-beam



9 washers inside bolt
1 washer outside bolt



3/4 Ton Capacity Trolley

Part No. 10711

Adapts to: 4", 5" & 6" I-beams

For I-beams over 6", contact Webb Sales for special assembly instructions.

Standard Features:

Side guide rollers prevent unnecessary wear on track and trolley.

Extended end flanges for added safety.

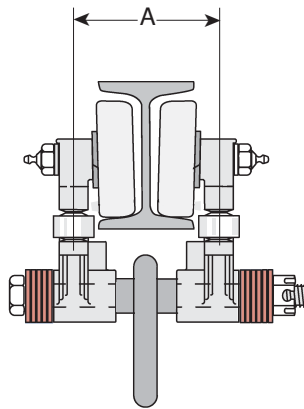
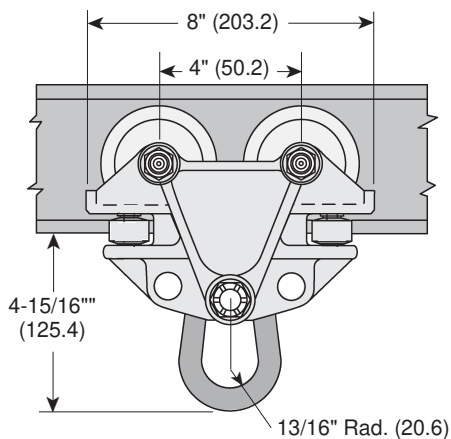
Rugged cast iron body construction.

Trolley wheels are equipped with standard triple labyrinth seals.

Wheels are bolted for easy replacement.

Available options:

Red Seal Guard with full contact grease seals.

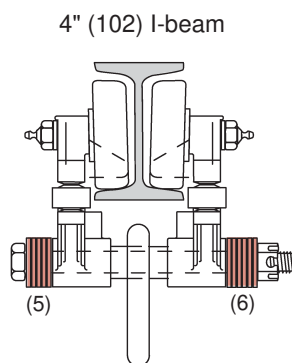


Min. horizontal radius 12" (304.8)
Dia. of load link bolt 5/8" (15.9)
Weight 17 pounds (7.71 kg)

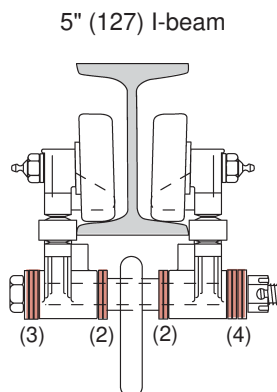
I-beam Size	A	
	inch	mm
4"	4	101.6
5"	4-3/8	111.7
6"	4-3/4	120.6

Washer Placement Guide

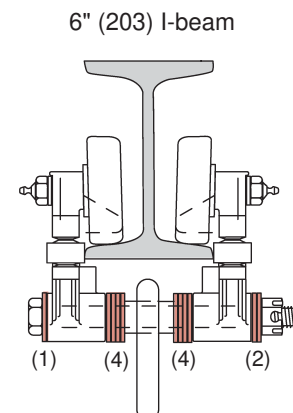
Caution: Maximum washer thickness for a 5/8" dia. (16.0) load bolt is 0.134" (2.4)



0 washers inside bolt
11 washers outside bolt



4 washers inside bolt
7 washers outside bolt



8 washers inside bolt
3 washers outside bolt



1 Ton Capacity Trolley

Part No. 8360

Adapts to: 5", 6", 7" & 8" I-beams

For use on 10" & 12" I-beams, contact Webb Sales for special assembly instructions.

Standard Features:

Side guide rollers prevent unnecessary wear on track and trolley.

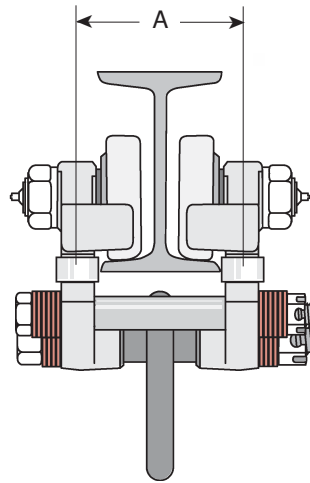
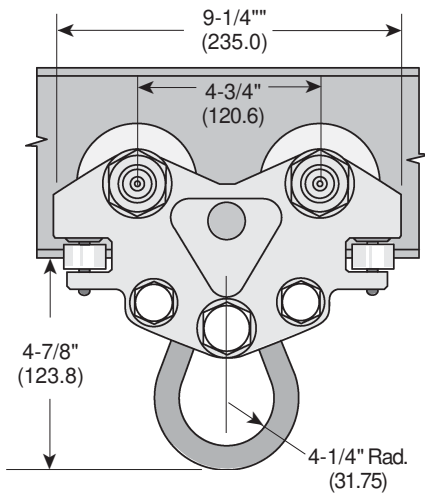
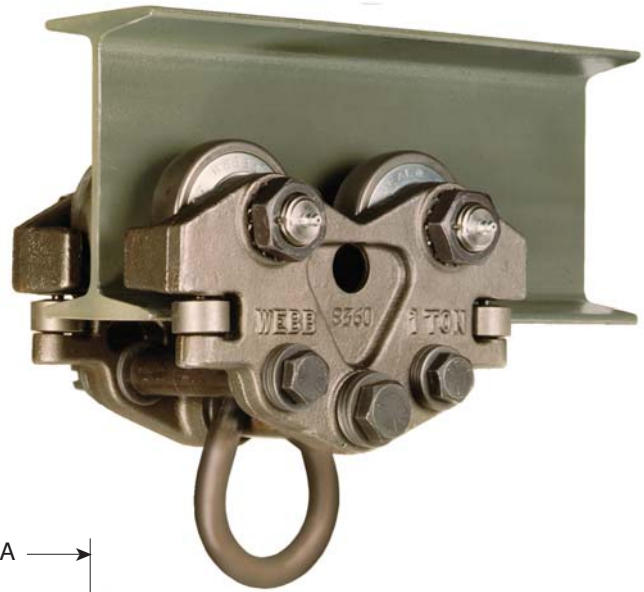
Extended end flanges for added safety.

Rugged cast iron body construction.

Trolley wheels are equipped with standard triple labyrinth seals. Wheels are bolted for easy replacement.

Available options:

Red Seal Guard with full contact grease seals.



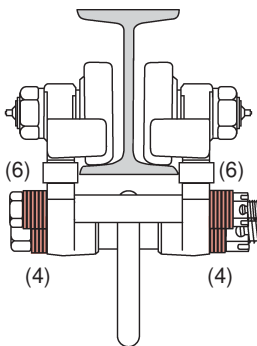
Min. horizontal radius 12" (304.8)
Dia. of load link bolt 3/4" (19.1)
Weight 27.75 pounds (12.58 kg)

I-beam Size	A	
	inch	mm
5"	4-5/16	109.5
6"	4-11/16	119.1
7"	4-15/16	125.4
8"	5-5/16	135.0

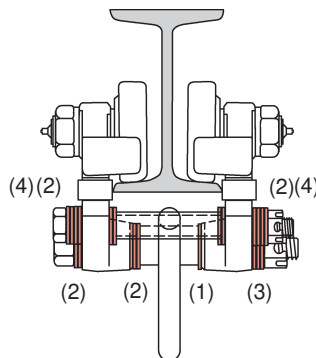
Washer Placement Guide

Caution: Maximum washer thickness for a 5/8" dia. (16.0) safety bolt is 0.095" (2.4)
Maximum washer thickness for a 3/4" dia. (19.0) load bolt is 0.134" (3.4)

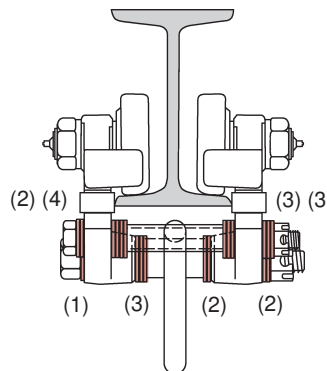
5" (127) I-beam



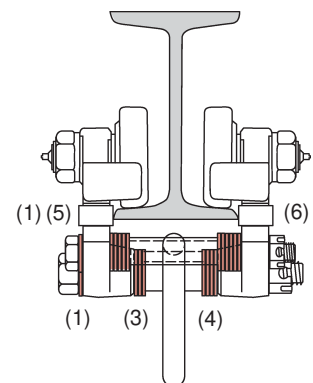
6" (152) I-beam



7" (178) I-beam



8" (203) I-beam



Load Bolts 0 washers per bolt inside
8 washers per bolt outside

Safety Bolts 0 washers per bolt inside
12 washers per bolt outside

3 washers per bolt inside
5 washers per bolt outside

4 washers per bolt inside
8 washers per bolt outside

5 washers per bolt inside
3 washers per bolt outside

7 washers per bolt inside
5 washers per bolt outside

7 washers per bolt inside
1 washers per bolt outside

11 washers per bolt inside
1 washer per bolt outside



2 Ton Capacity Trolley

Part No. 8363

Adapts to: 6", 8", 10" & 12" I-beams

Standard Features:

Side guide rollers prevent unnecessary wear on track and trolley.

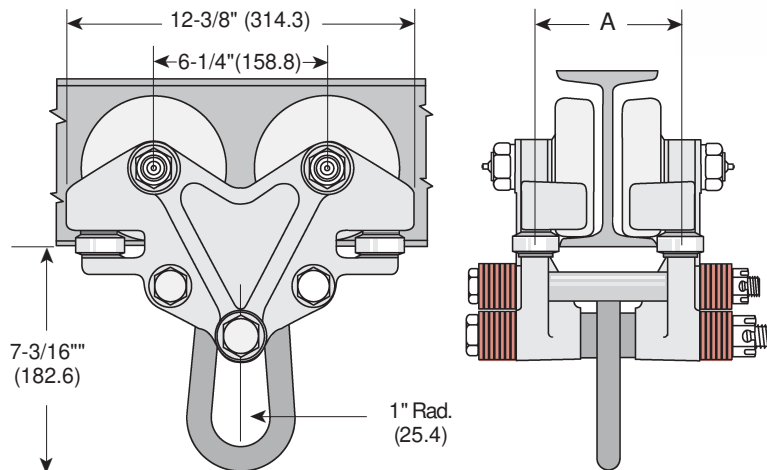
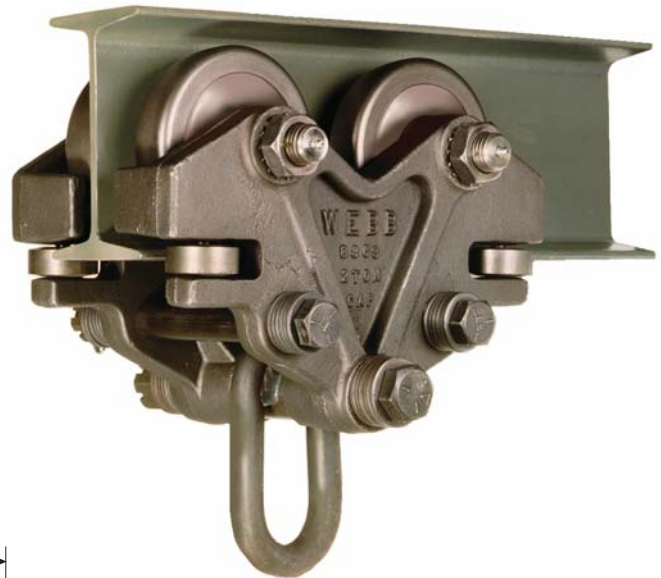
Extended end flanges for added safety.

Rugged cast iron body construction.

Trolley wheels are equipped with standard triple labyrinth seals. Wheels are bolted for easy replacement.

Available options:

Red Seal Guard with full contact grease seals.



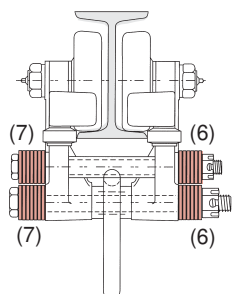
Min. horizontal radius36" (304.8)
Dia. of load link bolt 7/8" (22.2)
Weight66.5 pounds (30.16 kg)

I-beam Size	A	
	inch	mm
6"	5-5/16	135.0
8"	5-15/16	150.8
10"	6-9/16	166.6
12"	6-15/16	176.2

Washer Placement Guide

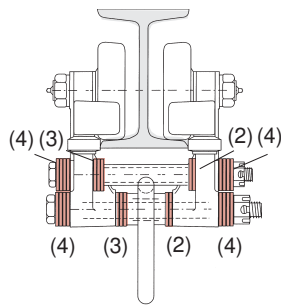
Caution: Maximum washer thickness for a 3/4" dia.(19.0) safety bolt is 0.134" (3.4)
Maximum washer thickness for a 7/8" dia. (22.0) load bolt is 0.134" (3.4)

6" (152mm) I-beam



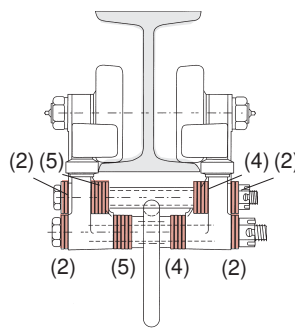
0 washers per bolt inside
13 washers per bolt outside

8" (203mm) I-beam



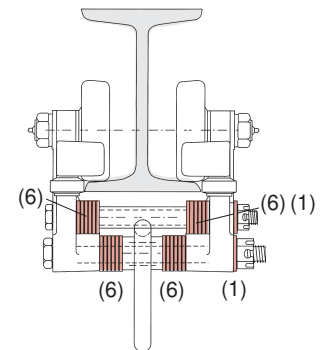
5 washers per bolt inside
8 washers per bolt outside

10" (254mm) I-beam



9 washers per bolt inside
4 washers per bolt outside

12" (304.8mm) I-beam

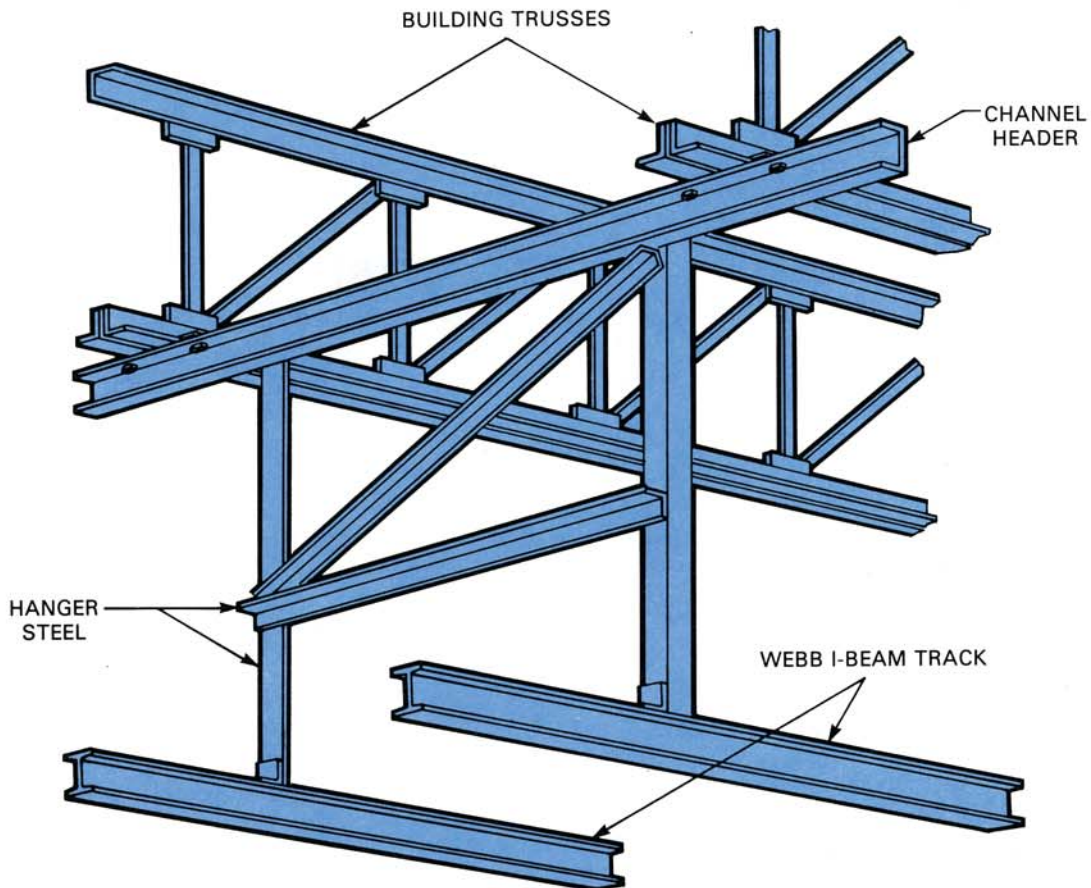


12 washers per bolt inside
1 washer per bolt outside



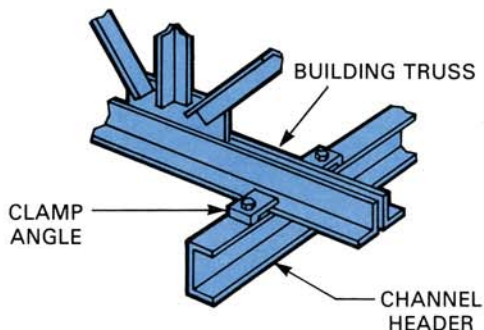
Reference Use Only

FITTINGS AND METHODS OF SUPPORTING I-BEAM TRACK



Wherever possible, avoid welding superstructure and hanger steel to the building steel...use bolted type connections. On hangers and header steel, welded connections are considered to be more economical than bolted connections...either type can be used.

Trolley loads and spacings govern the selection of hanger and sway brace angle sizes. The following angle sizes will provide sufficient conveyor support under average loading conditions:



TYPICAL BOLTED CONNECTION

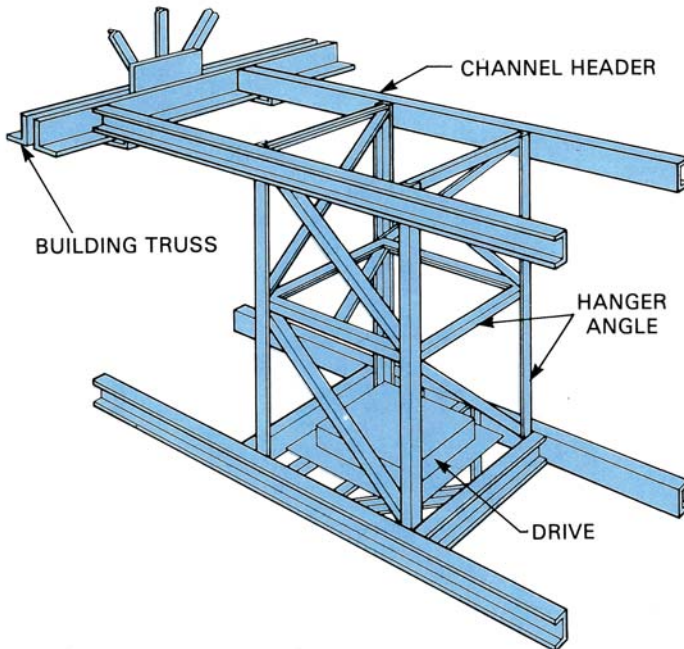
Note:

1. When supporting the drive, the above angle sizes must be increased.
2. Use welded construction except to building steel carrying stresses where clamps should be used.
3. Horizontal and vertical curves should be erected first.

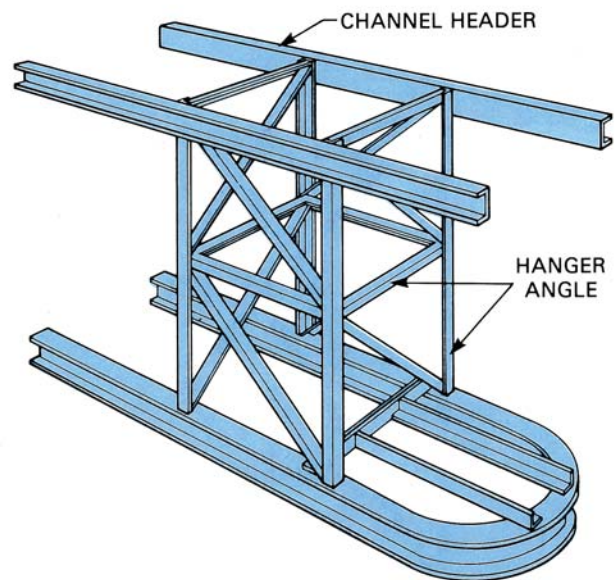


Reference Use Only

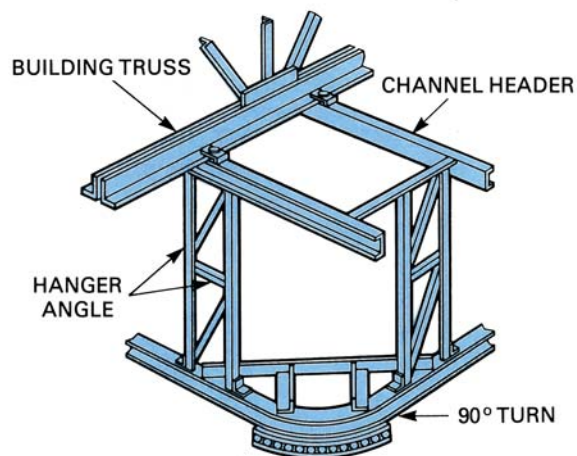
TYPICAL COMPONENT SUPPORT METHODS



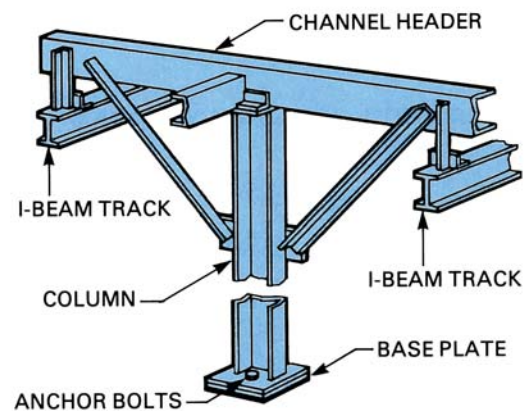
TYPICAL DRIVE SUPPORT



TYPICAL SUPPORTS FOR ALL 180° TURNS



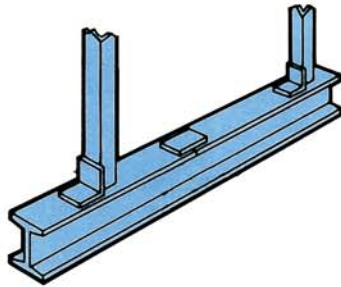
TYPICAL SUPPORTS FOR 90° TURNS



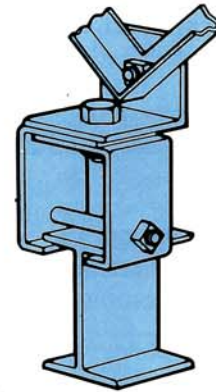
TYPICAL FLOOR SUPPORT



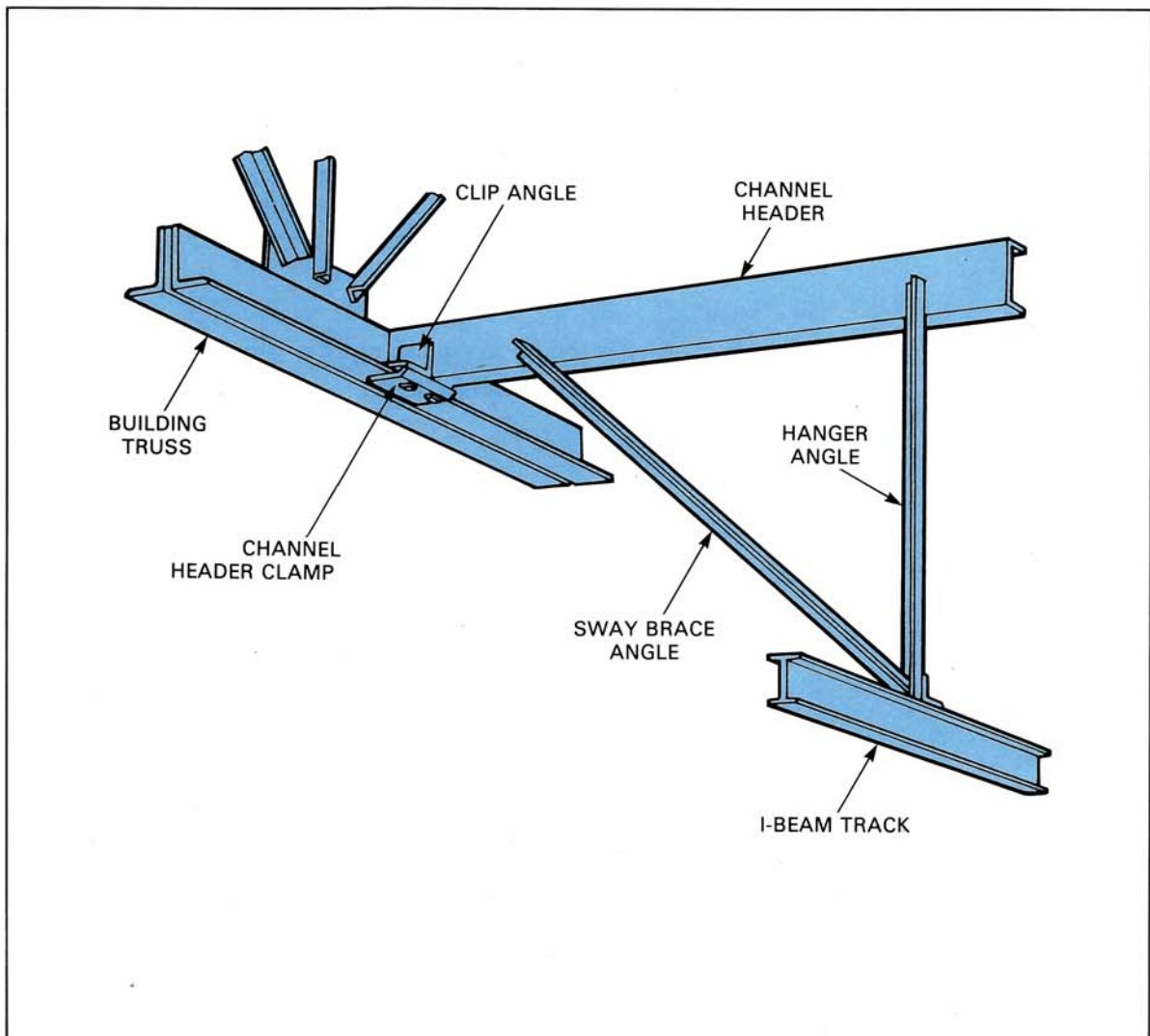
Reference Use Only



WELDED CONSTRUCTION



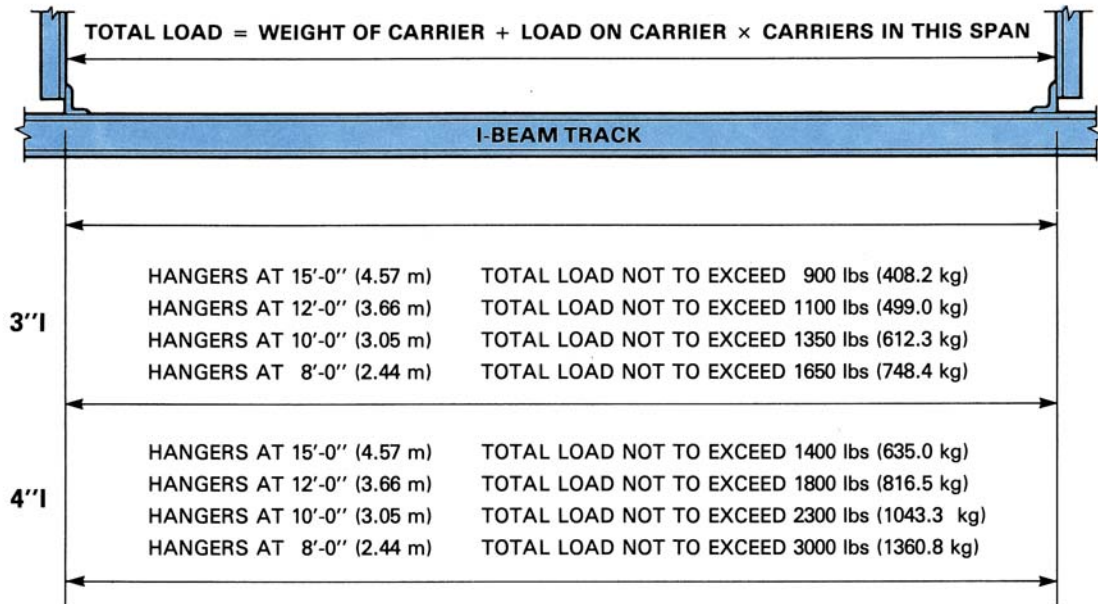
BOLTED CONSTRUCTION



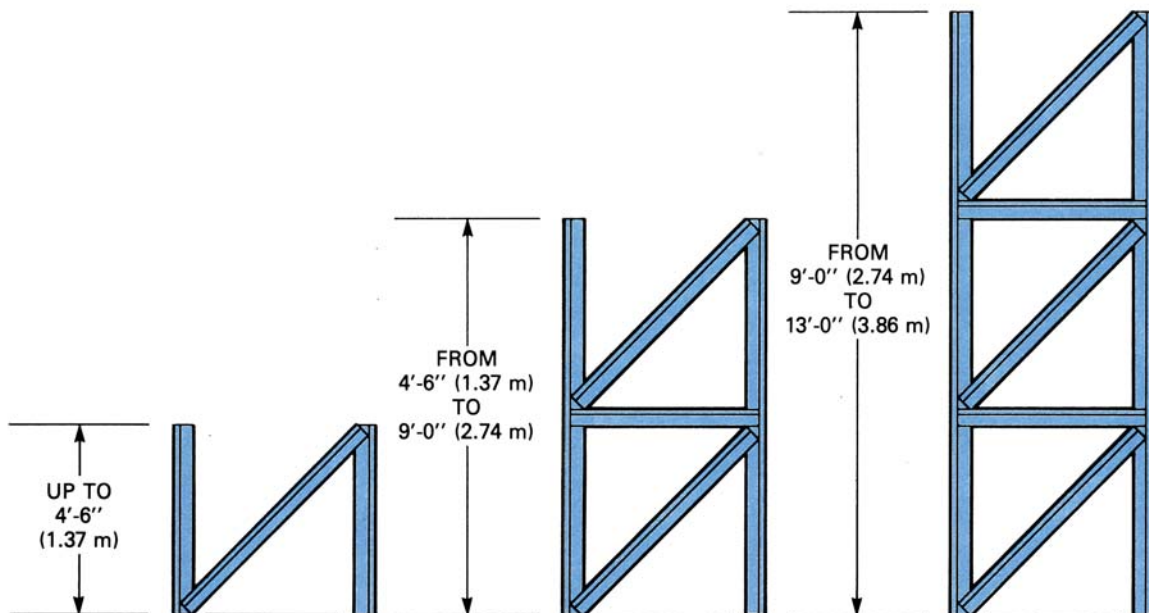


Reference Use Only

LOAD LIMITS ON I-BEAM TRACK



TYPICAL SUPPORT ELEVATIONS FOR HANGER STEEL
CROSS AND SWAY BRACES





Systematic care, inspection, and service of equipment performed on a regular basis will lead to early detection of minor problems.

- **Upon completion** of erection of an Overhead Trolley Conveyor and before operation of the conveyor, the customer's Maintenance Department shall properly lubricate all moving parts. Many customers prefer to use their own choice of lubricants and lubricating intervals. The following charts and suggestions are therefore offered as a guide.
- **Trolley wheel bearings** receive a minimum application of rust-proof spindle oil at the factory for protection during shipment only.
- **Trolley wheels** operating through part washers, steam, elevated temperatures, caustic and abnormal conditions should be baffled for protection and require special consideration. Refer to chart or your local lubricant specialist for recommendations.
- **Trolley wheels operating in elevated temperatures** (above 250°F, 121°C) should have an automatic lubricator of positive connection type located a reasonable distance from oven exit to allow parts to cool down to approximately 200°F (93°C). Lubricators should apply a minimum of mist or fog of light penetrating oil that will leave a minimum of residue.
- **Inspect** as recommended for sluggish wheels, dry chain, etc.
- **Sluggish or frozen wheels** must be removed from conveyor and thoroughly cleaned and inspected for later replacement use. The cost of a new trolley is sometimes less than the cost of cleaning the components.
- **A quantity of spare parts** should be on hand for replacement, especially half trolley assemblies, attachments, and inner caps.
- **To remove wheel inner cap**, pierce with a sharp tool and pry loose. Replace with new wheel inner cap, which must be pressed in place carefully with a blunt tool.
- **Do not over lubricate.** Wheels running smoothly require no additional lubricant.
- **Trolley brackets** that may become bent in service should be replaced. Do not attempt to straighten.
- **Chain should be lubricated at drive** on slack chain side to ensure lubricant reaches bearing point of pin and link.
- **Traction wheels with carbon bushing must never be lubricated.**
- **I-beam track should be inspected** at regular intervals for wear and peening of flanges at vertical curves and wear on I-beam webs.
- **Conveyors operating in extremely low temperatures** should be allowed to run at reduced speed continuously overnight to prevent freezing of lubricants.
- **Lubricants shown** in chart on page 8.5, or equal, are suggested.
DO NOT OVER LUBRICATE.



Reliability of conveyors depends largely on sound maintenance procedures. Each conveyor should be thoroughly inspected at regular intervals and corrective measures should be taken to prevent major breakdowns and loss of valuable production time.

If the log is maintained with sufficient information, a dual purpose will be accomplished. First, a record of trouble and responsibility is available. Second, the log can be reviewed periodically; and changes to frequency of inspection and/or maintenance methods could be made. This would then, over a period of time, make the maintenance program more effective.

A suggested log sheet form is shown below. If the same or similar troubles recur frequently, it is only logical to (1) make more frequent inspections for the particular trouble, or (2) investigate changes which will prevent such trouble. A written record of the log form type will assist in evaluation much more than “word of mouth”.

IMPORTANT: Do not attempt to perform maintenance or make adjustments on any equipment without first consulting the service manual. Be sure the conveyor is always disconnected from the power source before starting maintenance.

Maintenance Log Sheet

Conveyor No.	Date of Inspection	Result of Inspection	Parts Replaced or Repaired	Cause of Trouble	Mechanics' Initials



<i>Trouble</i>	<i>Probable Causes</i>	<i>Remedy</i>
CHAIN		
Excessive chain wear. <i>(Note: The chain will elongate due to wear; this is normal wear and is no fault of the system.)</i>	Lack of lubrication. Sluggish or frozen trolley wheels. Roller turn roller frozen. Obstruction in chain path. Conveyor overloaded.	Lubricate chain. Lubricate or replace trolleys. Replace roller turn rollers. Remove obstruction and remove and replace chain if damaged. Conveyor should not be loaded beyond its designed capacities.
Excessive slack chain.	Chain growth through normal wear.	Adjust take-up and if necessary remove links of chain.
TROLLEYS		
Sluggish or frozen trolley wheels.	Residue accumulated from over lubrication. Bearings corroded or worn out.	Remove from conveyor and clean. Remove welsh plug to clean and press on new plug with blunt tool. Replace trolley.
Bent trolley brackets	Damaged in jam or by obstruction.	Remove obstruction and replace damaged trolley bracket with new bracket. Do not attempt to straighten bent brackets.)
ROLLER TURNS		
Sluggish or frozen roller turn rollers	Dirt or grease residue.	Clean thoroughly or replace if bearings are damaged. See lubrication chart.
I-BEAM TURNS		
Excessive wear or peening of flanges at vertical curves.	Excessive chain tension.	Adjust chain tension.
Excessive wear on I-beam web.	Bent trolley brackets. Eccentric Loading.	Replace trolleys. Load carriers symmetrically.



<i>Trouble</i>	<i>Probable Causes</i>	<i>Remedy</i>
TAKE-UP		
Floating frame movement sluggish or frozen	<p>Spring compression, air pressure or counterweight load too great.</p> <p>Dry or damaged expansion joints.</p> <p>Guide wheels worn or frozen with dirt and grease residue.</p>	<p>Reduce the spring, air or counterweight loading.</p> <p>Lubricate if dry and replace with new expansion joints if damaged.</p> <p>Clean thoroughly or replace if worn.</p>
DRIVE		
Decrease in conveyor speed	<p>Belt slippage</p> <p>Set screws on pulley are loose and causing pulley to rotate on shaft.</p>	<p>Adjust belt until snug.</p> <p>Align pulley and tighten set screws.</p>
Drive stops	<p>Overload limit switch</p> <p>Power failure</p>	<p>Locate and eliminate cause of conveyor jam and restart conveyor.</p> <p>Check power supply</p>
Excessive noise in reducer	<p>Lack of lubrication</p> <p>Oil leak</p> <p>Worn or broken gear or bearing</p>	<p>Fill reducer with oil to oil level plate; or, if needed, change oil. Grease all fittings.</p> <p>Tighten all grease fittings and pipe plugs, clear breather tube opening and add lubricant.</p> <p>Disassemble reducer and replace damaged part.</p>
Motor running above normal temperature	<p>Conveyor chain pull excessive</p> <p>Electrical</p> <p>Bearing failure</p> <p>Motor ventilation obstructed</p>	<p>Inspect chain & trolley lubrication</p> <p>Inspect electrical wiring and controls.</p> <p>Inspect and replace motor.</p> <p>Clean motor of dust and dirt.</p>
Slapping or pulsating caterpillar chain	<p>Chain too loose</p> <p>Conveyor chain or caterpillar chain worn beyond use</p>	<p>Adjust drive take-up unit until chain is snug. (Do not remove any links of caterpillar chain or dogs.)</p> <p>Replace</p>
Floating frames sluggish or frozen	<p>Obstruction</p> <p>Guide wheels worn or frozen with dirt or grease residue</p>	<p>Remove obstruction and repair or replace any damaged equipment.</p> <p>Clean thoroughly or replace if worn too badly.</p>



Lubricant Guide for Operating Temperatures up to 250°F (121°C)

See local lubrication specialist for temperatures above 250°

	Inspect	Lubricant	Remarks
Chain	60 Days or as required	AGMA #3	
Trolley Wheels	30 Days	NLGI #2 Gr.*	
Roller Turn Rollers Zerk Fittings No Fittings		NLGI #2 Gr. SAE #30 Oil	Generally not used above 250°F
Traction Wheels Anti-Friction Carbon Bush		NLGI #2 Gr. None	Never lubricate carbon bushed traction wheels
Motor			See Instructions on motor
Countershaft Bearings		NLGI #2 Gr.	
Caterpillar Chain		SAE #90 Oil	
Caterpillar Chain Dogs		NLGI #2 Gr.	Apply to face of Dog
Takeup Bearings		NLGI #2 Gr.	
Idler Sprocket		NLGI #2 Gr.	
Back-up Rollers		SAE #30 Oil or NLGI #2 Gr.	
Back-up Bar		NLGI #2 Gr.	
Track		None	Inspect wear
Floating Frame Wheels		None	Prepacked
Reducers & Fittings		50° to 125°F (10° to 52°C) NLGI #2 Gr.	
Gear Case		AGMA #8 Comp. Oil** For use with bronze worm gear reducer	See instructions on unit

*Lithium Complex Base Recommended

**Temperature 15° to 60° (-9° to 16°C). Use AGMA #7 Comp. oil for use with Bronze Worm Gear Reducer.



Suggested Inspection Checklist for Webb Overhead Trolley Conveyors

Chain

- ☐ Lubrication
- ☐ Excessive wear
- ☐ Slack Chain

Trolleys

- ☐ Lubrication
- ☐ Sluggish or frozen wheels
- ☐ Bent bracket
- ☐ Loose bracket bolts

I-Beam

- ☐ Wear and peening on flanges at vertical curves
- ☐ Wear on web at load or unload points, horizontal and vertical curves
- ☐ Obstacles on track interfering with trolley path

Roller Turns

- ☐ Lubrication
- ☐ Roller bearing wear
- ☐ Roller face wear
- ☐ Loose roller bolts
- ☐ Loose bracket bolts

Takeup

- ☐ Lubrication
- ☐ Limit switches
- ☐ Roller bearing wear
- ☐ Roller face wear
- ☐ Loose roller bolts
- ☐ Loose bracket bolts
- ☐ Travel remaining
- ☐ Spring (screw) adjustment
- ☐ Expansion joint conditions
 - Lubrication
 - Wear
 - Free movement
- ☐ Ease of floating frame travel

Traction Wheels

- ☐ Lubrication
- ☐ Bearings
- ☐ Rim wear
- ☐ Check bolts
- ☐ Alignment

Drive

- ☐ Lubrication
 - Cat chain
 - Machinery components
 - Bearings
 - Oil level in reducer
 - ☐ Wear
 - Cat chain
 - Back-up bar
 - Back-up rollers
 - Cat unit sprockets
 - ☐ Adjustments
 - Cat unit take-up (Cat chain should be tight)
 - Back-up bar
 - Limit switch cut-off tripper bar
 - ☐ Overload condition
 - Chain pull indicator reading in overload zone
 - Motor or reducer running at excessive temperature
 - ☐ Belt drive condition
 - Pulleys are aligned and set screws are tight
 - Belts are in good condition and are not slipping
 - ☐ Excessive oil leakage from reducer
 - ☐ Loose mounting bolts
 - ☐ Ease of floating frame travel
- ### Safety
- ☐ All applicable safety procedures followed during inspection
 - ☐ Proper installation of all safety devices

NOTICE:

This catalog is intended to illustrate the various Webb overhead conveyor components and their application into a conveyor system. Environmental as well as many other conditions will vary with each installation. Jervis B. Webb Company does not represent or warrant that adherence to any guidelines or suggestions set forth in this catalog will necessarily result in proper selection, manufacture, installation and/or maintenance of conveyor equipment and/or a conveyor system. Jervis B. Webb Company disclaims responsibility for any equipment and/or system malfunction, property damage, personal injury or any other damages of any kind or nature, or violations of law resulting from component, equipment and/or system selection, design, installation, maintenance or operation performed by a contractor, user or any other person.

DESIGN CHANGES: Jervis B. Webb Company reserves the right to change the design or construction of its products at any time without obligation for replacement or refund on any products or parts thereof which may be in any customer's possession at the time such changes become effective.

In accordance with our established policy to constantly improve our products, the specifications in this manual are subject to change without notice.

