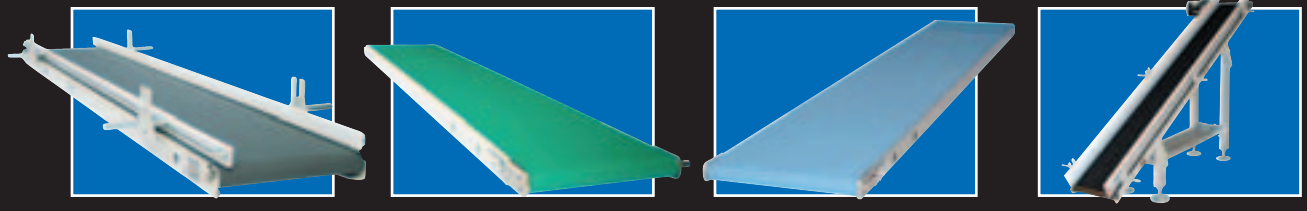
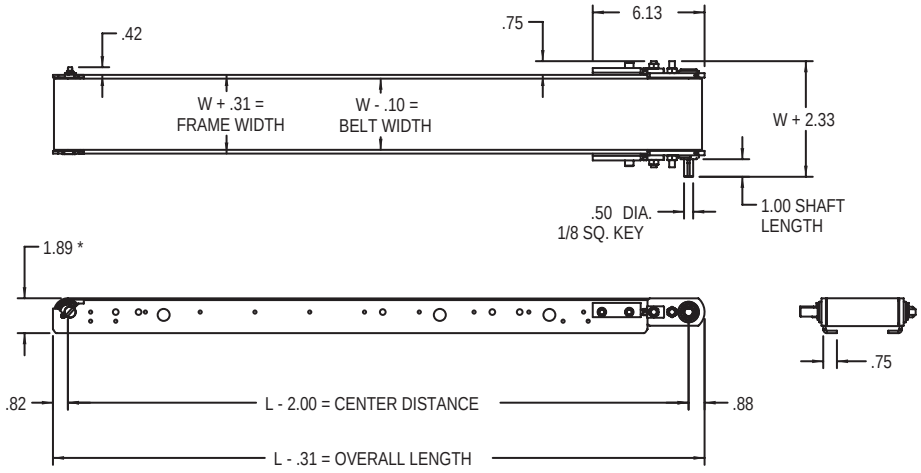
Specifications

- Width 2” to 24”
- Length 24” to 144”
- Profile 1.89” high
- Drive Pulley 1.31” Diameter
- Load Carrying Capacity to 450 lbs.*
- Speed Range up to 225 fpm

*See Technical Data on page 10



Overview Dimensions



Note: As in all industries, technical specifications will change with technology updates. Please contact factory or see www.qcindustries.com for the most up-to-date drawings.

*Dimension reflects use of MAA belt. See pages 20-21.

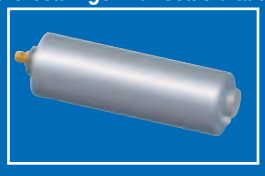
Features & Benefits

Conveyor

- ***Low profile design*** provides tight product transfers and the ability to fit into space-constrained areas
- Single piece 10-gauge steel framework is laser cut and formed to create a ***single-body frame construction***, ensuring frame integrity
- ***Tight tolerance belting*** and our unique snap-out sealed tail assembly provide for a ***quick belt change*** (less than 5 minutes) that is normally achieved without having to remove the drive packages or side rails
- ***High tensile strength belts*** offer superior strength-to-weight ratio and are ***available in over 50 various types***
- All components in our conveyors are produced on ***state-of-the-art manufacturing*** equipment

Tail Assembly

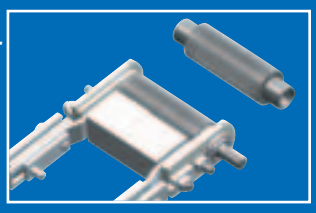
- ***Single point belt tension*** is achieved through a ***snap-in eccentric tail assembly*** designed to pull through the natural elongation characteristics of the belt and provide quick and easy belt change capacity
- ***Crowned sealed tail assembly*** is designed to promote excellent belt tracking and is equipped with superior ***needle bearings with seals*** that are filled with high performance grease
- ***Thrust washers*** designed into the tail assembly provide axial float, which allows the assembly to move with the natural camber of the belt and ***protect bearings against off-center load conditions***



- Grease fitting design in the tail assembly allows for lubrication of bearings while the conveyor is running, resulting in ***zero down time during lubrication***
- ***Precision bearing alignment*** is guaranteed within the pressed tail assembly, providing optimal conditions to ***move the heaviest loads*** in low profile conveyors
- Eccentric tracking bushing allows for ***single point tracking control*** at the idler end of the conveyor

Drive Assembly

- ***Straight knurl design used to prevent premature wear*** on the carcass of the belt and still provide superior grip to overcome start-up inertia
- ***Crowned sealed drive assembly*** designed to promote superior belt tracking, and is equipped with ***superior needle bearings with seals*** that are filled with high performance grease
- ***Thrust washers*** designed into the drive assembly provide axial float, which allows the assembly to move with the natural camber of the belt and ***protect bearings against off-center load conditions***



- Discreet needle fitting lubrication points in each bearing housing allows for lubrication of bearings while the conveyor is running, resulting in ***zero down time during lubrication***
- ***Precision bearing alignment*** is guaranteed within the pressed bearing assemblies that are piloted on body fitted studs, providing optimal conditions to ***move the heaviest loads*** in low profile conveyors
- ***Threaded tracking adjustment points*** provide simple responsive belt tracking that retain settings, even during belt removal
- Drive pulley is available in ***solid output design, dual solid output design***, or ***hex through shaft design***

Technical Data

Each of the myriad of applications that exist requires certain performance characteristics from the conveyor. QC Industries has developed a sizing system that condenses all of these parameters into a common factor, namely equivalent load.

A conveyor application that is accumulating a 5-pound load, for example, demands the conveyor to carry more than 5 pounds. As such, we have developed certain factors to add to the load that the conveyor needs to carry.

Follow the five steps below to determine the equivalent load your application requires. The result will then be used to help choose the gearmotor arrangement that will provide the correct torque.

1. Nominal Load 1. _____

Enter the total load in pounds the conveyor must carry. For example, (12) cartons weighing 10 pounds each would have a total nominal load of 120 lbs. Use Figure 10-A to cross-reference the width conveyor you desire with the nominal load you need to carry (to ensure it can carry the load). Each conveyor width listed shows a total load carrying capacity for both drive pushing and drive pulling applications. Enter nominal load (in pounds) on Line One.

2. Accumulation 2. _____

If the application does not have an accumulating load, enter zero on Line Two. Otherwise, multiply the nominal load from Line One times an accumulation factor. (0.2 for accumulation belts listed on page 20 and 0.3 for MAA standard urethane). Enter result on Line Two.

3. Incline/Decline [Factor] x [Load] = 3. _____

Some applications require an incline or decline. If the application does not require an incline or decline, enter zero on Line Three. For inclining or declining applications, choose a factor from Figure 10-B based upon the angle of incline then multiply that factor by the total nominal load from Line One. Enter result on Line Three.

4. Side Seals 4. _____

If the application does not call for side rails with seals to prevent small parts from getting under the rail, enter zero on Line Four. Otherwise, multiply the conveyor length in feet by 5. The side rails can be found on page 22. Example: 96" long conveyor with side seals would have a factor of 40 (8 x 5). Enter result on Line Four.

STOP

****Verify Load Capacity:**
After adding lines one through four together, please reference Figure 10-A to ensure that the conveyor width you desire will carry the sum of Lines One through Four. If the sum is greater than the load capacity listed for the width you have chosen, please choose a wider conveyor or consult factory.

5. Conveyor Friction 5. _____

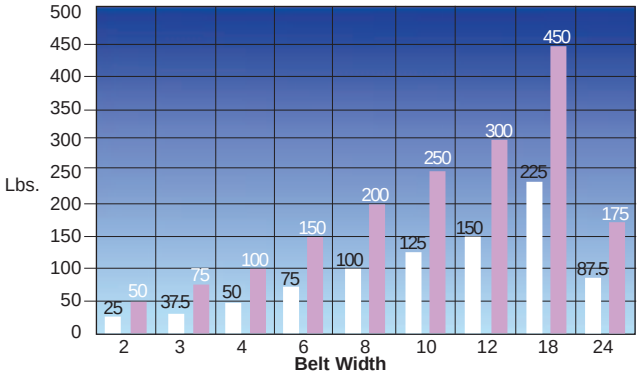
All conveyors have a certain amount of friction that must be added to the nominal load. To determine how much additional load must be factored in, add 4 to the conveyor width in inches, then multiply by 6, or simply choose the value from Figure 10-C. Enter result on Line Five.

Equivalent Load (lbs) SUM (1-5) _____ lbs.

Write down the equivalent load on your application assistance form (pages 116-117). The equivalent load will be needed to properly size a gearmotor for the conveyor. (See pages 30-37)

Next, proceed to the next page to construct the conveyor part number.

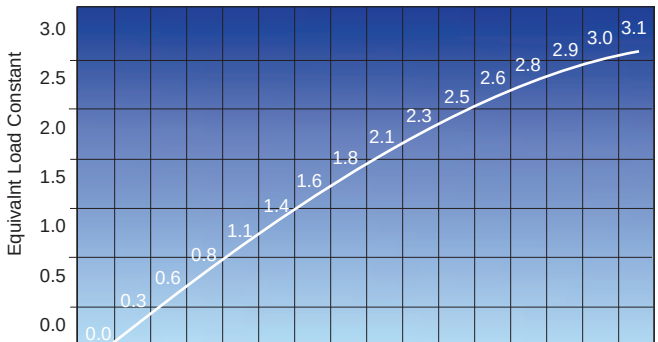
Load Carrying Capacity - Figure 10-A



Note: See page 11

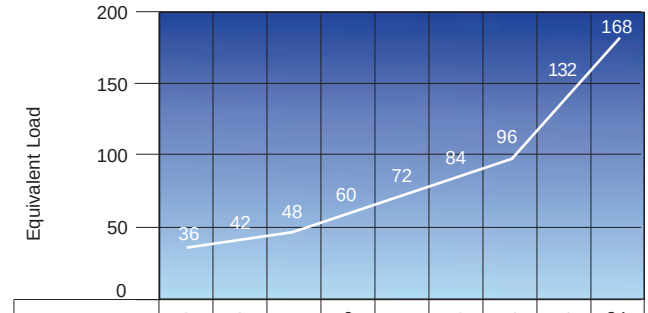
Above load carrying capacities are for both drive pushing and pulling applications.
Note: for drive pushing applications, decrease load capacity of conveyor by 1/2.

Incline/Decline Load Factors - Figure 10-B



Angle	0	5	10	15	20	25	30	35	40	45	50	55	60	65	70	75
Factor	0.0	0.3	0.6	0.8	1.1	1.4	1.6	1.8	2.1	2.3	2.5	2.6	2.8	2.9	3.0	3.1

Conveyor Friction - Figure 10-C



Conveyor Width	2	3	4	6	8	10	12	18	24
Frictional Load	36	42	48	60	72	84	96	132	168

How to Order

Step 1					Step 2				Step 3			Step 4		
Series	Drive Type	Construction	Frame	Frame Style	Width	Width	-	Length	Length	Length	-	Drive Location	Drive Pulley	Tail Pulley	-	Belt	Belt	Belt
1	E	S		H			-				-				-			

Step 1

Series	Drive Type	Construction	Frame	Frame Style
1 = 125	E = End Drive	S = Standard	B = 1.81” Powder Coat (Beige) E = 1.81” Stainless Steel Custom colors available - Contact factory	H = Straight Frame

Step 2

Widths

2”	3”	4”	6”	8”	10”	12”	18”	24”
02	03	04	06	08	10	12	18	24

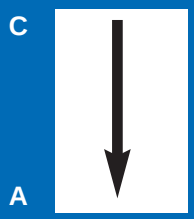
Lengths*

24”	36”	48”	60”	72”	96”	120”	144”
024	036	048	060	072	096	120	144

*Contact factory for special lengths

Step 3

Drive Location



A&B are drive **pulling**
C&D are drive **pushing**

Drive Pulley Type

Standard	Cap — 1/2” Dia* — Solid Output Shaft	S
Option see pg.41	Thru — 1/2” Hex — Hex Input	H
Option see pg.41	1/2” Dia* — 1/2” Dia* — Dual Output	D

Tail Pulley Type

Standard	Standard	Q
Option see pg.43	Rolling Nosebar	R
Option see pg.42	Detectable	D

* 1/8” sq. key included

Step 4

Choose three-digit belt ordering code on pages 20-21.

Example: 1ESBH02-048-ASQ-MAA
125 Series conveyor with standard construction and 1.81” powder coated frame. Conveyor measures 2” wide by 48” long with solid output pulley and standard tail pulley. The drive output shaft is in the A position. The conveyor has a standard urethane belt.

Optional: Snap-In Wiper is used with smooth surfaced, low friction belts for residue removal. This item snaps into the underside of the conveyor frame and can be installed at either end of the conveyor. Shown here on the drive end.

To Order:
Fill in the last two digits of the part number with the conveyor width

Part Number: 125-0192-WW

Example: 125-0192-08
Snap-In Wiper for an 8” wide conveyor

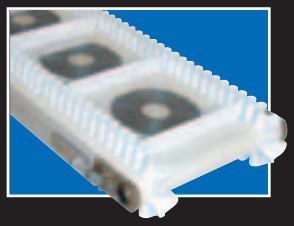
As standard, we assemble the conveyor, track the pre-tensioned belt and quality check every conveyor before we ship to the customer. Accessories such as Drives, Stands, Mounts, and Guides are packaged separately and are shipped unassembled with the conveyor to prevent damage during shipment. Complete assembly can be provided upon request; please contact our factory for details.

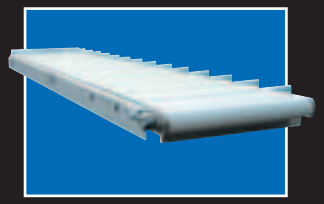
Note: proceed to page 22 to continue sizing your conveyor...

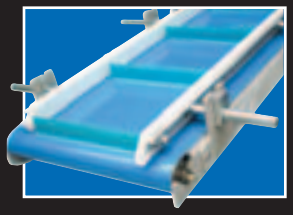
Specifications

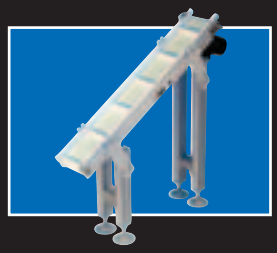
- Width 2” to 24”
- Length 24” to 144”
- Profile 1.89” high
- Drive Pulley 1.31” Diameter
- Load Carrying Capacity to 450 lbs.*
- Speed Range up to 225 fpm
- Multiple Cleat Heights Available

*See Technical Data on page 14



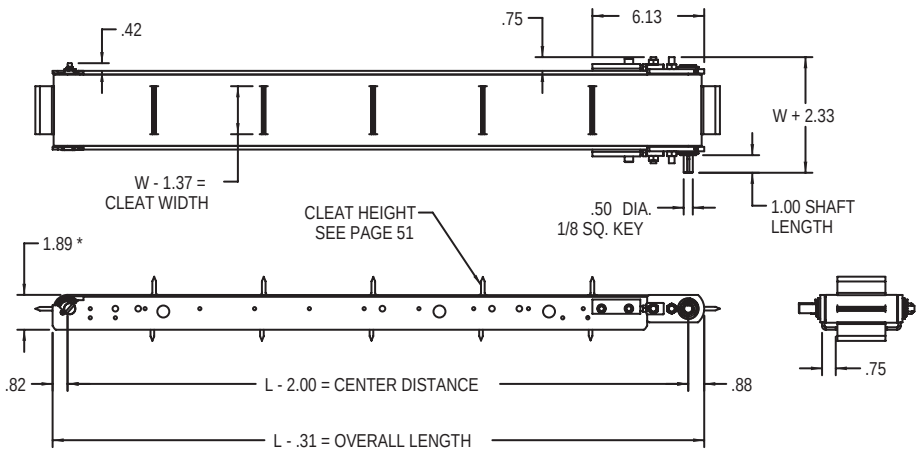






Overview Dimensions

Note: As in all industries, technical specifications will change with technology updates. Please contact factory or see www.qcindustries.com for the most up-to-date drawings.

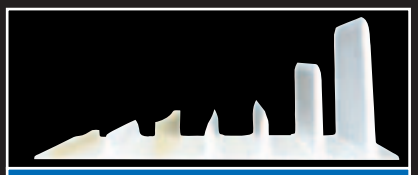


*Dimension reflects use of MAA belt. See pages 20-21.

Features & Benefits

Conveyor

- ***Low profile design*** provides tight product transfers and the ability to fit into space-constrained areas
- Single piece 10-gauge steel framework is laser cut and formed to create a **single-body frame construction**, ensuring frame integrity
- ***Tight tolerance belting*** and our unique snap-out sealed tail assembly provide for a ***quick belt change*** (less than 5 minutes) that is normally achieved without having to remove the drive packages or side rails
- ***High tensile strength cleated belts*** offer superior strength-to-weight ratio and are available in various styles and heights. Cleats are always ***high frequency welded*** to customer desired spacing and never glued to the top surface of the belt
- All components in our conveyors are produced on ***state-of-the-art manufacturing*** equipment

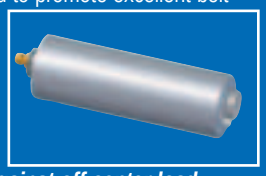


Multiple cleat sizes and styles available
See page 15 Step 4 for options

Corrugated sides available with 1 inch cleats

Tail Assembly

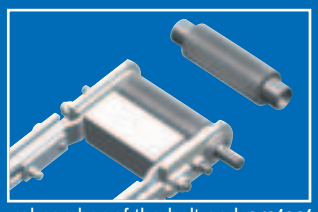
- ***Single point belt tension*** is achieved through a ***snap-in eccentric tail assembly*** designed to pull through the natural elongation characteristics of the belt and provide quick and easy belt change capacity
- ***Crowned sealed tail assembly*** is designed to promote excellent belt tracking and is equipped with superior ***needle bearings with seals*** that are filled with high performance grease



- ***Thrust washers*** designed into the tail assembly provide axial float, which allows the assembly to move with the natural camber of the belt and ***protect bearings against off-center load conditions***
- Grease fitting design in the tail assembly allows for lubrication of bearings while the conveyor is running, resulting in ***zero down time during lubrication***
- ***Precision bearing alignment*** is guaranteed within the pressed tail assembly, providing optimal conditions to ***move the heaviest loads*** in low profile conveyors
- Eccentric tracking bushing allows for ***single point tracking control*** at the idler end of the conveyor

Drive Assembly

- ***Straight knurl design used to prevent premature wear*** on the carcass of the belt and still provide superior grip to overcome start-up inertia
- ***Crowned sealed drive assembly*** designed to promote superior belt tracking, and is equipped with ***superior needle bearings with seals*** that are filled with high performance grease



- ***Thrust washers*** designed into the drive assembly provide axial float, which allows the assembly to move with the natural camber of the belt and ***protect bearings against off-center load conditions***
- Discreet needle fitting lubrication points in each bearing housing allows for lubrication of bearings while the conveyor is running, resulting in ***zero down time during lubrication***
- ***Precision bearing alignment*** is guaranteed within the pressed bearing assemblies that are piloted on body fitted studs, providing optimal conditions to ***move the heaviest loads*** in low profile conveyors
- ***Threaded tracking adjustment points*** provide simple responsive belt tracking that retain settings, even during belt removal
- Drive pulley is available in ***solid output design, dual solid output design,*** or ***hex through shaft design***

Technical Data

Each of the myriad of applications that exist requires certain performance characteristics from the conveyor. QC Industries has developed a sizing system that condenses all of these parameters into a common factor, namely equivalent load.

A conveyor application that is carrying a 5-pound load, for example, demands the conveyor to carry more than 5 pounds. As such, we have developed certain factors to add to the load that the conveyor needs to carry.

Follow the three steps below to determine the equivalent load your application requires. The result will then be used to help choose the gearmotor arrangement that will provide the correct torque.

1. Nominal Load 1. _____

Enter the total load in pounds the conveyor must carry. For example, (12) cartons weighing 10 pounds each would have a total nominal load of 120 lbs. Use Figure 14-A to cross-reference the width conveyor you desire with the nominal load you need to carry (to ensure it can carry the load). Each conveyor width listed shows a total load carrying capacity for both drive pushing and drive pulling applications. Enter nominal load (in pounds) on Line One.

2. Incline/Decline [Factor] x [Load] = 2. _____

Some applications require an incline or decline. If the application does not require an incline or decline, enter zero on Line Two. For inclining or declining applications, choose a factor from Figure 14-B based upon the angle of incline then multiply that factor by the total nominal load from Line One.

Enter result on Line Two.

STOP

****Verify Load Capacity:**
After adding lines One and Two together, please reference Figure 14-A to ensure that the conveyor width you desire will carry the sum of Lines One through Two. If the sum is greater than the load capacity listed for the width you have chosen, please choose a wider conveyor or consult factory.

3. Conveyor Friction 3. _____

All conveyors have a certain amount of friction that must be added to the nominal load. To determine how much additional load must be factored in, add 4 to the conveyor width in inches, then multiply by 6, or simply choose the value from Figure 14-C.

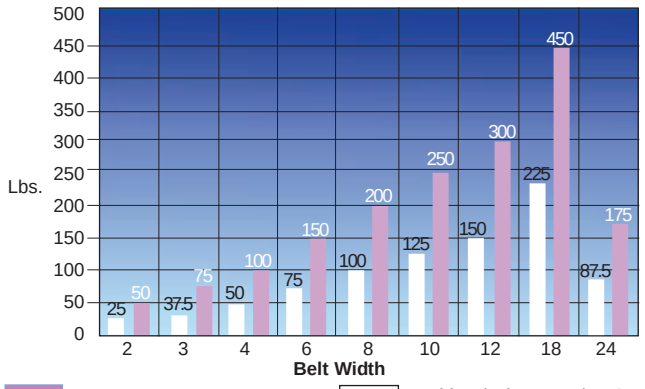
Enter result on Line Three.

Equivalent Load (lbs) SUM (1-3) _____ lbs.

Write down the equivalent load on your application assistance form (pages 116-117). The equivalent load will be needed to properly size a gearmotor for the conveyor. (See pages 30-37)

Next, proceed to the next page to construct the conveyor part number.

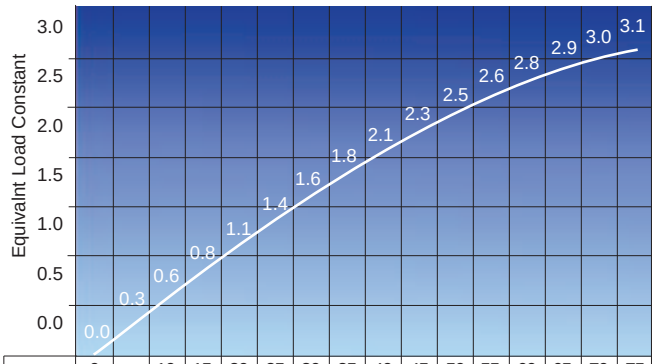
Load Carrying Capacity - Figure 14-A



Note: See page 15

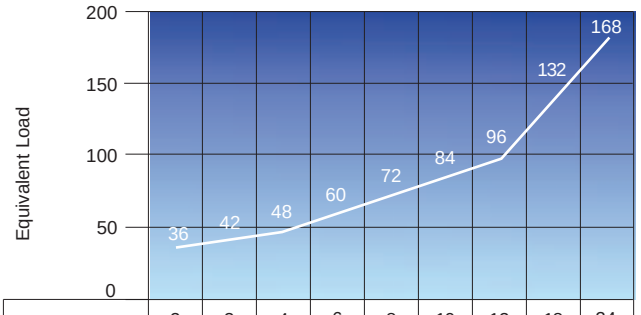
Above load carrying capacities are for both drive pushing and pulling applications.
Note: for drive pushing applications, decrease load capacity of conveyor by 1/2.

Incline/Decline Load Factors - Figure 14-B



Angle	0	5	10	15	20	25	30	35	40	45	50	55	60	65	70	75
Factor	0.0	0.3	0.6	0.8	1.1	1.4	1.6	1.8	2.1	2.3	2.5	2.6	2.8	2.9	3.0	3.1

Conveyor Friction - Figure 14-C



Conveyor Width	2	3	4	6	8	10	12	18	24
Frictional Load	36	42	48	60	72	84	96	132	168

How to Order

Step 1					Step 2			Step 3			Step 4			Step 5		
Series	Drive Type	Construction	Frame	Frame Style	Width	Width		Length	Length	Length	Drive Location	Drive Pulley	Tail Pulley	Belt	Belt	Belt	# of Cleats	# of Cleats	# of Cleats
1	E	S		H			-				-			-					

Step 1

Series	Drive Type	Construction	Frame	Frame Style
1 = 125	E = End Drive	S = Standard	B = 1.81" Powder Coat (Beige) E = 1.81" Stainless Steel Custom colors available - Contact factory	H = Straight Frame

Step 2

Widths

2"	3"	4"	6"	8"	10"	12"	18"	24"
02	03	04	06	08	10	12	18	24

Lengths*

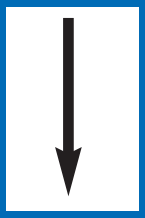
24"	36"	48"	60"	72"	96"	120"	144"
024	036	048	060	072	096	120	144

*Contact factory for special lengths

Step 3

Drive Location

C D



A B

A&B are drive **pulling**
C&D are drive **pushing**

Drive Pulley Type			Tail Pulley Type		
Standard	Cap 1/2" Dia* Solid Output Shaft	S	Standard	Standard	Q
Option see pg.41	Thru 1/2" Hex Hex Input	H	Option see pg.42	Detectable	D
Option see pg.41	1/2" Dia* 1/2" Dia* Dual Output	D			

* 1/8" sq. key included

Step 4

Choose a base belt material and cleat height

Base Belt Material	5mm	19mm	1/2"	3/4"	1" w/corr. sides	1"	2"	3"
MAA (Standard Urethane)	CAB	CAD	CAE	CAF	CAH	CAG	CAI	CAK
UAC (White Urethane)	CBB	CBD	CBE	CBF	CBH	CBG	CBI	CBK

Note 1: All belts must have a cleat indent of width minus 1.37", except 1" cleats with corrugated sidewall. That cleat indent is width minus 3.62"
Note 2: Cleated belts are intended for use in conjunction with indented or adjustable guides (see page 23)

Step 5

Determine the total number of cleats on the conveyor. Multiply conveyor length (in inches) by 2, divide by the desired spacing between the cleats (in inches). This will result in the total number of cleats evenly spaced around the circumference of the belt. Note: Must have a whole number of cleats.

Example: 1ESBH06-048-ASQ-CAE016
125 Series conveyor with standard construction and 1.81" powder coated frame. Conveyor measures 6" wide by 48" long with solid output pulley and standard tail pulley. The drive output shaft is in the A position. The conveyor belt has a 1/2" high cleat every 6".

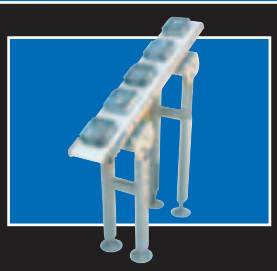
As standard, we assemble the conveyor, track the pre-tensioned belt and quality check every conveyor before we ship to the customer. Accessories such as Drives, Stands, Mounts, and Guides are packaged separately and are shipped unassembled with the conveyor to prevent damage during shipment. Complete assembly can be provided upon request; please contact our factory for details.

Note: proceed to page 22 to continue sizing your conveyor...

Specifications

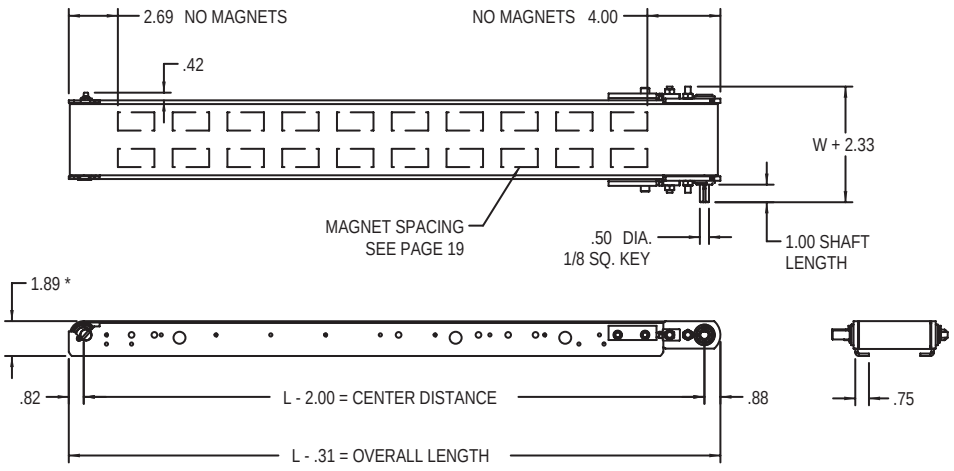
- Width 2” to 24”
- Length 24” to 144”
- Profile 1.89” high
- Drive Pulley 1.31” Diameter
- Load Carrying Capacity to 450 lbs.*
- Speed Range up to 225 fpm

*See Technical Data on page 18



Overview Dimensions

Note: As in all industries, technical specifications will change with technology updates. Please contact factory or see www.qcindustries.com for the most up-to-date drawings.

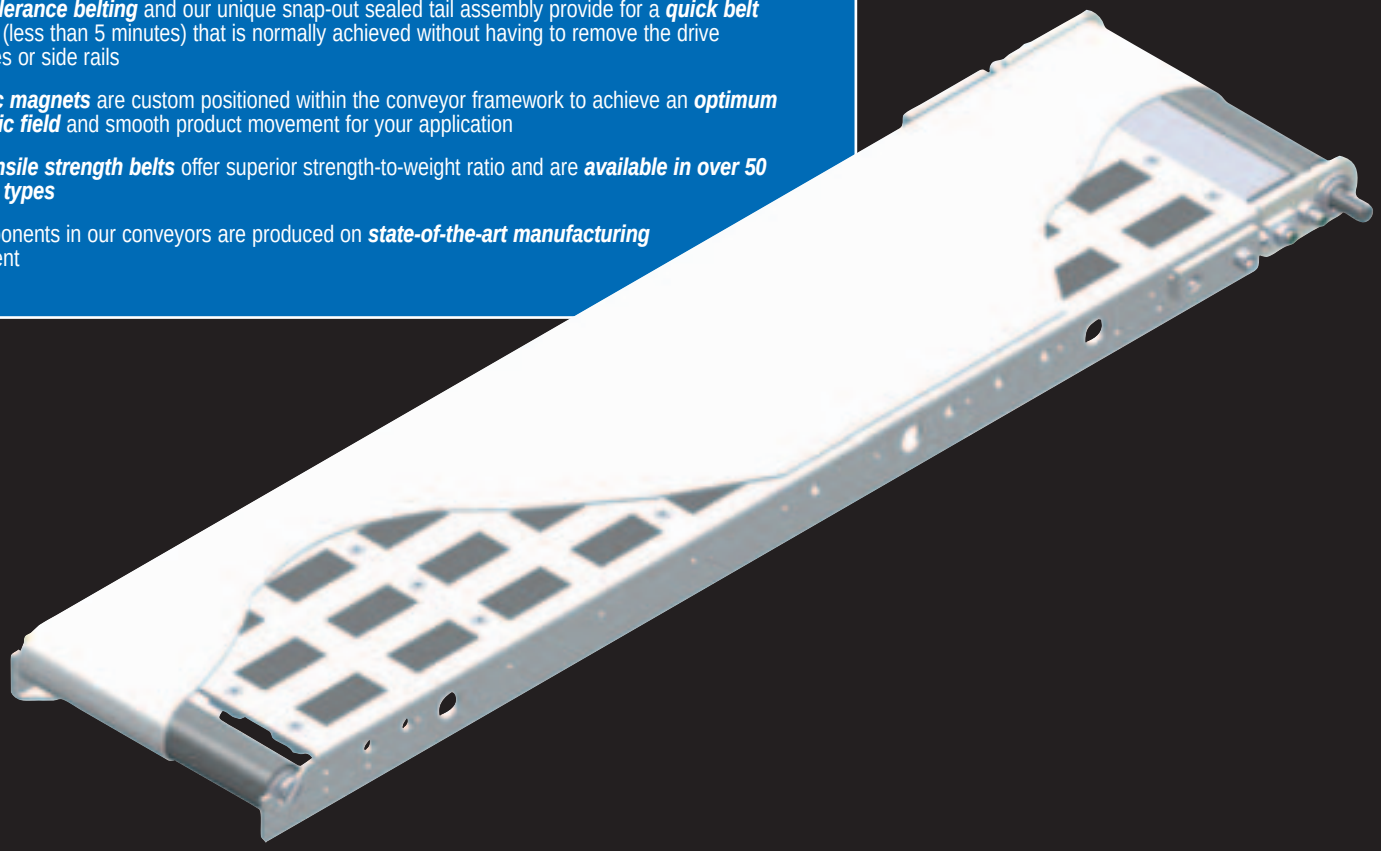


*Dimension reflects use of MAA belt. See pages 20-21.

Features & Benefits

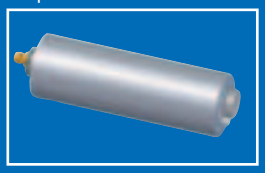
Conveyor

- ***Low profile design*** provides tight product transfers and the ability to fit into space-constrained areas
- Single piece 10-gauge stainless steel framework is laser cut and formed to create a **single-body frame construction**, ensuring frame integrity
- ***Tight tolerance belting*** and our unique snap-out sealed tail assembly provide for a ***quick belt change*** (less than 5 minutes) that is normally achieved without having to remove the drive packages or side rails
- ***Ceramic magnets*** are custom positioned within the conveyor framework to achieve an ***optimum magnetic field*** and smooth product movement for your application
- ***High tensile strength belts*** offer superior strength-to-weight ratio and are ***available in over 50 various types***
- All components in our conveyors are produced on ***state-of-the-art manufacturing*** equipment



Tail Assembly

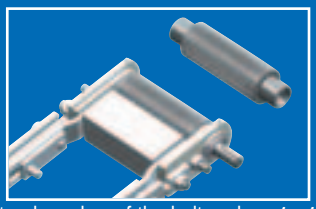
- ***Single point belt tension*** is achieved through a ***snap-in eccentric tail assembly*** designed to pull through the natural elongation characteristics of the belt and provide quick and easy belt change capacity
- ***Crowned sealed tail assembly*** is designed to promote excellent belt tracking and is equipped with superior ***needle bearings with seals*** that are filled with high performance grease



- ***Thrust washers*** designed into the tail assembly provide axial float, which allows the assembly to move with the natural camber of the belt and ***protect bearings against off-center load conditions***
- Grease fitting design in the tail assembly allows for lubrication of bearings while the conveyor is running, resulting in ***zero down time during lubrication***
- ***Precision bearing alignment*** is guaranteed within the pressed tail assembly, providing optimal conditions to ***move the heaviest loads*** in low profile conveyors
- Eccentric tracking bushing allows for ***single point tracking control*** at the idler end of the conveyor

Drive Assembly

- ***Straight knurl design used to prevent premature wear*** on the carcass of the belt and still provide superior grip to overcome start-up inertia
- ***Crowned sealed drive assembly*** designed to promote superior belt tracking, and is equipped with ***superior needle bearings with seals*** that are filled with high performance grease



- ***Thrust washers*** designed into the drive assembly provide axial float, which allows the assembly to move with the natural camber of the belt and ***protect bearings against off-center load conditions***
- Discreet needle fitting lubrication points in each bearing housing allows for lubrication of bearings while the conveyor is running, resulting in ***zero down time during lubrication***
- ***Precision bearing alignment*** is guaranteed within the pressed bearing assemblies that are piloted on body fitted studs, providing optimal conditions to ***move the heaviest loads*** in low profile conveyors
- ***Threaded tracking adjustment points*** provide simple responsive belt tracking that retain settings, even during belt removal
- Drive pulley is available in ***solid output design, dual solid output design,*** or ***hex through shaft design***

Technical Data

Each of the myriad of applications that exist requires certain performance characteristics from the conveyor. QC Industries has developed a sizing system that condenses all of these parameters into a common factor, namely equivalent load.

A conveyor application that is carrying a 5-pound load, for example, demands the conveyor to carry more than 5 pounds. As such, we have developed certain factors to add to the load that the conveyor needs to carry.

Follow the five steps below to determine the equivalent load your application requires. The result will then be used to help choose the gearmotor arrangement that will provide the correct torque.

1. Nominal Load 1. _____

Enter the total load in pounds the conveyor must carry. For example, (12) metal parts weighing 10 pounds each would have a total nominal load of 120 lbs. Use Figure 18-A to cross-reference the width conveyor you desire with the nominal load you need to carry (to ensure it can carry the load). Each conveyor width listed shows a total load carrying capacity for both drive pushing and drive pulling applications. Enter nominal load (in pounds) on Line One.

2. Magnetic Factor 2. _____

To achieve magnetic pull, there are rows of magnets down the length of the conveyor. The maximum number of rows can be determined by dividing the conveyor width by two (not to exceed eight rows). Choose the number of magnet rows and then multiply the load by the factor from Figure 18-B. Enter result on Line Two.

3. Incline/Decline [Factor] x [Load] = 3. _____

Some applications require an incline or decline. If the application does not require an incline or decline, enter zero on Line Three. For inclining or declining applications, choose a factor from Figure 18-C based upon the angle of incline then multiply that factor by the total nominal load from Line One. Enter result on Line Three.

4. Side Seals 4. _____

If the application does not call for side rails with seals to prevent small parts from getting under the rail, enter zero on Line Four. Otherwise, multiply the conveyor length in feet by 5. The side rails can be found on page 22. Example: 96" long conveyor with side seals would have a factor of 40 (8 x 5). Enter result on Line Four.

STOP

****Verify Load Capacity:**
After adding lines one through four together, please reference Figure 18-A to ensure that the conveyor width you desire will carry the sum of Lines One through Four. If the sum is greater than the load capacity listed for the width you have chosen, please choose a wider conveyor or consult factory.

5. Conveyor Friction 5. _____

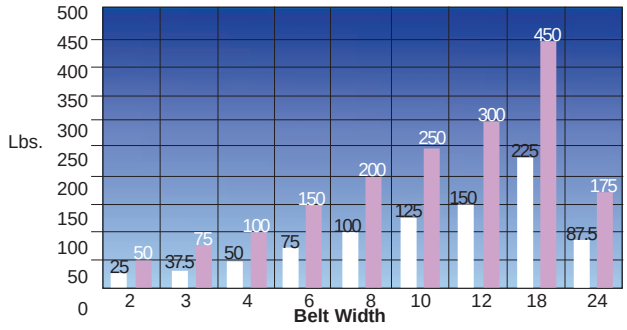
All conveyors have a certain amount of friction that must be added to the nominal load. To determine how much additional load must be factored in, add 4 to the conveyor width in inches, then multiply by 6, or simply choose the value from Figure 18-D. Enter result on Line Five.

Equivalent Load (lbs) SUM (1-5) _____ lbs.

Write down the equivalent load on your application assistance form (pages 116-117). The equivalent load will be needed to properly size a gearmotor for the conveyor. (See pages 30-37)

Next, proceed to the next page to construct the conveyor part number.

Load Carrying Capacity - Figure 14-A

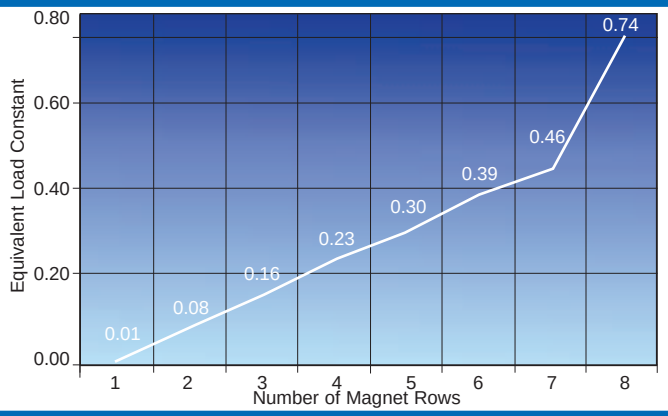


Pulling (Drive Location A&B) Pushing (Drive Location C&D)

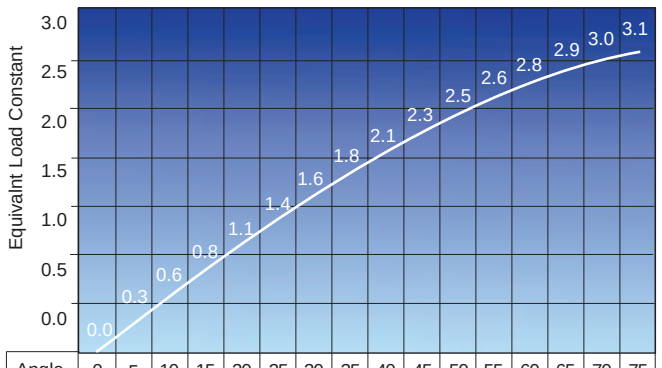
Note: See page 19

Above load carrying capacities are for both drive pushing and pulling applications. Note: for drive pushing applications, decrease load capacity of conveyor by 1/2.

Magnetic Load Factors - Figure 18-B

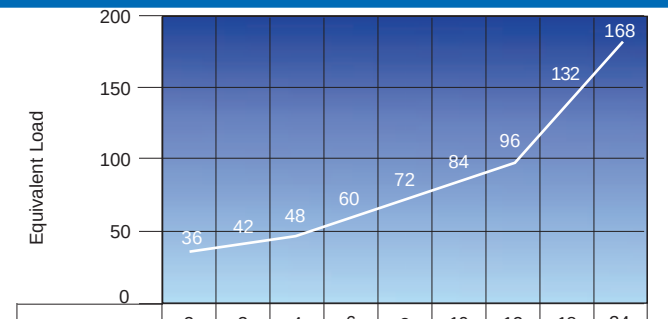


Incline/Decline Load Factors - Figure 18-C



Angle	0	5	10	15	20	25	30	35	40	45	50	55	60	65	70	75
Factor	0.0	0.3	0.6	0.8	1.1	1.4	1.6	1.8	2.1	2.3	2.5	2.6	2.8	2.9	3.0	3.1

Conveyor Friction - Figure 18-D



Conveyor Width	2	3	4	6	8	10	12	18	24
Frictional Load	36	42	48	60	72	84	96	132	168

How to Order

Step 1					Step 2			Step 3			Step 4			Step 5			
Series	Drive Type	Construction	Frame	Frame Style	Width	Width	Length	Length	Length	Drive Location	Drive Pulley	Tail Pulley	Belt	Belt	Belt	Number of rows	6" Section from Tail	6" Sections on Row	Row Spacing
1	E	M	E	H			-			-			-			-	See Step 5 below		

Consult factory

Step 1

Series	Drive Type	Construction	Frame	Frame Style
1 = 125	E = End Drive	M = Magnetic	E = 1.81" Stainless Steel	H = Straight Frame

Step 2

Widths

2"	3"	4"	6"	8"	10"	12"	18"	24"
02	03	04	06	08	10	12	18	24

Lengths*

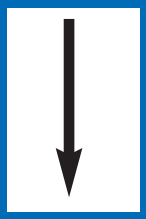
24"	36"	48"	60"	72"	96"	120"	144"
024	036	048	060	072	096	120	144

*Contact factory for special lengths

Step 3

Drive Location

C D



A B

A&B are drive **pulling**
C&D are drive **pushing**

Drive Pulley Type			Tail Pulley Type		
Standard	Cap — Solid Output Shaft — 1/2" Dia*	S	Standard	Standard	Q
Option see pg.41	Thru — Hex Input — 1/2" Hex	H	Option see pg.42	Detectable	D
Option see pg.41	1/2" Dia* — Dual Output — 1/2" Dia*	D			

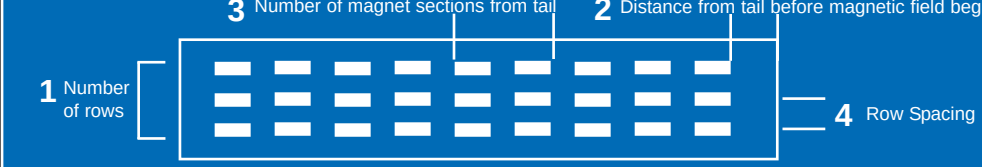
* 1/8" sq. key included

Step 4

Choose three-digit belt ordering code on page 20 and 21.

Step 5

Please send the part to be conveyed to our Sales Department to evaluate for proper magnetic arrangement. Ceramic magnets are positioned in a stainless steel frame according to each application. This permits a wide variety of magnetic field strengths and location options. Our application specialists will complete the part number for you. Below is an illustration of how we document the magnet spacing.



As standard, we assemble the conveyor, track the pre-tensioned belt and quality check every conveyor before we ship to the customer. Accessories such as Drives, Stands, Mounts, and Guides are packaged separately and are shipped unassembled with the conveyor to prevent damage during shipment. Complete assembly can be provided upon request; please contact our factory for details.

Note: proceed to page 22 to continue sizing your conveyor...

Belt Selection Guide

	Belt Ordering Code	Top Surface Description	Top Surface Material	Belt Color	FDA	Topside Coefficient of Friction (CoF)	Short Term Part Max Temperature (°F)	Max. Ambient Operating Temperature (°F)	Anti-Static	Average Belt Thickness (inches)
Multi-Purpose Belts										
A. Standard Urethane	**MAA**	Smooth	Urethane	White	YES	LOW	212	176	YES	0.075
B. Option #1-Sealed Edge Standard Urethane	**MAB**	Smooth, Sealed Edge	Urethane	White	YES	LOW	212	176	YES	0.075
C. Option #2-Spill Edge Cleat	**MAC**	Longitudinal Serrated Cleat	Urethane	White	YES	LOW	212	176	YES	0.075
D. Option #3-Perforated Belt	**MAD**	Smooth, Perforations	Urethane	White	YES	LOW	212	176	YES	0.075
High Friction Belts										
A. Grey Diamond Top High Adhesion	**FAA**	Snakeskin	PVC	Light Grey	NO	HIGH	212	176	NO	0.103
B. Green High Tack PVC	**FAB**	Matte	PVC Soft	Dark Green	NO	HIGH	212	176	YES	0.145
C. Beige FDA High Adhesion	**FAC**	Smooth	Silicone	Beige	YES	HIGH	212	176	YES	0.072
D. Black Lateral Grooved High Adhesion	**FAD**	Longitudinal Groove	PVC	Black	NO	HIGH	194	158	YES	0.083
E. Black Rough Top High Adhesion	**FAF**	Rough Top	PVC	Black	NO	HIGH	212	176	YES	0.185
Accumulation Belts (Low Friction)										
A. White FDA Fabric Accumulator	**AAA**	Fabric	Urethane	White	YES	VERY LOW	212	176	YES	0.054
C. Black Tight Weave Accumulator	**AAC**	Fabric	Urethane Impregnated	Black	NO	VERY LOW	248	212	NO	0.051
D. Grey Textured Urethane Accumulator	**AAD**	Textured	Urethane Impregnated	Light Grey	NO	VERY LOW	140	140	YES	0.060
E. Green FDA Fabric Accumulator	**AAE**	Fabric	Urethane Impregnated	Dark Green	YES	VERY LOW	175	175	YES	0.054
Heat-Resistant Belts										
A. White Silicone Heat Resistor	**HAA**	Fine Texture	Silicone	White	NO	MED	356	356	YES	0.059
B. White Silicone Translucent Resistor	**HAB**	Fabric	Silicone Impregnated	White	NO	LOW	356	356	YES	0.051
C. Smooth White FDA Silicone Heat Resistor	**HAC**	Smooth	Silicone	White	YES	MED	400	350	NO	0.085
D. Blue Nitrile Heat Resistor	**HAD**	Coarse Structure	Nitrile Rubber	Blue	NO	MED	300	212	YES	0.079
E. White Nitrile Heat Resistor	**HAE**	Smooth	Nitrile Rubber	White	NO	MED	300	212	YES	0.067
Cut Resistant Belts										
A. Yellow Cut Resistor	**IAA**	Smooth	Urethane	Yellow	NO	LOW	230	194	YES	0.060
B. Standard Urethane	**IAB**	Smooth	Urethane	White	YES	LOW	212	176	YES	0.075
C. Black Dimple Top Cut Resistor	**IAC**	Dimple Top	Hard Urethane	Black	NO	HIGH	248	212	YES	0.083
D. Rugged Poly Cut Resistor	**IAD**	Structured	Nitrile Rubber	Black	NO	MED	176	176	YES	0.100
FDA Belts										
A. Standard Urethane	**UAA**	Smooth	Urethane	White	YES	LOW	212	176	YES	0.075
B. Sealed Edge Standard Urethane	**UAB**	Smooth, Sealed Edge	Urethane	White	YES	LOW	212	176	YES	0.075
C. Pure White FDA	**UAC**	Matte	Urethane	White	YES	LOW	230	194	YES	0.061
D. Woven White FDA	**UAD**	Smooth	Urethane Impregnated	Translucent	YES	MED	248	212	YES	0.047
E. White FDA Urethane High Adhesion	**UAE**	Smooth	Urethane	White	YES	HIGH	176	176	YES	0.050
Static Conductive Belts										
A. Textured Carbon Impregnated	**EAA**	Textured	Urethane Impregnated	Black	NO	MED	212	176	$10^4\Omega$	0.063
B. Accumulation Static Conductive	**EAB**	Rough Texture	Nitrile Rubber	Black	NO	HIGH	212	212	$10^4\Omega$	0.080
C. Low Friction Static Conductive	**EAC**	Smooth	Urethane	Black	NO	LOW	158	158	$10^5\Omega$	0.040
D. Structured Static Conductive	**EAD**	Structured	NBR Impregnated Fleece	Black	NO	MED	176	176	$10^5\Omega$	0.100
Translucent Belts										
A. Green Translucent Accumulator	**TAA**	Textured	Impregnated PU	Light Green	YES	VERY LOW	175	175	NO	0.023
B. FDA Fabric Translucent Accumulator	**TAB**	Fabric	Urethane Impregnated	Translucent	YES	VERY LOW	248	212	NO	0.024
C. Silicone Translucent Accumulator	**TAC**	Textured	Silicone	Translucent	YES	VERY LOW	176	176	NO	0.040
Color Contrasting Belts										
A. Gray Textured Contraster	**PAA**	Textured	PVC	Grey	NO	MED	158	158	YES	0.060
B. Smooth Green Urethane Contraster	**PAB**	Smooth	Urethane	Green	YES	LOW	176	176	YES	0.050
C. Dark Green PVC Contraster	**PAC**	Matte	PVC	Dark Green	NO	MED	212	176	YES	0.075
D. Light Blue Urethane Contraster	**PAD**	Matte	Urethane	Light Blue	YES	MED	212	176	YES	0.063
E. Smooth Black PVC Contraster	**PAE**	Smooth	PVC	Black	NO	MED	212	176	NO	0.071
Non-Marking Belts										
A. Felt Topped Product Protector	**NAA**	Felt	Felt	White	YES	MED	175	175	NO	0.070
B. Fabric Topped Product Protector	**NAB**	Fabric	Spun Polyester	White	YES	MED	175	175	NO	0.067
C. Cotton Topped Product Protector	**NAC**	Fabric	Cotton	Natural White	YES	MED	175	175	NO	0.072
D. Black Elastomer Product Protector	**NAD**	Felt	Polyester	Black	NO	MED	302	248	YES	0.098
Release Properties Belts										
A. Beige Silicone Product Release	**RAA**	Smooth	Silicone	Beige	YES	HIGH	212	176	YES	0.072
B. White PVC Product Release	**RAB**	Matte, Smooth	Non-Stick PVC	White	YES	LOW	194	158	YES	0.059
C. Textured Silicone Product Release	**RAC**	Fine Texture	Silicone	White	NO	MED	356	356	YES	0.059
D. Smooth Habilene Product Release	**RAD**	Smooth	Habilene	White	YES	MED	176	176	YES	0.090
E. Smooth Silicone Product Release	**RAE**	Textured	Silicone	White	YES	LOW	176	176	NO	0.040
Specialty/Profile Belts										
A. Green Sawtooth Profile Belt	**SAA**	Sawtooth	PVC	Green	NO	HIGH	212	176	YES	0.177
B. White Grooved Rubber	**SAB**	Lateral Groove	Nitrile Rubber	White	YES	HIGH	225	225	NO	0.210
C. Stipple Top PVC Profile	**SAC**	Stipple Top	PVC	White	YES	MED	212	176	NO	0.106
D. Negative Pyramid Profile	**SAD**	Textured	Urethane	White	YES	MED	212	176	YES	0.078
E. Green Longitudinal PVC Profile Belt	**SAE**	Longitudinal Groove	PVC	Green	NO	HIGH	175	175	YES	0.175

Chemical Resistant Belts

Due to the broad spectrum of chemicals and percentages of chemical mixtures, QC Industries offers belt selection assistance in chemical application circumstances. Our application specialists will help determine which belt is best suited to withstand the chemicals present as well as the entire scope of the application parameters. This approach delivers the best possible product for the application.

QC Industries offers conveyor belting for a wide variety of applications and industries. These pages cover a number of the more popular belts we have provided through the years. These belts have all been tested at QC Industries and offer a compatible fit to the 125 Series conveyors. If you have a specific need that is not covered on these pages, please contact one of our sales engineers directly at the factory to discuss your application parameters.

To Order With Conveyor:
Please use the three-digit QC belt code number for conveyor ordering on pages 11, 15, and 19.

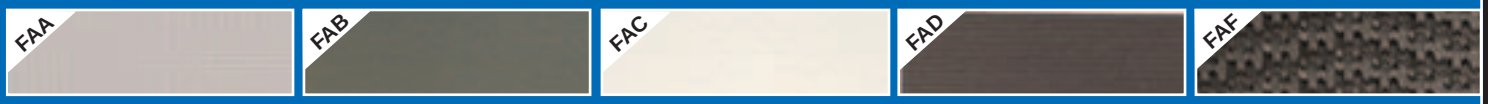
To Order Belt Only:
Choose nominal conveyor width and length in inches and enter the three-digit belt code.

1E - WW - LLL - □□□

Example: 1E-08-120-MAA
Standard urethane belt for an 8" wide by 120" long 125 Series conveyor

Multi-Purpose Belts

High-Friction Belts



Accumulation Belts (Low Friction)

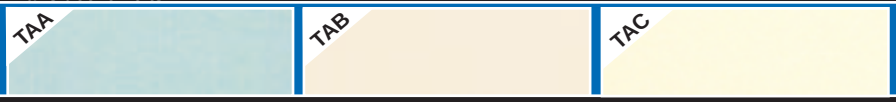
Heat-Resistant Belts

Cut-Resistant Belts

FDA/USDA Belts

Static Conductive Belts

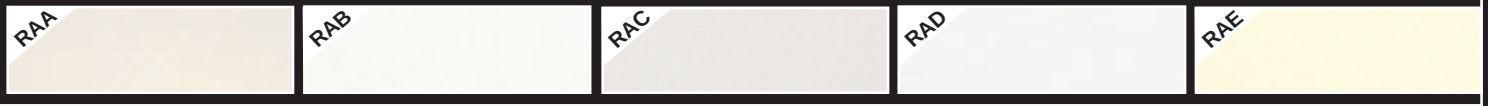
Translucent Belts



Color Contrasting Belts

Non-Marking Belts

Release Properties Belts



Specialty/Profile Belts

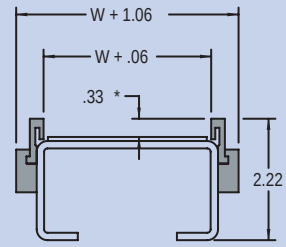
Chemical Resistant Belts

Due to the wide variety of chemical and percentages of chemical mixtures, QC Industries offers belt selection assistance in these application circumstances. Our application specialists will help determine which belt is best suited to withstand not only the chemicals present, but the entire scope of the application parameters. This approach delivers the best possible product for the application.

Fixed Side Rails

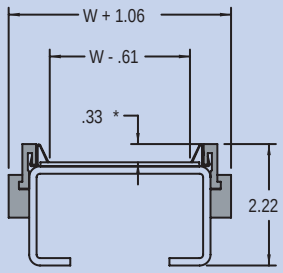
1/3" Side Rails

125-0169 pictured



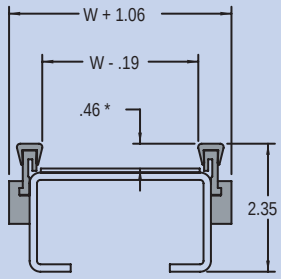
Aluminum extruded 1/3" high sides
Part No. 125-0153-□□□

To Order:
Fill in the last three digits of the part number with the nominal conveyor length in inches.
Ex. 125-0153-048



Aluminum extruded 1/3" high sides with seals**
Part No. 125-0169-□□□

To Order:
Fill in the last three digits of the part number with the nominal conveyor length in inches.
Ex. 125-0169-096

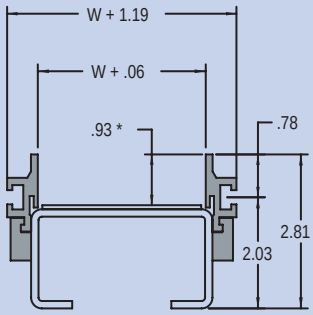


Aluminum extruded 1/3" high sides with wear strip
Part No. 125-0170-□□□

To Order:
Fill in the last three digits of the part number with the nominal conveyor length in inches.
Ex. 125-0170-024

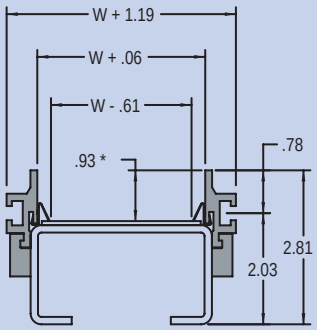
1" Side Rails

125-0178 pictured



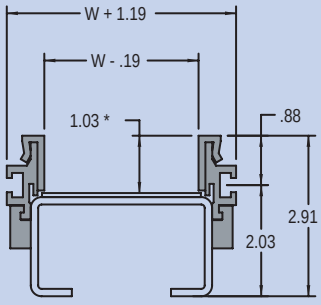
Aluminum extruded 1" high sides
Part No. 125-0174-□□□

To Order:
Fill in the last three digits of the part number with the nominal conveyor length in inches.
Ex. 125-0174-048



Aluminum extruded 1" high sides with seals**
Part No. 125-0177-□□□

To Order:
Fill in the last three digits of the part number with the nominal conveyor length in inches.
Ex. 125-0177-024

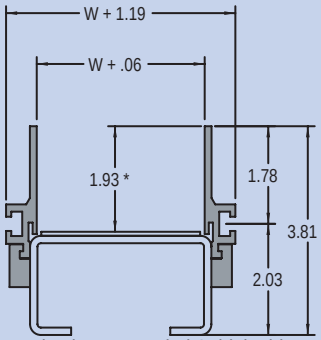


Aluminum extruded 1" high sides with wear strip
Part No. 125-0178-□□□

To Order:
Fill in the last three digits of the part number with the nominal conveyor length in inches.
Ex. 125-0178-096

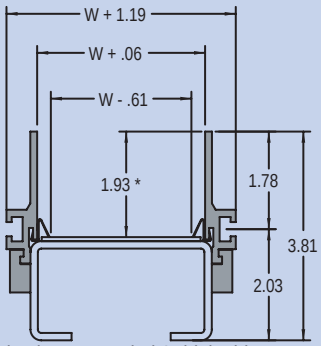
2" Side Rails

125-0215 pictured



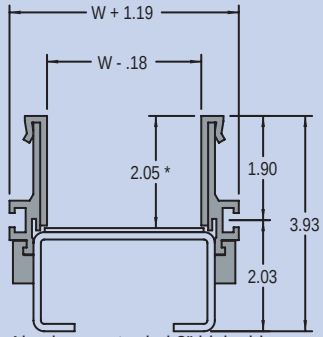
Aluminum extruded 2" high sides
Part No. 125-0215-□□□

To Order:
Fill in the last three digits of the part number with the nominal conveyor length in inches.
Ex. 125-0215-024



Aluminum extruded 2" high sides with seals**
Part No. 125-0217-□□□

To Order:
Fill in the last three digits of the part number with the nominal conveyor length in inches.
Ex. 125-0217-036



Aluminum extruded 2" high sides with wear strip
Part No. 125-0216-□□□

To Order:
Fill in the last three digits of the part number with the nominal conveyor length in inches.
Ex. 125-0216-060

Note 1: W = nominal belt width in inches
Note 2: All rails are sold in sets
Note 3: Side rails start 1 11/16" from tail end and stop 3 1/2" from drive end

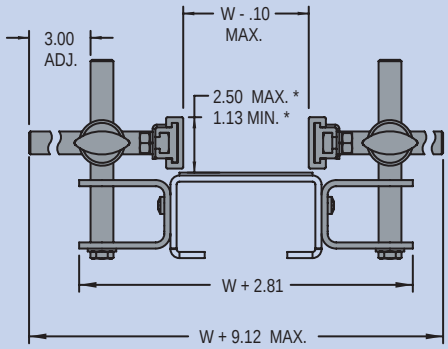
* Dimension reflects use of standard urethane belt (MAA) see page 20
** Side seals are not intended for cleated belts, high friction belts, or belt speeds exceeding 30 FPM

Custom fixed and flared side rails are available. For heights, consult factory

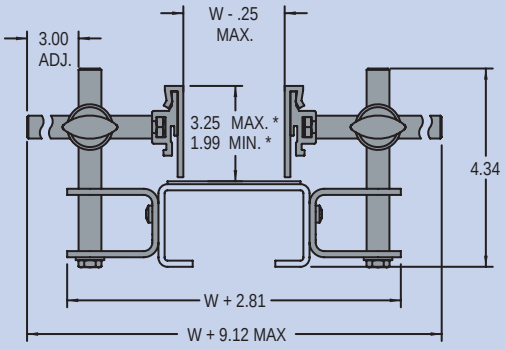
Adjustable Guide Rails

2-Axis Adjustable Guides

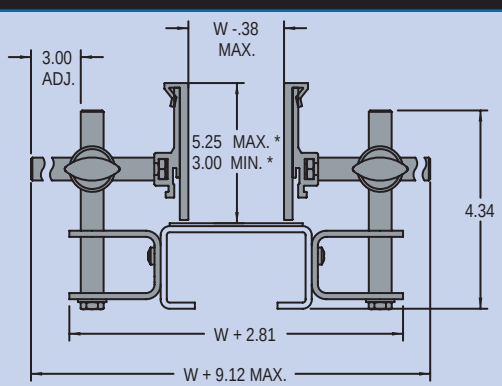
125-0281-048-T pictured



1" High 2-Axis Adjustable Guides
Part No. 125-0281-□□□-□



2" High 2-Axis Adjustable Guides
Part No. 125-0282-□□□-□



3" High 2-Axis Adjustable Guides
Part No. 125-0283-□□□-□

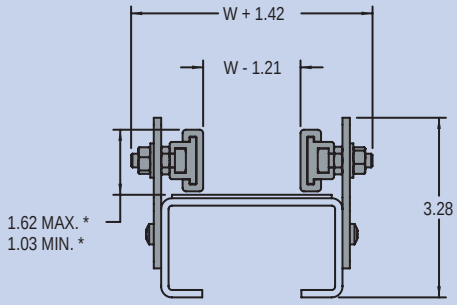
To Order:
Fill in the last three digits of part number with the nominal length of the conveyor. Choose a set screw adjustment or a thumb wheel adjustment mechanism by indicating (S) for set screw and (T) for thumb wheel at the end of the part number.

Example 125-0281-120 -T
1" adjustable guide rail with wear strip and thumb wheel adjustment for a 120" long conveyor.

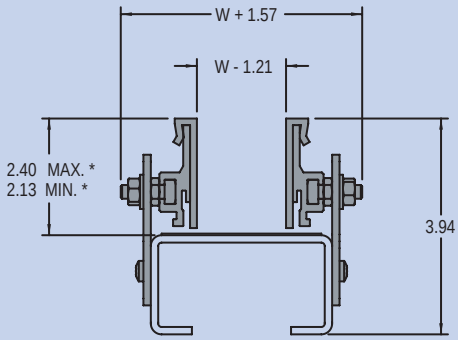
The 2-Axis Adjustable Guides are designed to guide the product being conveyed. The rails can adjust vertically and horizontally, offering the end user the ultimate in flexibility. Choose from a set screw or thumb wheel adjustment. The thumb wheel is shown in the above picture and is ideal for quick adjustments, because no tools are required.

Indented Guides

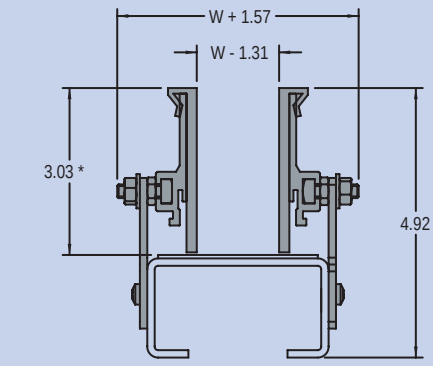
125-0219 pictured



1" High Indented Guide Assembly
Part No. 125-0219-□□□



2" High Indented Guide Assembly
Part No. 125-0218-□□□



3" High Indented Guide Assembly
Part No. 125-0222-□□□

To Order:
Fill in the last three digits of part number with the nominal conveyor length in inches.

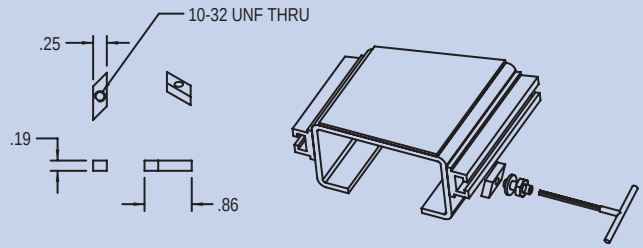
Example 125-0219-120
1" adjustable guide rail with wear strip for a 120" long conveyor.

The Indented Guides are designed to work with cleated belts. Each cleated belt is indented slightly (see page 15). The Indented Guide spans the indentation, providing a pocket which surrounds the product being conveyed.

*Dimension reflects use of MAA belt. See pages 20-21.

Tee Slotted Extrusions

Rotate-In Tee Nut



Rotate-In Tee Nut
Part No. 125-0074-035 (Qty 1)
Part No. 125-0074-035-SET (Qty 4)

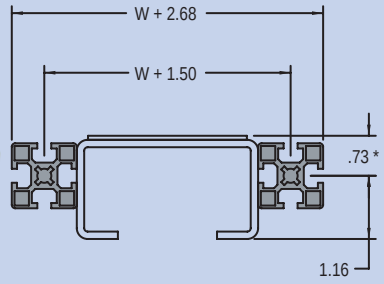
Note:
The Rotate-In Tee Nut works with the 1" and 2" side rails shown on page 22, as well as the Single Tee Slot and the Multi Tee Slot extrusions shown below.

To Order:
Use part number
125-0074-035 (Qty. 1)
125-0074-035-SET (Qty. 4)

The Rotate-In Tee Nut is designed to hold lightweight brackets that have a thickness of .148" or under

The Rotate-In Tee Nut can be used with the following rails and bolt on profiles:
1" - 125-0174, 125-0177, 125-0178
2" - 125-0215, 125-0217, 125-0216
Tee - 125-0225, 125-0199

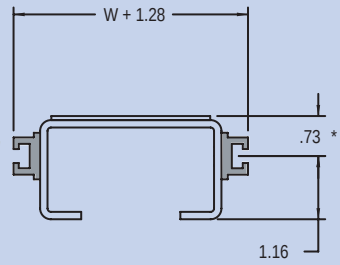
Multi Tee Slot



Multi Tee Slot Side Assembly
Part No. 125-0225-□□□

To Order:
Fill in last three digits of part number with the nominal conveyor length in inches. Part number includes one set as shown in drawing.

Single Tee Slot

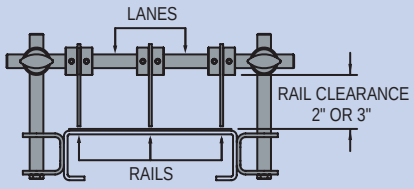


Single Tee Slot Side Assembly
Part No. 125-0199-□□□

To Order:
Fill in last three digits of part number with the nominal conveyor length in inches. Part number includes one set as shown in drawing.

Product Containment Accessories

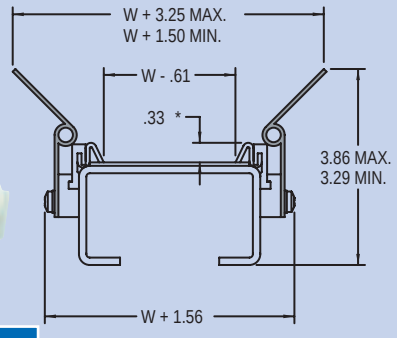
Lane Dividers



Lane Dividers
For part number see below

Hinged Side Extenders

Shown with 1/3" side rail with seal



Hinged Side Extenders
For part number see below

To Order:
LD-□-□□□□□-□□□S

- S — Construction (S - Standard)
- F or T — Mounting Type (F - Frame or T - Tee slot)
- 2,3,4 etc — # of Lanes (2,3,4 etc)
- 1, 2, 3 etc — # of Rails (1, 2, 3 etc)
- Conveyor Length (in inches)
- Conveyor Width (in inches)
- 2" or 3" — Rail Clearance Height (2" or 3")

Example
LD-2-08144-12FS
2" Lane Divider for 8" wide 144" long conveyor. One rail with two lanes mounted to the conveyor frame

To Order:

Hinged Side Extenders bolt directly onto the frame of the conveyor, and can be used in conjunction with 1/3" side rails. Only available in 24" and 36" lengths.

36" Long Part No. 125-1003-036
24" Long Part No. 125-1003-024

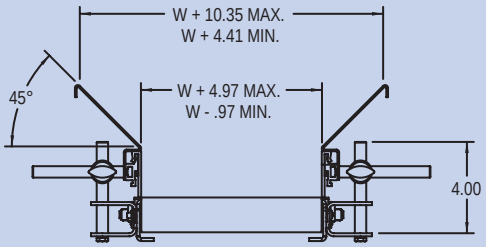
Note:
To obtain a longer length of hinged side, please use combinations of 24" and 36" lengths. However, all length combinations must equal 12" less than the nominal conveyor length.

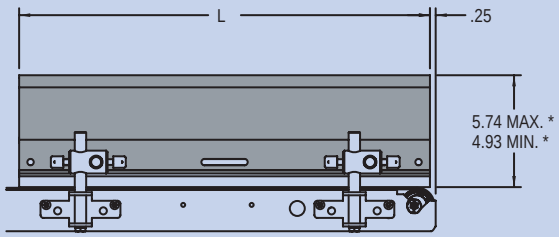
*Dimension reflects use of MAA belt. See pages 20-21.

Flared Side Rails

Flared Side Rails

Note: Shown with 2-axis adjustable guide (sold separately) Part # 125-0282-LLL-S





L = length of flared side rails

Flared Side Rails are ideal for applications that require a "drop zone" wider than the width of the conveyor. The rails attach to and require the use of the adjustable guide rails shown at the top of page 23. Additionally, the user can add other components (shown below) to help guide the product as needed. Note: Flared Side Rails should be ordered one size smaller than the nominal length of the conveyor.

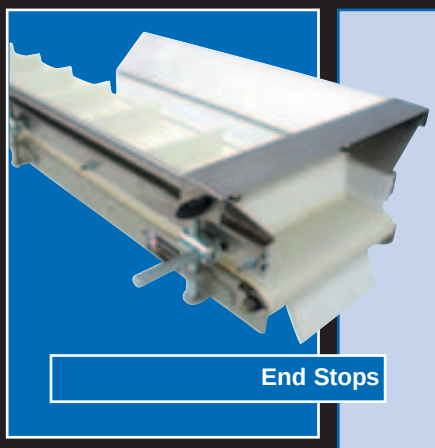
To Order:

Z-1004-012	12" length
Z-1004-018	18" length
Z-1004-024	24" length
Z-1004-030	30" length
Z-1004-036	36" length
Z-1004-042	42" length
Z-1004-048	48" length

Example:
(1) Z-1004-036
A set of 36" long flared side rails

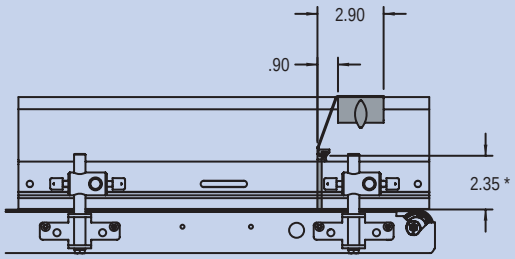
The rails are sold in sets and include mounting hardware

Note: Requires Part #125-0282-LLL-S shown on page 23



End Stops

Note: Shown with 2-axis adjustable guide AND Flared Side Rails (both sold separately) Part # 125-0282-LLL-S, #Z-1004-LLL



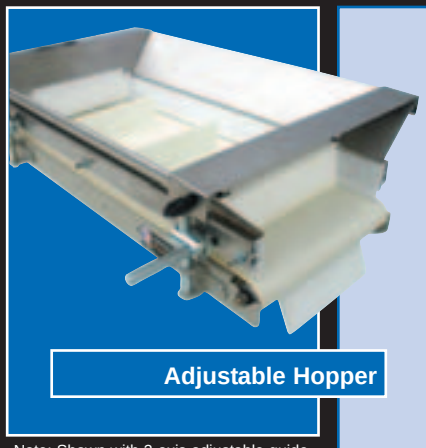
End Stops are used in conjunction with the Flared Side Rail. Stops are adjustable down the length of the rail. Note: End stops are available for the following width conveyors: 8", 10", 12", 18", and 24".

To Order:

8"	125-0234-08
10"	125-0234-10
12"	125-0234-12
18"	125-0234-18
24"	125-0234-24

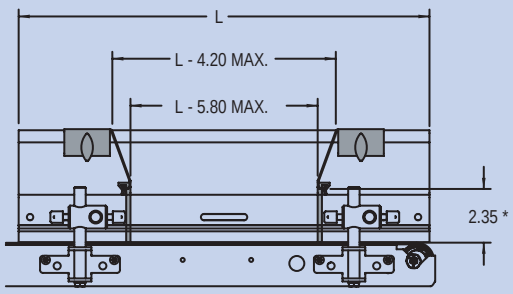
Example: (1) 125-0234-10
One end stop for a 10" wide conveyor equipped with flared side rails

Note: Designed to be compatible with 1" and 2" cleats. End stops are equipped with a swing gate to help contain product



Adjustable Hopper

Note: Shown with 2-axis adjustable guide AND Flared Side Rails (both sold separately) Part # 125-0282-LLL and #Z-1004-LLL



L = length of flared side rails

The Adjustable Hopper is used in conjunction with the Flared Side Rail. The hopper is made from (2) end stops, which are adjustable down the length of the rail. Available for the following width conveyors: 8", 10" 12" 18", and 24".
To Order:
Please order a quantity of 2:

8"	125-0234-08
10"	125-0234-10
12"	125-0234-12
18"	125-0234-18
24"	125-0234-24

Example: (2) 125-0234-10
Two end stops for a 10" wide conveyor equipped with flared side rails

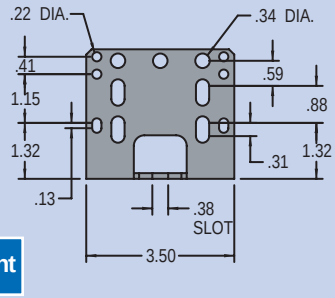
Note: Designed to be compatible with 1" and 2" cleats. End stops are equipped with a swing gate to help contain product

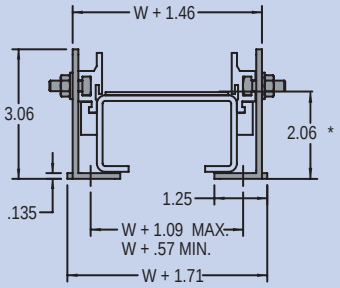
*Dimension reflects use of MAA belt. See pages 20-21.

Standard Mounts

Universal Adjustable Side Mount

125-0181-04 pictured





Notes:
Brackets are universal and can work on either side of the conveyor.
Frame mounted brackets can only be used with 1" high or lower cleats.
Tee Slot mounted brackets can only be used with 1/2" high or lower cleats.

To Order:
Frame Mounted version attaches directly to the conveyor frame. The frame has mounting holes every 3".

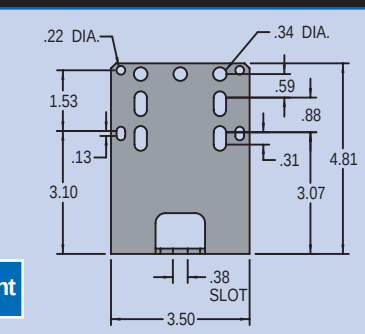
The Tee Slot mounted version attaches to 1" side rails, 2" side rails, the single tee slot and the multi tee slot. See page 22 & 24.

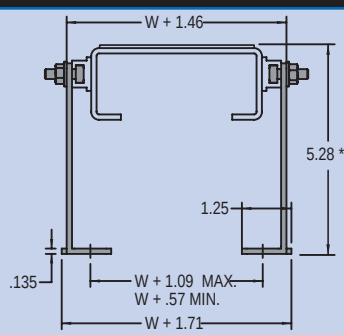
Part No. 125-0181-01 (Tee Slot)*
Part No. 125-0181-04 (Frame)*
Part No. 125-0181-05 (For use with multi-tier stand)*

**Part No. denotes one bracket and necessary hardware*

Universal Raised Side Mount

125-0182-04 pictured





Notes:
Brackets are universal and can work on either side of the conveyor.
Universal raised side mounts work with all cleat heights.

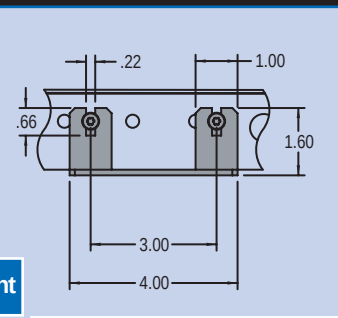
To Order:
Frame Mounted version attaches directly to the conveyor frame. The frame has mounting holes every 3".

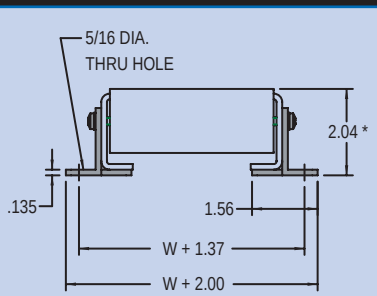
The Tee Slot mounted version attaches to 1" side rails, 2" side rails, the single tee slot and the multi tee slot. See page 22 & 24.

Part No. 125-0182-01 (Tee Slot)*
Part No. 125-0182-04 (Frame)*

**Part No. denotes one bracket and necessary hardware*

Tee Mount





Notes:
Brackets are universal and can work on either side of the conveyor.
Can also be used at tail end of conveyor in conjunction with drive end mounts (125-0014-00, 125-0013-00, and 125-0015-00).
Cannot be used with cleated belts.

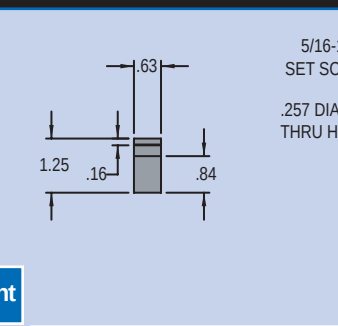
To Order:

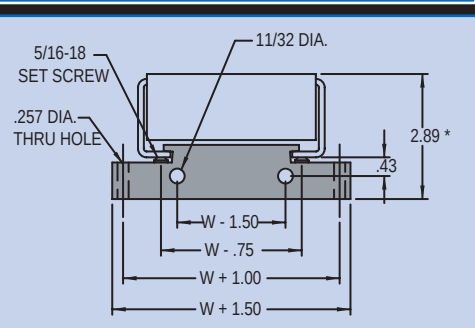
Attaches directly to the conveyor frame. The frame has mounting holes every 3".

Part No. 125-0010-00*

**Part No. denotes one bracket and necessary hardware*

Universal Bottom Mount





Notes:
Bottom mount can attach conveyor to a horizontal or vertical surface.
Cannot be used with high adhesion or cleated belts.

To Order:
Attaches directly to the underside of the conveyor frame. To order, use the part number below and fill in the nominal conveyor width in inches for the last two digits.

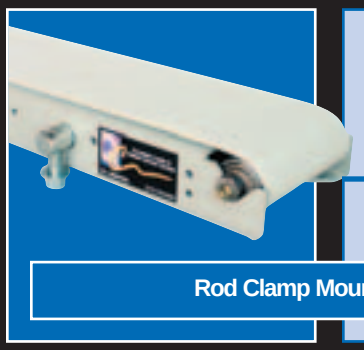
Part No. 125-0011-WW *

Example: 125-0011-04*
Universal Bottom mount for a 4" wide conveyor

**Part No. denotes one bracket and necessary hardware*

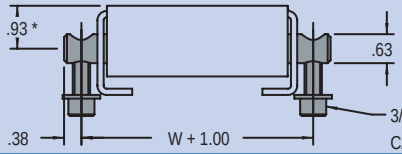
*Dimension reflects use of MAA belt. See pages 20-21.

Standard Mounts

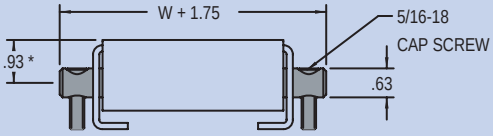


Rod Clamp Mount

Standard method for mounting to stands (fasteners included)



Alternate method for mounting (fasteners not included)



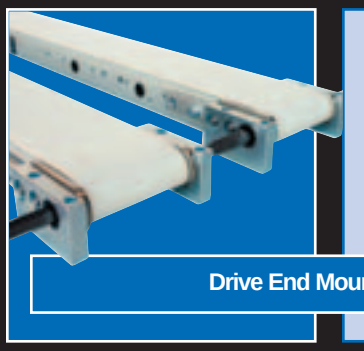
Notes:
Mounts cannot be used with Multi Tee or Single Tee Slotted Side Assembly.
Mounts cannot be used with cleated belts.

To Order:
This mount uses existing through holes on the conveyor that are located 6.06" from the tail end and 8.5" or 14.5" from the drive end, depending on which gearmotor selection is chosen. This will mount the conveyor to a flat surface. To order, use the part number below and fill in the nominal conveyor width in inches for the last two digits.

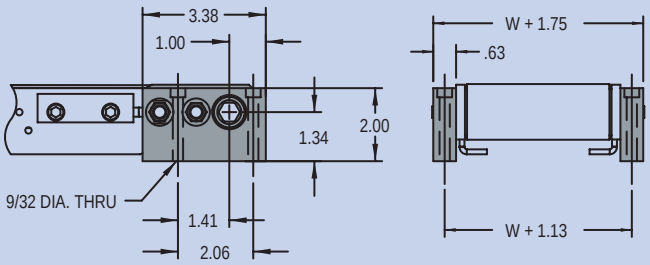
Part No. 125-0116-WW*

Example: 125-0116-06*
Rod Clamp Mount for 6" wider conveyor

**Part No. denotes one bracket and necessary hardware*



Drive End Mount



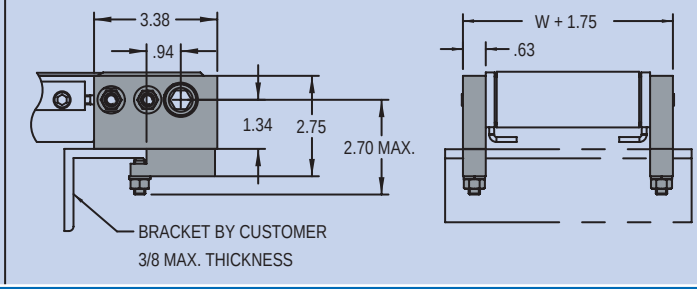
Notes:
Mounts can only be used with a side or remote drive.
Mounts cannot be used with cleated belts.

To Order:
These mounts are primarily intended to provide precise alignment when mounted to a common flat surface, or for multiple conveyors utilizing a common drive shaft. See gang drive page 41.

TYPE	PART NO.
LEFT HAND	125-0014-00
RIGHT HAND	125-0013-00
UNIVERSAL*	125-0015-00

*This mount replaces either right hand or left hand mount and allows mounting of a side drive.

Self-Aligning Bottom Clamp Mount



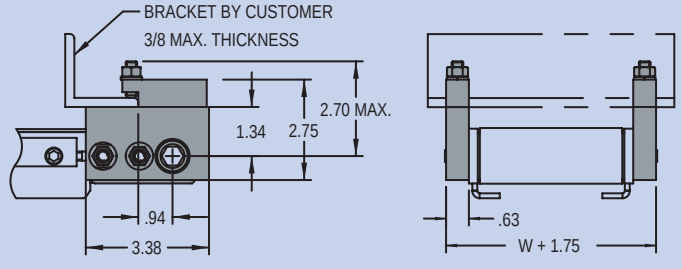
Notes:
Mounts can only be used with a side or remote drive.
Mounts cannot be used with cleated belts.

To Order:
For applications where rapid alignment and rigid mounting of conveyors is required. These clamp mounts provide an economical and practical approach to rapid bolster mounting of gang driven conveyors. See gang drives pg. 41.

TYPE	PART NO.
LEFT HAND	125-0103-BL
RIGHT HAND	125-0102-BR
UNIVERSAL*	125-0117-BU

*This mount replaces either right hand or left hand mount and allows mounting of a side drive.

Self-Aligning Top Clamp Mount



Notes:
Mounts can only be used with a side or remote drive.
Mounts cannot be used with cleated belts.

To Order:
For applications where rapid alignment and rigid mounting of conveyors is required. These clamp mounts are ideal for quick die change systems since the conveyors can be installed into the dies prior to being inserted into the press. See gang drives pg. 41.

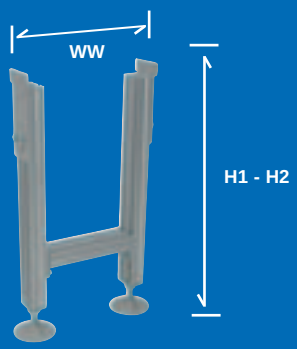
TYPE	PART NO.
LEFT HAND	125-0102-TL
RIGHT HAND	125-0103-TR
UNIVERSAL*	125-0117-TU

*This mount replaces either right hand or left hand mount and allows mounting of a side drive.

*Dimension reflects use of MAA belt. See pages 20-21.

NOTE: There is a 3" overall height adjustment with feet

Aluminum Exact Width Conveyor Stands



Stand Height Range: H1- H2 (in inches)

H1 - H2	H1 - H2
06 - 09	33 - 36
09 - 12	36 - 39
12 - 15	39 - 42
15 - 18	42 - 45
18 - 21	45 - 48
21 - 24	48 - 51
24 - 27	51 - 54
27 - 30	54 - 57
30 - 33	57 - 60

Stand Widths-WW (nominal conveyor width in inches)

02	03	04	06	08	10	12	18	24

To order:

Part No. 0182 - H1 H1 - H2 H2 - WW WW

1) Choose height range from left and enter into H1 & H2 sections. *Remember that the conveyor profile adds 1.89" to the height.*

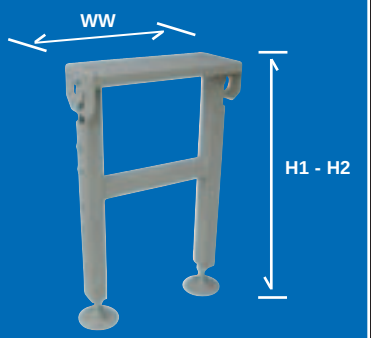
2) Enter conveyor width into WW section.

NOTE: No additional mounts are required.

NOTE: Conveyors 4" wide and under will have the stand framework on the outside of the conveyor; and the minimum height range is 12 - 15 inches

Example: 0182 - 30 - 33 - 24 (Part No. includes one stand)

Steel Telescoping Conveyor Stands



Stand Height Range: H1- H2 (in inches)

H1 - H2
16 - 24
23 - 36
35 - 48
47 - 60

Top Plate Widths - WW (in inches)

08	14	21	27

To order:

Part No. 0184 - H1 H1 - H2 H2 - WW WW

1) Choose height range from left and enter into H1 & H2 sections. *Remember that the conveyor profile adds 1.89" to the height.*

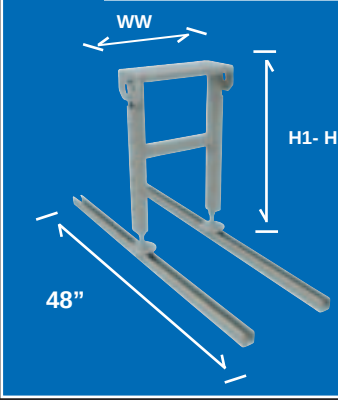
2) Enter top plate width into WW section.

NOTE: Mounts are required to attach the conveyor to the stand. See mount pages 26 & 27 for details

NOTE: 8" wide top plate will accept up to a 6" wide conveyor
14" wide top plate will accept up to a 12" wide conveyor
21" wide top plate will accept up to an 18" wide conveyor
27" wide top plate will accept up to a 24" wide conveyor

Example: 0184 - 16 - 24 - 14 (Part No. includes one stand)

Steel Stands with Stabilizers



Stand Height Range: H1- H2 (in inches)

H1 - H2
18 - 26
25 - 38
37 - 50
49 - 62

Top Plate Widths - WW (in inches)

08	14	21	27

Note: Max conveyor length is 60"

To order:

Part No. 0186 - H1 H1 - H2 H2 - WW WW

1) Choose height range from left and enter into H1 & H2 sections. *Remember that the conveyor profile adds 1.89" to the height.*

2) Enter top plate width into WW section.

NOTE: Must use Rod Clamp Mount 125-0016-WW (See page 27) to attach the conveyor to the stand.

NOTE: 8" wide top plate will accept up to a 6" wide conveyor
14" wide top plate will accept up to a 12" wide conveyor
21" wide top plate will accept up to an 18" wide conveyor
27" wide top plate will accept up to a 24" wide conveyor

Example: 0186 - 16 - 24 - 21 (Part No. includes one stand)

Aluminum Multiple Conveyor Stands

H1 - H2
(in inches)

27 - 30
33 - 36
39 - 42
45 - 48
51 - 54
57 - 60

Widths - WW* (in inches)

12	18	24	30	36

To order:

Part No. 0187 - H1 H1 - H2 H2 - WW WW

1) Choose height range from left and enter into H1 & H2 sections.
2) Choose stand width (WW) and enter into WW section.

NOTE: Conveyor will add 1.89" to top of belt height

NOTE: Adjustable side mounts are required to attach the conveyors to the stand. Use Part No. 125-0181-05

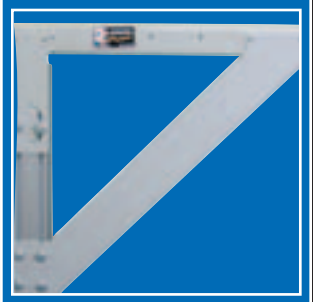
NOTE: *Stand width must be at least 4" greater than the width of the top tier conveyor and/or at least 8" greater than the width of the bottom tier conveyor

NOTE: Bottom conveyors can be adjusted within 5" from the floor to within 8" of the top conveyor

Example: 0187 - 33 - 36 - 12 (Part No. includes one stand)

NOTE: All applications will require the end user to properly lag stands and ensure stability. Because every application and installation is different, the functionality and performance of the supports depend on the end user. QC Industries can aid in determining the supports your application requires.

Angle Brace



To order:

Part No.
125-0189-00

For use with aluminum stands only.
Angle brace can be used on a 125 Series conveyor with a minimum top of belt height of 28”. The angle brace is designed for conveyors 5’ or longer. When used with casters, angle braces must be used on both stands. Part number denotes a set; order (1) per stand.

Aluminum Cross Ties

To order:
Cross Ties - Available Lengths

Inches	LLL
24”	024
36”	036
48”	048
60”	060
72”	072
96”	096
120”	120
144”	144

Part No. LLL
125 - 0235 - ☐☐☐

Enter length of cross ties needed into the “LLL” section above. A quantity of one includes (2) cross ties.

Note: Cross ties require customer to cut to length because of stand placement variations.

Example: 125-0235-120

Steel Cross Ties

To order:
Cross Ties - Available Lengths

Inches	LLL
24”	024
36”	036
48”	048
60”	060
72”	072
96”	096
120”	120
144”	144

Part No. LLL
125 - 0236 - ☐☐☐

Enter length of cross ties needed into the “LLL” section above. A quantity of one includes (2) cross ties.

Note: Cross ties require customer to cut to length because of stand placement variations.

Example: 125-0236-036

Casters

To order:
Part No. 125-0122-04
Swivel locking caster
Order (2) per stand

Casters can be added to either aluminum or steel stands. Swivel locking casters increase stand height by 5.50”.
Casters should only be used with stands that are 1/3 as wide as they are tall.

Swivel-In Tee Nut

To order:
Part No.
125-0074-036 (Qty 1)
125-0074-036-SET (Qty 4)

The Swivel-In Tee Nut is ideal for mounting brackets to an aluminum stand, and allows quick mounting location changes.

1/4 - 20 thread in Tee-Nut is provided for attaching accessories

NOTE: All applications will require the end user to properly lag stands and ensure stability. Because every application and installation is different, the functionality and performance of the supports depend on the end user. QC Industries can aid in determining the supports your application requires.

Drive Sizing Technical Data

The equivalent load was determined in the conveyor technical data pages (pages 10, 14, and 18). To choose a gear motor combination that works best for the application, the next step is to convert that equivalent load into the torque required and size a drive based upon its use. The user must know the belt speed (in feet per minute) and service factor (determined below). The steps below guide the user through this process. These steps will utimately compare the torque required to move the load on the conveyor (Required Conveyor Drive Torque) and the torque the drive train is capable of producing (Supplied Drive Train Torque).

1. Calculate Required Conveyor Drive Torque (RCDT) 1. _____

Enter the equivalent load the drive must handle (from pages 10, 14, or 18). _____ Divide this number by 6. The result equals the torque required for the application, or the required conveyor drive torque (RCDT). Enter RCDT on Line One.

2. Select Belt Speed & Enter Drive Train Torque (DTT) 2. _____

Choose the belt speed from one of the following pages (33 or 37), and write down the drive train torque (DTT) for the selected speed. Please note that if you are choosing a top or bottom drive, you may use either a timing belt or a chain. For heavy duty drives (listed on page 37), the drive train torque is lower if using a timing belt. Enter the drive train torque on Line Two.

3. Select Service Class and Enter Service Factor (SF) Service Class (I or II)_____ 3. _____

Select a service class: Class I - Moderate loads with chain and sprocket or direct drive
Class II - Moderate loads with timing belt and pulley

Now select the service factor (SF) from Chart 30-A below based upon hours of operation per day and number of starts and stops per hour. Enter the result on Line Three.

4. Calculate Supplied Drive Train Torque (SDTT) 4. _____

Divide the drive train torque (DTT) from #2 by the service factor (SF) from #3. This result equals the supplied drive train torque (SDTT). Enter the result on Line Four.

5. Determine Functionality

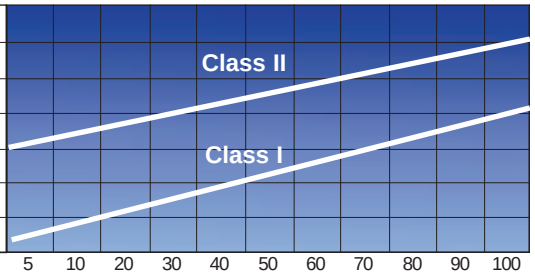
Compare Line 4 (the supplied drive train torque [SDTT]) to Line 1 (the required conveyor drive torque [RCDT]). If the SDTT is equal to or greater than RCDT, then you have selected the proper drive. SDTT > RCDT. If not, then:

A) Slow down the belt speed
B) Choose a wider conveyor
C) Consult factory

Proceed to the next page for instructions on how to use the remaining drive pages.

Service Factor - Chart 30-A

Service Factor	Hours of Operation per Day 24	16	8	2
	2.3	2.0	1.8	1.6
	2.2	1.9	1.7	1.5
	2.1	1.8	1.6	1.4
	2.0	1.7	1.5	1.3
	1.9	1.6	1.4	1.2
	1.8	1.5	1.3	1.1
	1.7	1.4	1.2	1.0



Example:

Equivalent load = 100 (per conveyor technical data page)
100 / 6 = 17 (RCDT)
30 FPM (From page 33 - standard duty top drive - fixed speed)
33 inch lbs. of torque (DTT)
Class II (using timing belt on a top drive)
8 hours per day with no starts and stops (Service Factor is 1.5)
33 / 1.5 = 22 inch lbs. (SDTT)

RCDT = 17
SDTT = 22

20 ≧ 17 (Gearmotor assembly will provide adequate torque)

Example:

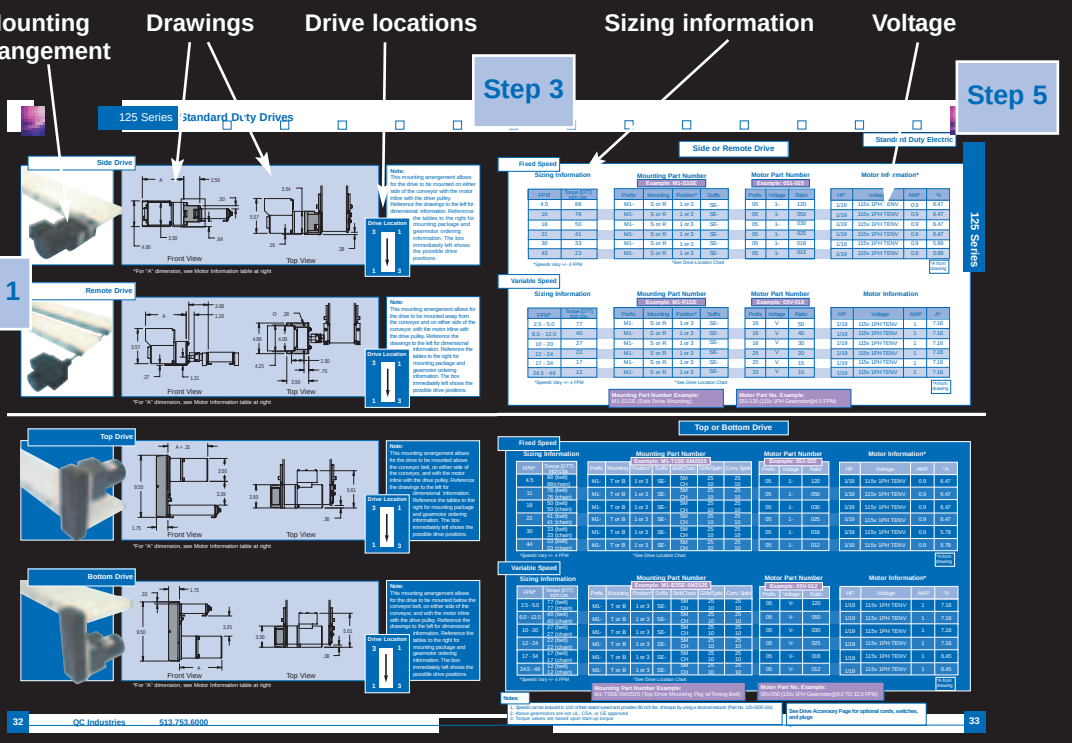
Equivalent load = 300 (per conveyor technical data page)
300 / 6 = 50.0 (RCDT)
50 FPM (From page 37 - heavy duty bottom drive - fixed speed)
87 inch lbs. of torque (DTT)
Class II (using timing belt on a bottom drive)
16 hours per day with (10) starts and stops (Service Factor is 1.7)
87 / 1.7 = 51.1 inch lbs. (SDTT)

RCDT = 50.0
SDTT = 51.1

51.1 ≧ 50.0 (Gearmotor assembly will provide adequate torque)

How to Use the Following Pages

The following pages contain information on types and locations of available QC drives, presented in a clear, concise manner. Simply follow the two-page spread from left to right, and note the steps listed here.



Step 1:
Choose mounting arrangement & location

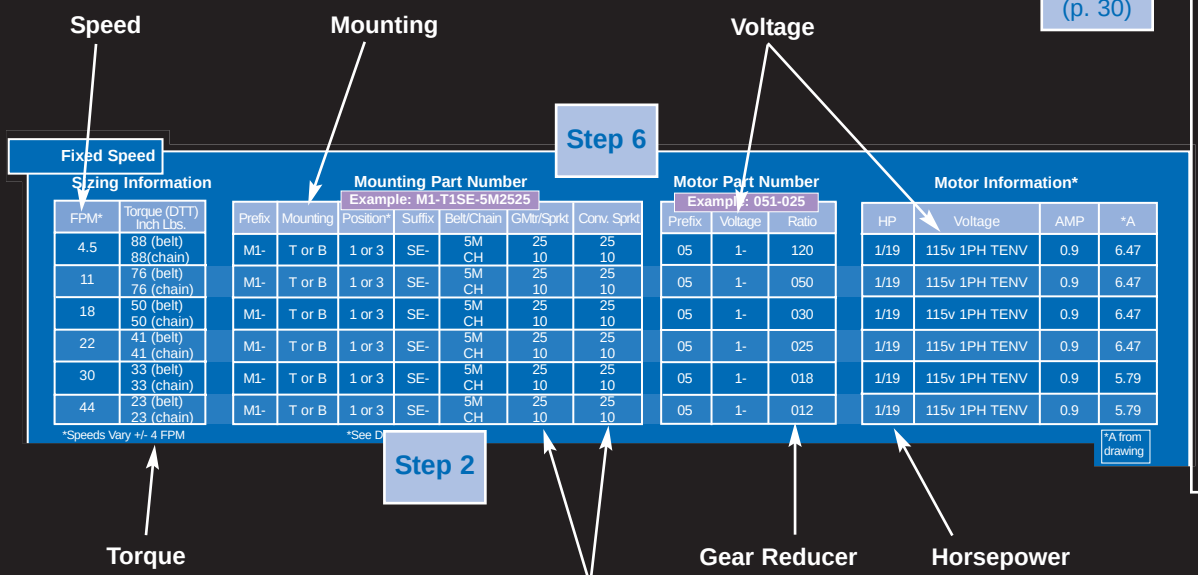
Step 2:
If top or bottom drive mounting arrangement, choose timing belt or chain drive
Note: Each speed has two rows. The top row is timing belt driven, and the bottom row is chain driven

Step 3:
Choose speed

Step 4:
Run drive sizing calculations listed on Page 30

Step 5:
Choose voltage requirements

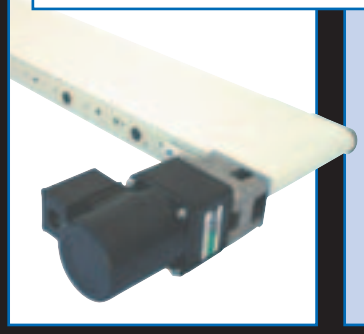
Step 6:
Put together two part numbers, drive mounting package and gearmotor, by following from left to right

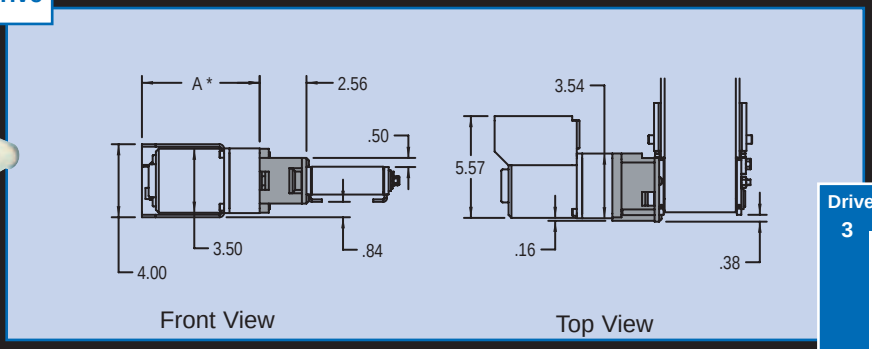


Voltage Key

1	115VAC 1 PH
3	230/460 VAC 3 PH
V	90 VDC w/controller
D	90 VDC w/o controller

Side Drive



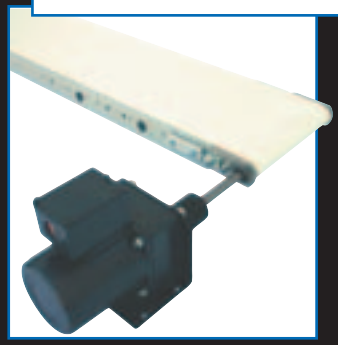


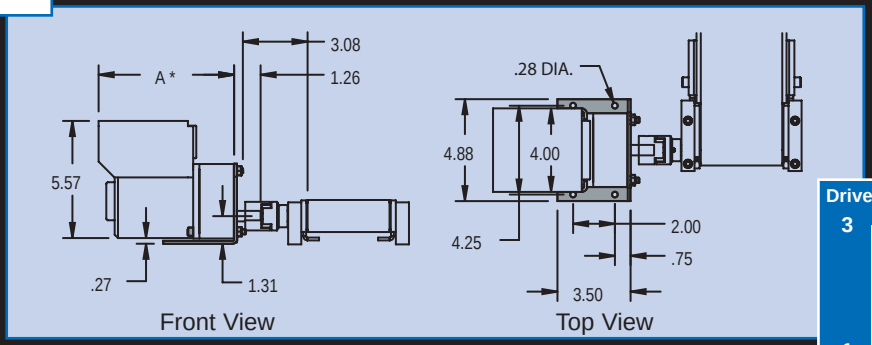
*For “A” dimension, see Motor Information table on next page

Note:
This mounting arrangement allows for the drive to be mounted on either side of the conveyor with the motor inline with the drive pulley. Reference the drawings to the left for dimensional information. Reference the tables to the right for mounting package and gearmotor ordering information. The box immediately left shows the possible drive positions.

Drive Location

Remote Drive

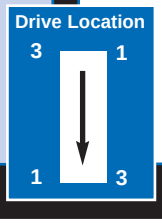




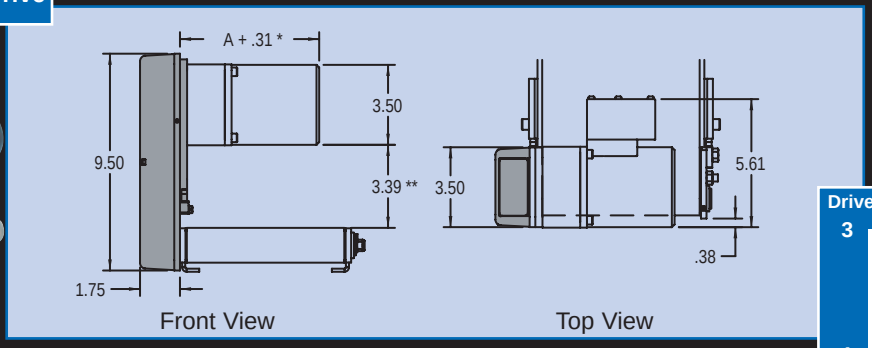
*For “A” dimension, see Motor Information table on next page

Note:
This mounting arrangement allows for the drive to be mounted away from the conveyor and on either side of the conveyor, with the motor inline with the drive pulley. Reference the drawings to the left for dimensional information. Reference the tables to the right for mounting package and gearmotor ordering information. The box immediately left shows the possible drive positions.

Drive Location



Top Drive

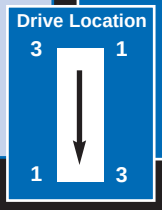


*For “A” dimension, see Motor Information table on next page

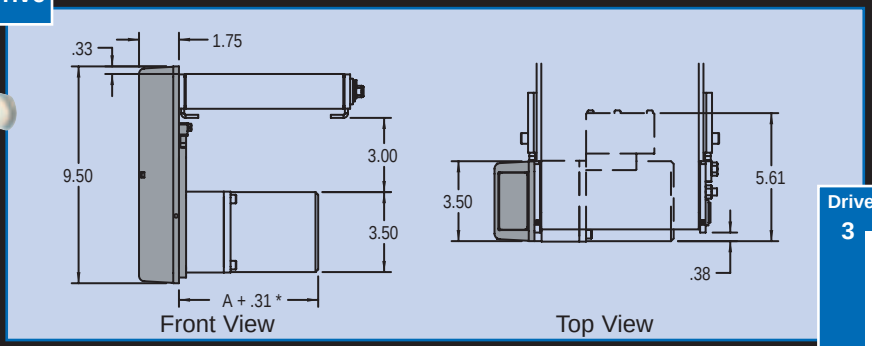
**Dimension reflects use of MAA belt. See pages 20-21

Note:
This mounting arrangement allows for the drive to be mounted above the conveyor belt, on either side of the conveyor, and with the motor inline with the drive pulley. Reference the drawings to the left for dimensional information. Reference the tables to the right for mounting package and gearmotor ordering information. The box immediately left shows the possible drive positions.

Drive Location



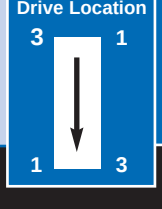
Bottom Drive



*For “A” dimension, see Motor Information table on next page

Note:
This mounting arrangement allows for the drive to be mounted below the conveyor belt, on either side of the conveyor, and with the motor inline with the drive pulley. Reference the drawings to the left for dimensional information. Reference the tables to the right for mounting package and gearmotor ordering information. The box immediately left shows the possible drive positions.

Drive Location



Side or Remote Drive

Fixed Speed

Sizing Information

FPM*	Torque (DTT) Inch Lbs.
4.5	88
10	76
18	50
21	41
30	33
43	23

*Speeds vary up to +/- 4 FPM

Mounting Part Number

Example: M1-S3SE

Prefix	Mounting	Position*	Suffix
M1-	S or R	1 or 3	SE
M1-	S or R	1 or 3	SE
M1-	S or R	1 or 3	SE
M1-	S or R	1 or 3	SE
M1-	S or R	1 or 3	SE
M1-	S or R	1 or 3	SE

*See Drive Location Chart

Motor Part Number

Example: 051-025

Prefix	Voltage	Ratio
05	1-	120
05	1-	050
05	1-	030
05	1-	025
05	1-	018
05	1-	012

Motor Information*

HP	Voltage	AMP	*A
1/19	115v 1PH TENV	0.7	6.47
1/19	115v 1PH TENV	0.7	6.47
1/19	115v 1PH TENV	0.7	6.47
1/19	115v 1PH TENV	0.7	6.47
1/19	115v 1PH TENV	0.7	5.79
1/19	115v 1PH TENV	0.7	5.79

*A from drawing

Variable Speed

Sizing Information

FPM*	Torque (DTT) Inch Lbs.
2.5 - 5.0	73
6 - 12	63
10 - 20	42
12 - 24	34
17 - 34	27
24.5 - 49	19

*Speeds vary up to +/- 4 FPM

Mounting Part Number

Example: M1-R1SE

Prefix	Mounting	Position*	Suffix
M1-	S or R	1 or 3	SE
M1-	S or R	1 or 3	SE
M1-	S or R	1 or 3	SE
M1-	S or R	1 or 3	SE
M1-	S or R	1 or 3	SE
M1-	S or R	1 or 3	SE

*See Drive Location Chart

Motor Part Number

Example: 05V-018

Prefix	Voltage	Ratio
05	V-	120
05	V-	050
05	V-	030
05	V-	025
05	V-	018
05	V-	012

Motor Information

HP	Voltage	AMP	A*
1/19	115v 1PH TENV	1	7.16
1/19	115v 1PH TENV	1	7.16
1/19	115v 1PH TENV	1	7.16
1/19	115v 1PH TENV	1	7.16
1/19	115v 1PH TENV	1	6.45
1/19	115v 1PH TENV	1	6.45

*A from drawing

Mounting Part Number Example:
M1-S1SE (Side Drive Mounting)

Motor Part No. Example:
051-120 (115v 1PH Gearmotor@4.5 FPM)

Top or Bottom Drive

Fixed Speed

Sizing Information

FPM*	Torque (DTT) Inch Lbs.
4.5	88
11	76
18	50
22	41
30	33
44	23

*Speeds vary up to +/- 4 FPM

Mounting Part Number

Example: M1-T1SE-5M2525

Prefix	Mounting	Position*	Suffix	Belt/Chain	GMtr/Sprkt	Conv. Sprkt
M1-	T or B	1 or 3	SE-	5M CH	25 10	25 10
M1-	T or B	1 or 3	SE-	5M CH	25 10	25 10
M1-	T or B	1 or 3	SE-	5M CH	25 10	25 10
M1-	T or B	1 or 3	SE-	5M CH	25 10	25 10
M1-	T or B	1 or 3	SE-	5M CH	25 10	25 10
M1-	T or B	1 or 3	SE-	5M CH	25 10	25 10

*See Drive Location Chart

Motor Part Number

Example: 051-025

Prefix	Voltage	Ratio
05	1-	120
05	1-	050
05	1-	030
05	1-	025
05	1-	018
05	1-	012

Motor Information*

HP	Voltage	AMP	*A
1/19	115v 1PH TENV	0.7	6.47
1/19	115v 1PH TENV	0.7	6.47
1/19	115v 1PH TENV	0.7	6.47
1/19	115v 1PH TENV	0.7	6.47
1/19	115v 1PH TENV	0.7	5.79
1/19	115v 1PH TENV	0.7	5.79

*A from drawing

Variable Speed

Sizing Information

FPM*	Torque (DTT) Inch Lbs.
2.5 - 5.0	73
6 - 12	63
10 - 20	42
12 - 24	34
17 - 34	27
24.5 - 49	19

*Speeds vary up to +/- 4 FPM

Mounting Part Number

Example: M1-B3SE-5M2525

Prefix	Mounting	Position*	Suffix	Belt/Chain	GMtr/Sprkt	Conv. Sprkt
M1-	T or B	1 or 3	SE-	5M CH	25 10	25 10
M1-	T or B	1 or 3	SE-	5M CH	25 10	25 10
M1-	T or B	1 or 3	SE-	5M CH	25 10	25 10
M1-	T or B	1 or 3	SE-	5M CH	25 10	25 10
M1-	T or B	1 or 3	SE-	5M CH	25 10	25 10
M1-	T or B	1 or 3	SE-	5M CH	25 10	25 10

*See Drive Location Chart

Motor Part Number

Example: 05V-012

Prefix	Voltage	Ratio
05	V-	120
05	V-	050
05	V-	030
05	V-	025
05	V-	018
05	V-	012

Motor Information*

HP	Voltage	AMP	*A
1/19	115v 1PH TENV	1	7.16
1/19	115v 1PH TENV	1	7.16
1/19	115v 1PH TENV	1	7.16
1/19	115v 1PH TENV	1	7.16
1/19	115v 1PH TENV	1	6.45
1/19	115v 1PH TENV	1	6.45

*A from drawing

Mounting Part Number Example:
M1-T3SE-5M2525 (Top Drive Mounting Pkg w/Timing Belt)

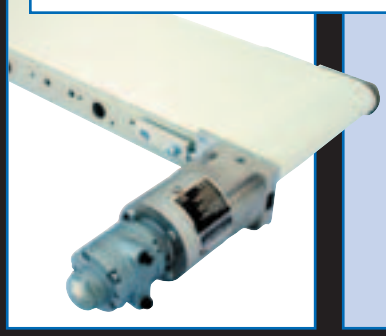
Motor Part No. Example:
05V-050 (115v 1PH Gearmotor@6 TO 12 FPM)

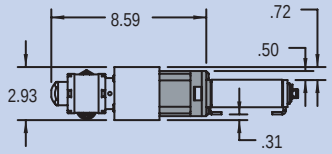
Notes:

1. Speeds can be reduced to 1/10 of their stated speed and provides 88 inch lbs. of torque by using a decimal reducer (Part No. 125-0205-10x)
2. Fixed speed motors are UL, cUL, and CE approved; however, the variable speed motor is not
3. Torque values are based upon start-up torque

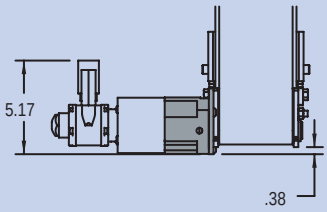
See Drive Accessory Page (Page 39) for standard duty cords, switches, and plugs

Side Drive



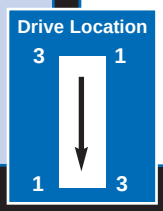


Front View

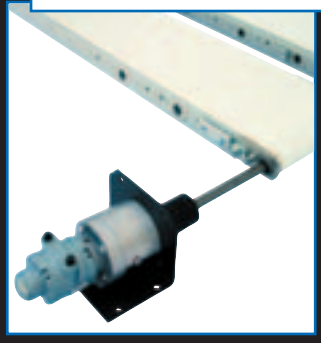


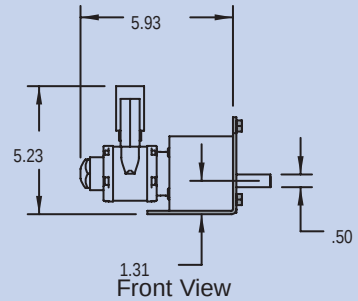
Top View

Note:
This arrangement allows for the drive to be mounted on either side of the conveyor with the motor inline with the drive pulley. Reference the drawings to the left for dimensional information. Reference the tables to the right for mounting package and gearmotor ordering information. The box immediately left shows the possible drive positions.

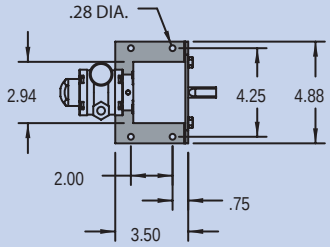


Remote Drive





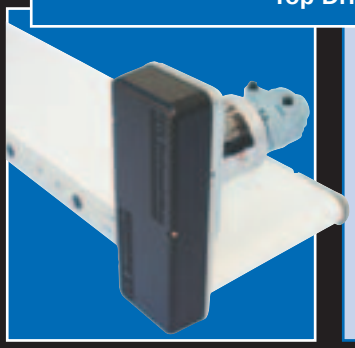
Front View

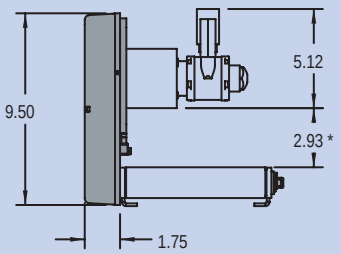


Top View

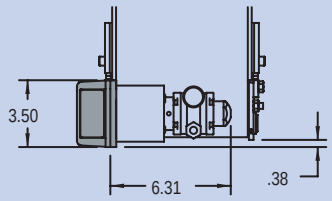
Note:
This arrangement allows for the drive to be mounted away from the conveyor and on either side of the conveyor, with the motor inline with the drive pulley. Reference the drawings to the left for dimensional information. Reference the tables to the right for mounting package and gearmotor ordering information. The box immediately left shows the possible drive positions.

Top Drive





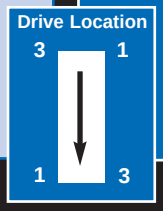
Front View



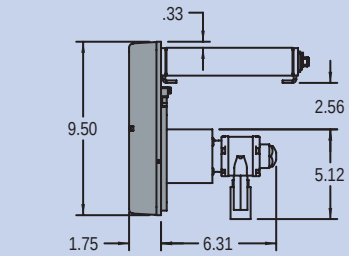
Top View

*Dimension reflects use of MAA belt. See pages 20-21.

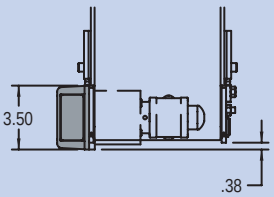
Note:
This arrangement allows for the drive to be mounted above the conveyor belt, on either side of the conveyor, and with the motor inline with the drive pulley. Reference the drawings to the left for dimensional information. Reference the tables to the right for mounting package and gearmotor ordering information. The box immediately left shows the possible drive positions.



Bottom Drive

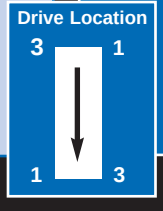


Front View



Top View

Note:
This arrangement allows for the drive to be mounted below the conveyor belt, on either side of the conveyor, and with the motor inline with the drive pulley. Reference the drawings to the left for dimensional information. Reference the tables to the right for mounting package and gearmotor ordering information. The box immediately left shows the possible drive positions.



Side or Remote Drive

Sizing Information

FPM*	Torque In. Lbs.
14-144	See Chart Below

*Speeds vary up to +/- 4 FPM

Mounting Part Number

Example: M1-S3SA

Prefix	Mounting	Position*	Suffix
M1-	S or R	1 or 3	SA

*See Drive Location Chart

Mounting Part Number Example:
M1-S1SA
Top Drive Mounting Package with Chain

Motor Part Number

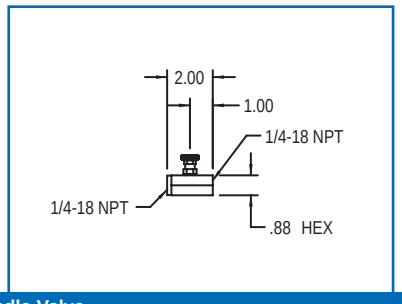
Example: 30A-015

Prefix	Voltage	Ratio
30	A-	015

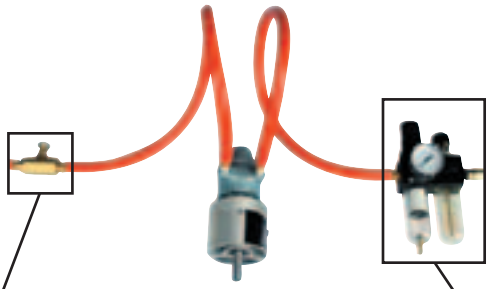
Motor Part No. Example:
30A-015
4 Vane Reversible Pnuematic Motor

Motor Information

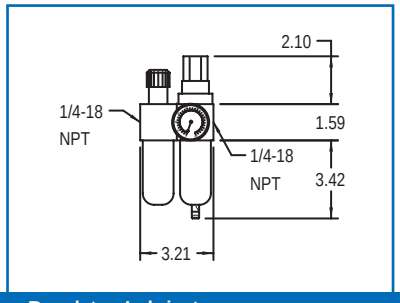
Vane	Max PSI
4	80



Needle Valve
Part Number: 125-0034-VLV1
The QC Industries Needle Valve acts as a throttling device, and is sized to incrementally control the speed of the Standard Duty Pneumatic Drive



Typical Arrangement



Filter, Regulator, Lubricator
Part Number: 125-0034-FRL
The QC Industries Filter, Regulator, and Lubricator has been sized to handle the flow and pressure requirements of the Standard Duty Pneumatic Drive

Top or Bottom Drive

Sizing Information

FPM*	Torque In. Lbs.
14-144	See Chart
	See Chart

*Speeds vary up to +/- 4 FPM

Mounting Part Number

Example: M1-T1SA-5M2525

Prefix	Mounting	Position*	Suffix	Belt/Chain	GMtr. Sprkt	Conv Sprkt
M1-	T or B	1 or 3	SA-	5M	25	25
				CH	10	10

*See Drive Location Chart

Mounting Part Number Example:
M1-T3SA-CH1010 (Top Drive Mounting Pkg w/Chain)

Motor Part No.

Example: 30A-015

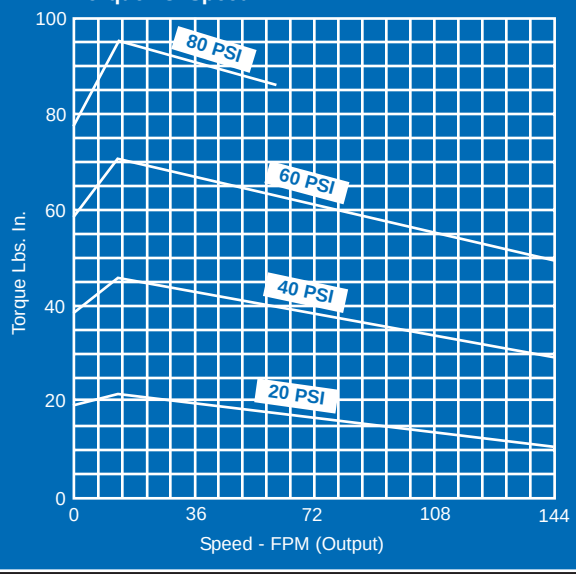
Prefix	Voltage	Ratio
30	A-	015

Motor Part No. Example:
30A-015 (4 Vane Reversible Pneumatic Motor)

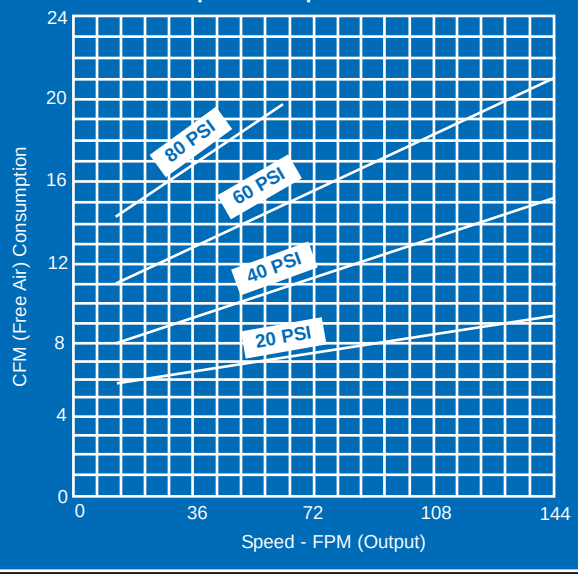
Motor Information

Vane	Max PSI
4	80

Torque vs. Speed



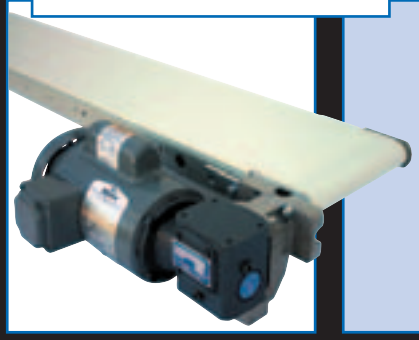
Air Consumption vs. Speed

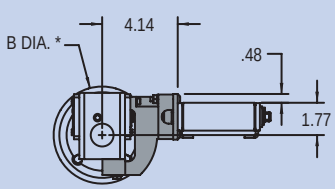


Notes:

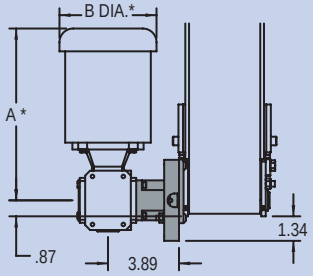
1. Motor comes standard with muffler and in-line filter.
2. Speed should be controlled on the exhaust of air to preserve maximum torque output and a stable speed control.
3. Max speed is 61 FPM @ 80 PSI.
4. Both chain and timing belt drives have the same torque rating.

Side Drive





Front View

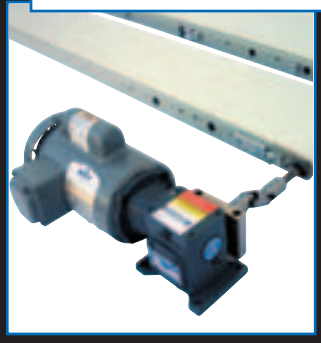


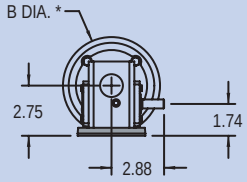
Top View

*For "A" and "B" dimensions, see table at bottom of page

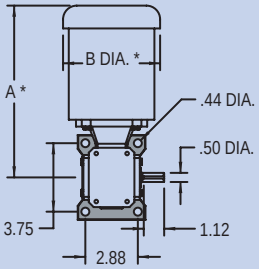
Note:
This arrangement allows for the drive to be mounted on either side of the conveyor with the motor perpendicular to the drive pulley. Reference the drawings to the left for dimensional information. Reference the tables to the right for mounting package and gearmotor ordering information. The box immediately left shows the possible drive positions.

Remote Drive





Front View

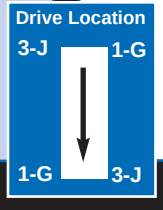


Top View

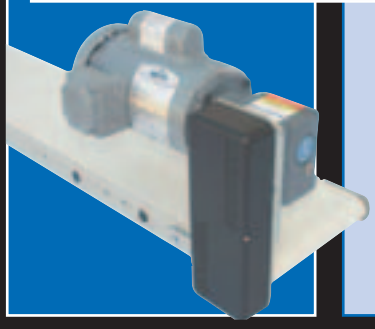
Note: 56 frame gear motors extend below gear box mounting plate and may require shimming

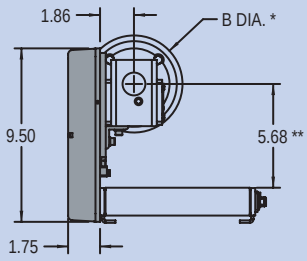
*For "A" and "B" dimensions, see table at bottom of page

Note:
This arrangement allows for the drive to be mounted away from the conveyor and on either side of the conveyor, with the motor perpendicular to the drive pulley. Reference the drawings to the left for dimensional information. Reference the tables to the right for mounting package and gearmotor ordering information. The box immediately left shows the possible drive positions.

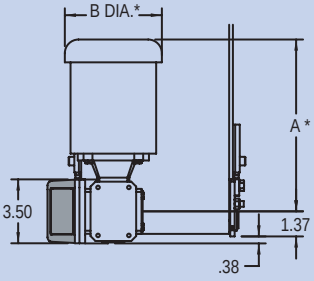


Top Drive





Front View

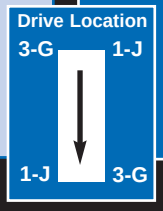


Top View

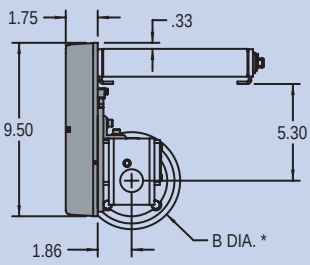
*For "A" and "B" dimensions, see table at bottom of page

**Dimension reflects use of MAA belt. See pages 20-21.

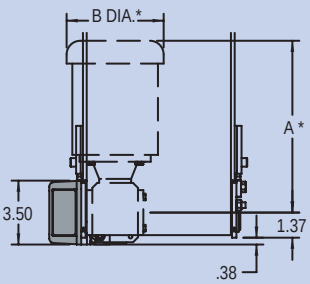
Note:
This arrangement allows for the drive to be mounted above the conveyor belt, on either side of the conveyor, and with the motor perpendicular to the drive pulley. Reference the drawings to the left for dimensional information. Reference the tables to the right for mounting package and gearmotor ordering information. The box immediately left shows the possible drive positions.



Bottom Drive



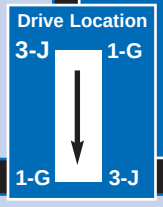
Front View

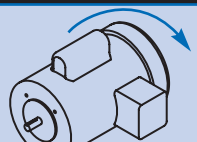


Top View

*For "A" and "B" dimensions, see table at bottom of page

Note:
This arrangement allows for the drive to be mounted below the conveyor belt, on either side of the conveyor, and with the motor perpendicular to the drive pulley. Reference the drawings to the left for dimensional information. Reference the tables to the right for mounting package and gearmotor ordering information. The box immediately left shows the possible drive positions.





The motor can be rotated in 90° increments when attaching it to the gearbox. This allows the user flexibility when deciding where the motor capacitor and work box will be located.

Motor Dimension Chart

	161	163	16V	251	253	25V	331	333	33V	501	503	50V	503 (ID)
A	11.39	11.26	8.22	9.22	9.25	9.15	9.01	9.24	10.11	13.85	13.22	15.84	14.08
B	5.20	4.69	4.98	5.19	5.20	4.99	6.20	5.20	5.01	6.15	6.19	4.98	7.23

Fixed or Variable Speed

Side Drive

Sizing Information

FPM*	Torque (DTT) Inch Lbs.
12	120
15	128
20	132
30	130
40	128
60	107
120	82

*Speeds vary up to +/- 4FPM

Mounting Part Number

Example: M1-S1J0

Prefix	Mounting	Position*	Suffix
M1-	S	1J or 3G	0
M1-	S	1J or 3G	0
M1-	S	1J or 3G	0
M1-	S	1J or 3G	0
M1-	S	1J or 3G	0
M1-	S	1J or 3G	0
M1-	S	1J or 3G	0

*See Drive Location Chart

Motor Part Number

Example: 161 - 50J

Prefix	Voltage	Ratio	Gearbox Hand
16	1,3,V,D-	50	G or J
16	1,3,V,D-	40	G or J
16	1,3,V,D-	30	G or J
25	1,3,V,D-	20	G or J
25	1,3,V,D-	15	G or J
33	1,3,V,D-	10	G or J
50	1,3,V,D-	05	G or J

Motor Information

HP	Voltage 115/230 Amp	Voltage 230/460 Amp	DC Amp	Face
1/6	3.6/1.9	1.3/0.6	1.7	42C
1/6	3.6/1.9	1.3/0.6	1.7	42C
1/6	3.6/1.9	1.3/0.6	1.7	42C
1/4	4.6/2.6	1.3/0.6	2.5	42C
1/4	4.6/2.6	1.3/0.6	2.5	42C
1/3	5.2/2.8	1.5/0.7	3.2	42C
1/2	7.4/3.7	2.1/2.0	4.8	56C

Remote Drive

Sizing Information

FPM*	Torque (DTT) Inch Lbs.
12	120
15	128
20	132
30	130
40	128
60	107
120	82

*Speeds vary up to +/- 4FPM

Mounting Part Number

Example: M1-R1G0

Prefix	Mounting	Position*	Suffix
M1-	R	1G or 3J	0
M1-	R	1G or 3J	0
M1-	R	1G or 3J	0
M1-	R	1G or 3J	0
M1-	R	1G or 3J	0
M1-	R	1G or 3J	0
M1-	R	1G or 3J	0

*See Drive Location Chart

Motor Part Number

Example: 251-20G

Prefix	Voltage	Ratio	Gearbox Hand
16	1,3,V,D-	50	G or J
16	1,3,V,D-	40	G or J
16	1,3,V,D-	30	G or J
25	1,3,V,D-	20	G or J
25	1,3,V,D-	15	G or J
33	1,3,V,D-	10	G or J
50	1,3,V,D-	05	G or J

Motor Information

HP	Voltage 115/230 Amp	Voltage 230/460 Amp	DC Amp	Face
1/6	3.6/1.9	1.3/0.6	1.7	42C
1/6	3.6/1.9	1.3/0.6	1.7	42C
1/6	3.6/1.9	1.3/0.6	1.7	42C
1/4	4.6/2.6	1.3/0.6	2.5	42C
1/4	4.6/2.6	1.3/0.6	2.5	42C
1/3	5.2/2.8	1.5/0.7	3.2	42C
1/2	7.4/3.7	2.1/2.0	4.8	56C

Mounting Part Number Example:
M1-S3J0 (Side Drive Mounting)

Motor Part No. Example:
253-15J (230/460v 3PH Gearmotor@40 FPM)

Voltage Key

1	115 VAC 1 PH	For optional AC controls, see p. 38
3	230/460 VAC 3 PH	For optional AC controls, see p. 38
V	90 VDC w/controller	See controller on p. 38
D	90 VDC w/o controller	Customer to supply controller

Fixed or Variable Speed

Top or Bottom Drive

Sizing Information

FPM*	Torque (DTT) Inch Lbs.
12	95 (belt)
	120 (chain)
15	95 (belt)
	128 (chain)
20	98 (belt)
	132 (chain)
30	93 (belt)
	130 (chain)
40	89 (belt)
	128 (chain
50	87 (belt)
	107 (chain)
60	84 (belt)
	107 (chain)
75	89 (belt)
	100 (chain)
100	67 (belt)
	67 (chain)
120	82 (belt)
	82 (chain)
150	68 (belt)
	68 (chain)
175	59 (belt)
	59 (chain)
200	51 (belt)
	51 (chain)
225	46 (belt)
	46 (chain)

*Speeds vary up to +/- 4FPM

Mounting Part Number

Example: M1-B3J0-CH1410

Prefix	Mounting	Position*	Suffix	Belt/Chain	GMtr. Sprkt	Conv Sprkt
M1-	T or B	1J, 1G, 3J or 3G	0-	5M	25	25
				CH	10	10
M1-	T or B	1J, 1G, 3J or 3G	0-	5M	25	25
				CH	10	10
M1-	T or B	1J, 1G, 3J or 3G	0-	5M	25	25
				CH	10	10
M1-	T or B	1J, 1G, 3J or 3G	0-	5M	25	25
				CH	10	10
M1-	T or B	1J, 1G, 3J or 3G	0-	5M	25	25
				CH	10	10
M1-	T or B	1J, 1G, 3J or 3G	0-	5M	30	25
				CH	12	10
M1-	T or B	1J, 1G, 3J or 3G	0-	5M	25	25
				CH	10	10
M1-	T or B	1J, 1G, 3J or 3G	0-	5M	30	25
				CH	12	10
M1-	T or B	1J, 1G, 3J or 3G	0-	5M	40	25
				CH	16	10
M1-	T or B	1J, 1G, 3J or 3G	0-	5M	25	25
				CH	10	10
M1-	T or B	1J, 1G, 3J or 3G	0-	5M	30	25
				CH	12	10
M1-	T or B	1J, 1G, 3J or 3G	0-	5M	34	25
				CH	14	10
M1-	T or B	1J, 1G, 3J or 3G	0-	5M	40	25
				CH	16	10
M1-	T or B	1J, 1G, 3J or 3G	0-	5M	44	25
				CH	18	10

*See Drive Location chart

Motor Part No.

Example: 503-05J

Prefix	Voltage	Ratio	Gearbox Hand
16	1,3,V,D-	50	G or J
16	1,3,V,D-	40	G or J
16	1,3,V,D-	30	G or J
25	1,3,V,D-	20	G or J
25	1,3,V,D-	15	G or J
25	1,3,V,D-	15	G or J
33	1,3,V,D-	10	G or J
33	1,3,V,D-	10	G or J
33	1,3,V,D-	10	G or J
50	1,3,V,D-	05	G or J
50	1,3,V,D-	05	G or J
50	1,3,V,D-	05	G or J
50	1,3,V, D-	05	G or J
50	1,3,V,D-	05	G or J

Motor Information

HP	Voltage 115/230 Amp	Voltage 230/460 Amp	DC Amp	Face
1/6	3.6/1.9	1.3/0.6	1.7	42C
1/6	3.6/1.9	1.3/0.6	1.7	42C
1/6	3.6/1.9	1.3/0.6	1.7	42C
1/4	4.6/2.6	1.3/0.6	2.5	42C
1/4	4.6/2.6	1.3/0.6	2.5	42C
1/3	2.5/2.8	1.5/0.7	3.2	42C
1/3	2.5/2.8	1.5/0.7	3.2	42C
1/3	2.5/2.8	1.5/0.7	3.2	42C
1/2	7.4/3.7	2.1/1.0	4.8	56C
1/2	7.4/3.7	2.1/1.0	4.8	56C
1/2	7.4/3.7	2.1/1.0	4.8	56C
1/2	7.4/3.7	2.1/1.0	4.8	56C
1/2	7.4/3.7	2.1/1.0	4.8	56C

Mounting Part Number Example:
M1-T1J0-5M4025 (Top Drive Mounting Pkg w/Timing Belt)

Motor Part No. Example:
331-10J (115v 1PH Gearmotor@100 FPM)

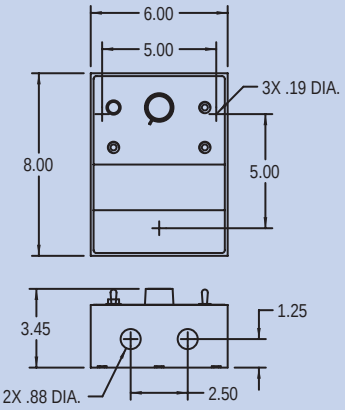
Notes:

1. ALL above gearmotors are UL and CSA approved
2. Torque values are based upon running torque
3. Inverter duty variable frequency rated motors are available in 1/2 HP. Add an ID to the end of the motor part number for the 230/460VAC 3ph motors only.
4. Please note that all inverter duty motors have a non-removable foot mount on them

See Drive Accessories pages (p. 38 & 39) for optional controllers, motor starters, e-stops, cords, switches, and plugs

Motor Controls

Standard DC Control



Note: It is the responsibility of the end user to properly wire this controller to the gearmotor

Specifications/Features:

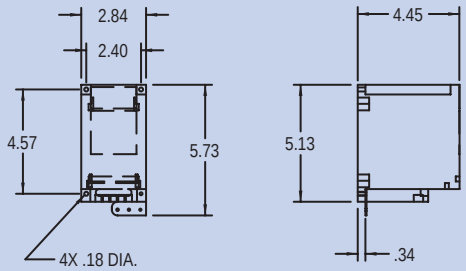
115 V AC, 1 phase input, 90 V DC, 1/2 hp max output
230 V AC, 1 phase input, 180 V DC, 1 hp max output
30:1 speed range
UL/ULc/CE
NEMA 1 Enclosure
Forward/Reverse switch, Run/Brake switch
Min/Max & Accel/Decel settings

To Order:
Part Number:

125-0054-01	Standard NEMA 1DC Control
125-0149-09*	Wiring: cords & plugs

*Includes 8' cord from control to AC plug and 8' cord from control to motor with male/female disconnects (wired).

Standard AC Control



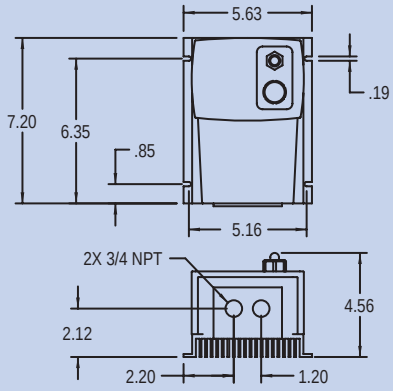
Note: It is the responsibility of the end user to properly wire this controller to the gearmotor

Specifications/Features:
115/230 V AC, 1/3 phase, 50/60 hz input, 1 hp max output
10:1 speed range (when used with ID motor)
UL/ULc/CE
IP 20 Enclosure
3-digit LED display
Forward/Reverse switch
Run/Stop button, Accel/Decel buttons
Carrier frequency selectable for quiet operation

To Order:
Part Number:*

125-0054-5C-11-05	115V AC, 1 phase input, IP20
125-0054-5C-21-05	230V AC, 1 phase input, IP20
125-0054-5C-23-20	230 V AC, 3 phase input, IP20
125-0054-5C-43-10	460 V AC, 3 phase input, IP20

Washdown DC Control



Note: It is the responsibility of the end user to properly wire this controller to the gearmotor

Specifications/Features:

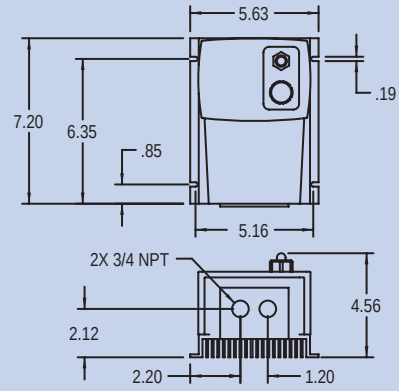
115 V AC, 1 phase input, 90 V DC, 1 hp max output
230 V AC, 1 phase input, 180 V DC, 2 hp max output
30:1 speed range
UL/ULc/CE
NEMA 4X Enclosure
Speed adjustment potentiometer
Forward/Off/Reverse switch
Min/Max & Accel/Decel settings

To Order:
Part Number:

125-0054-38	NEMA 4X DC Control

This 4X washdown controller can be used in a wet or dusty environment.

Washdown AC Control



Note: It is the responsibility of the end user to properly wire this controller to the gearmotor

Specifications/Features:

115/230 V AC, 1 phase, 50/60 hz input, 3 phase out, 1 hp max output
10:1 speed range (when used with ID motor)
UL/ULc
NEMA 4X Enclosure
Speed adjustment potentiometer
Run/Stop switch
Carrier frequency selectable for quiet operation

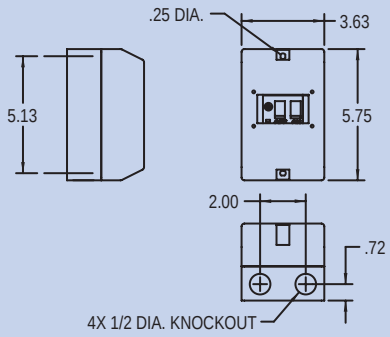
To Order:
Part Number:

125-0054-37	NEMA 4X AC Control

This 4X washdown controller can be used in a wet or dusty environment.

Motion Controls

Motor Starter



Note: It is the responsibility of the end user to properly wire motor starter and e-stops

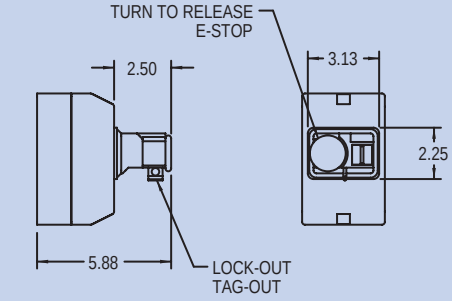
The Motor Starter is an overload protection that also provides a means of using a Remote E-Stop for safety. The starter is equipped with an undervoltage trip to protect against autostarting after the overload condition has been corrected. Also includes short circuit protection.

Specifications/Features:
115 V AC, 1 phase, 60 hz input, 1/2 hp max
230 V AC, 3 phase input, 1 1/2 hp max
460 V AC, 3 phase input, 1 1/2 hp max
UL/CSA/CE
Start/Stop buttons
IP55 Enclosure

To Order:
Part Number:

125-0054-38-115	115 V AC, 1ph w/enclosure
125-0054-38-230	230 V AC, 3 ph w/enclosure
125-0054-38-460	460 V AC, 3 ph w/enclosure

E-Stop Accessory



Note: It is the responsibility of the end user to properly wire motor starter and e-stops

The E-Stop accessory is mounted directly to the Motor Starter enclosure, providing a means of stopping the motor for safety. It can be padlocked for servicing, and contains a start button for restarting the motor after the pushbutton has been released.

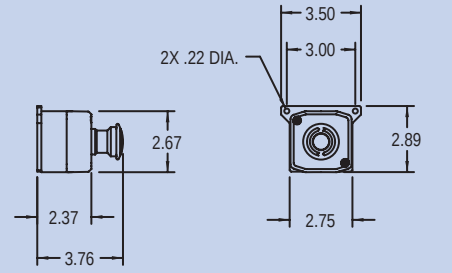
Specifications/Features:
Turn to release
UL/CSA/CE
E-Stop can be locked out/includes start button
IP55 Rated

Note: Mounts directly to motor starter enclosure

To Order:
Part Number:

ELECT-061	E-Stop Accessory for Motor Starter

Remote E-Stop



Note: It is the responsibility of the end user to properly wire motor starter and e-stops

The Remote E-Stop provides a means for locking out power to the motor for safety. It includes an IP65 enclosure and mounting bracket to allow the E-Stop to be mounted directly to the side of the conveyor frame.

Specifications/Features:
Turn to release
UL/CSA/CE
IP65 Enclosure

To Order:
Part Number:

ELECT-063-WBRKT	E-Stop with enclosure

Note: Includes mounting bracket to mount to conveyor frame

Optional Cords, Plugs, & Switches

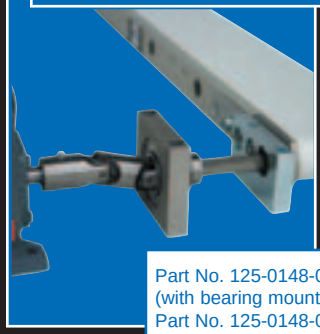
Standard Duty Motor Options

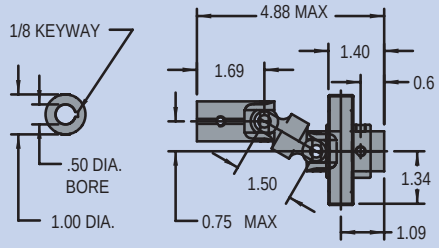
Part Number	Description
125-0149-01	Fixed speed standard duty electric motor ON/OFF switch
125-0149-02	Fixed speed standard duty electric motor FORWARD/REVERSE switch
125-0149-03	Variable speed standard duty electric motor FORWARD/REVERSEswitch
125-0149-04	Fixed speed standard duty electric motor 8' cord and plug

Heavy Duty Motor Options

Part Number	Description
125-0149-05	ON/OFF switch for 1 PH heavy duty motor
125-0149-06	FORWARD/REVERSE switch for 1 PH heavy duty motor
125-0149-07	8' cord and plug for 1 PH heavy duty motor
125-0149-09	8' cord and plug for 90VDC motor - see controller for details

Double Universal Joint





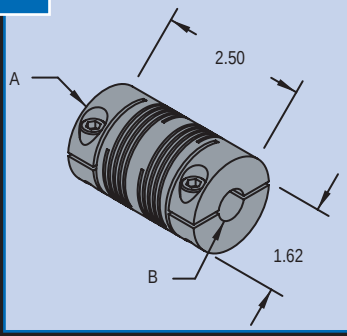
Part No. 125-0148-00 (with bearing mount)
Part No. 125-0148-03 (without bearing mount)

CAUTION: Universal joint must be guarded. (Guarding is the responsibility of the end user.)

The Double Universal Joint with bearing mount is used to couple a remote mounted motor with a conveyor drive shaft when there is not common shaft alignment. This assembly should be used with Drive End Mounts.

Note: Torque rating of universal joint at average angle of 15° (.375 offset) and 350 rpm is 125 inch lbs. Higher speeds and angle will reduce rating.

Single Piece Flex Coupling

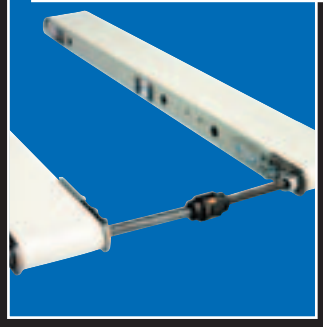


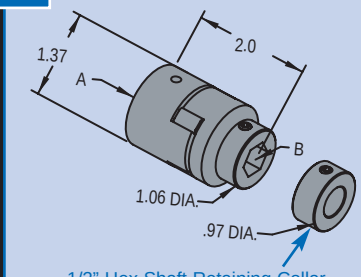
Part Number	A	B	*Torque Rating (Inch Lbs.)
125-0009-02	.5 in. diameter	.5 in. diameter	100
125-0009-03	.5 in. diameter w/keyway	.5 in. hex	100
125-0009-06	.5 in. hex	.5 in. hex	100

*Value based on non-reversing applications with an angular offset of up to 5°.

The Single Piece Flex Coupling is used to couple the remote mounted motor with the conveyor drive shaft. This coupling can also be used to couple between gang driven conveyors.

Three Piece Flex Coupling





1/2" Hex Shaft Retaining Collar
Part No. 125-0078-026

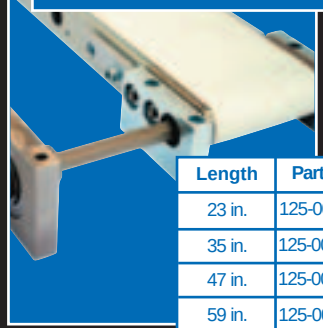
Part Number	A	B	*Torque Rating (Inch Lbs.)
125-0135-00	.5 in. diameter w/keyway	.5 in. hex	114
125-0135-01	.625 in. diameter w/keyway	.5 in. hex	114
125-0135-02	.5 in. hex	.5 in. hex	114
125-0135-07	.5 in. diameter	.5 in. diameter	114

*Value based on standard duty non-reversing applications with an angular offset of up to 1°. For heavy duty applications, divide torque by 2.

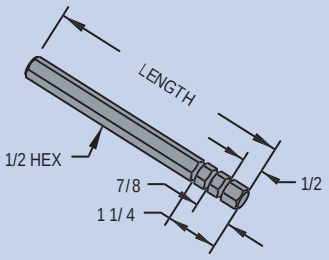
The Three Piece Flex Coupling is used to couple the remote mounted motor with the conveyor drive shaft. This coupling can also be used to couple between gang driven conveyors. This coupling is used on all side drives.

Note: Use of the three piece flex coupling may require the 1/2" hex shaft retaining collar (Part No. 125-0078-026) to prevent separation. Please consult factory.

Drive Extension Shaft



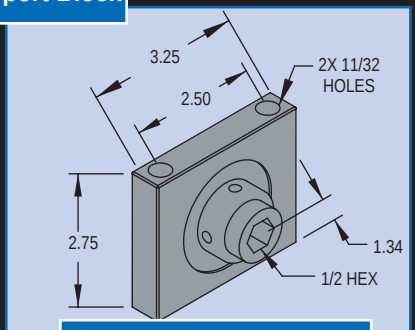
Length	Part No.
23 in.	125-0005-23
35 in.	125-0005-35
47 in.	125-0005-47
59 in.	125-0005-59
71 in.	125-0005-71
83 in.	125-0005-83
95 in.	125-0005-95



The Drive Extension Shaft can be used to gang drive multiple conveyors and/or for power take-off of remote drives.

Drive Extension Shaft Support Block

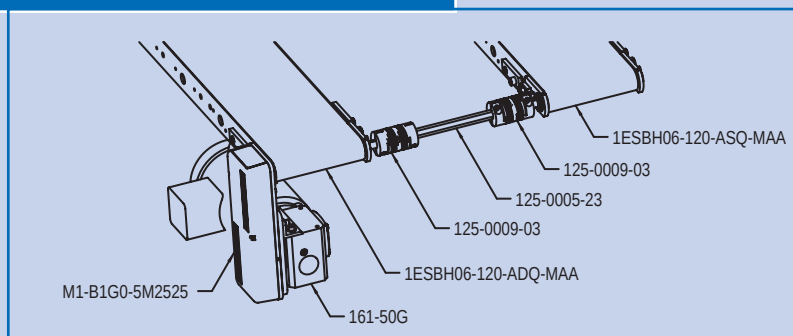
Part No. 125-0148-05



The Drive Extension Shaft Support Block is used to support lengths of shaft not supported by the drive coupling or a conveyor.

Typical Gang Drive Examples

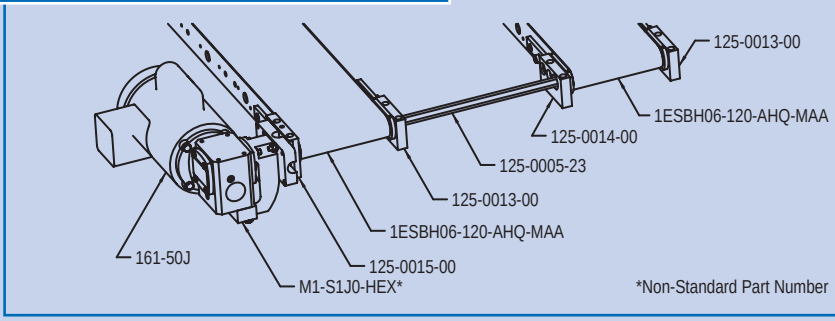
Bottom Drive withTwo Flex Couplings



Note 1:

This typical gang drive application shows a bottom drive mounting arrangement. The couplings and drive extension shaft are shown on the opposing page. Please note that the conveyor to which the drive is attached has a “D” designator in the drive pulley portion of the part number.

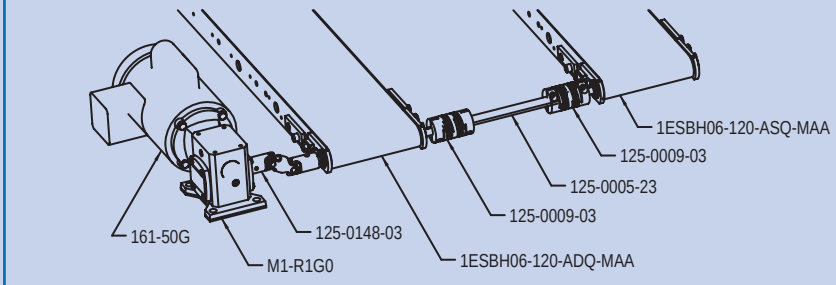
Side Drive with Through Shaft & Drive End Mounts



Note 2:

This typical gang drive application shows a side drive mounting arrangement. The drive end mounts are shown on page 27, and drive extension shafts are shown on the opposing page. Please note that the conveyor to which the drive is nearest has an “H” designator in the drive pulley portion of the part number.

Remote Drive with Flex Couplings



Note 3:

This typical gang drive application shows a remote drive mounting arrangement. The couplings and drive extension shafts are shown on the opposing page. Please note that the conveyor to which the drive is nearest has a “D” designator in the drive pulley portion of the part number.

How to Order

The examples above help illustrate how to assemble part numbers for typical applications. The following shows the steps needed to correctly size a gang driven application:

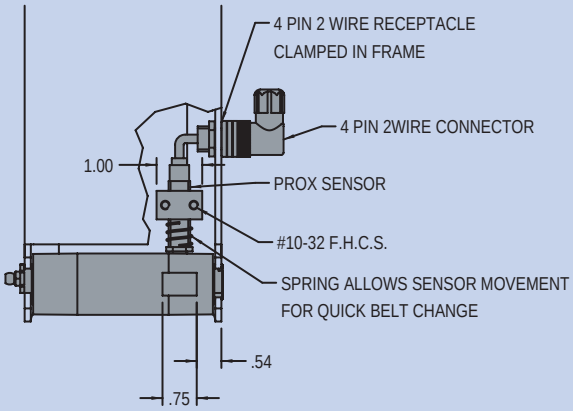
Step One: Add up the equivalent load for each conveyor you plan to gang drive. (Using pages 10, 14, and/or 18)
Step Two: Size a drive based upon the total equivalent load from Step One
Step Three: Determine which type of drive arrangement you need: side, remote, top, or bottom (Using page 32, 34, or 36)
Step Four: Change the drive pulley digit of the conveyor part number to reflect which drive arrangement you are using. "D" for top or bottom drives and "H" for side or remote drives. Conveyor Part number example: 1ESBH04-060-ADQ-MAA - The "D" designates a dual output drive pulley to be used in a gang driven application using a top or bottom drive. The “H” designates a hex input pulley to be used in a gang driven application using a side or remote drive.
Step Five: Determine the couplings and drive extension shaft needed, using the above diagrams as a guide. This information can be located on the opposing page
Step Six: Ensure that the couplings can handle the torque requirements of the system. Reference page 40

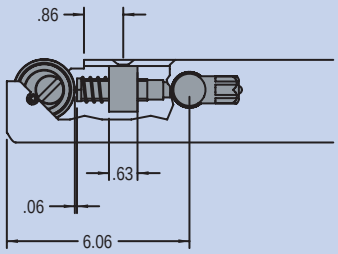
Please consult the factory if you have questions.

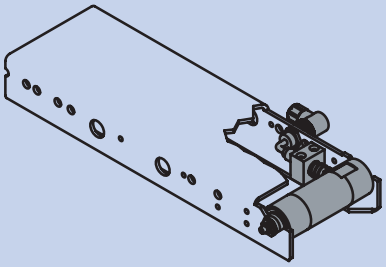
Motion Detection

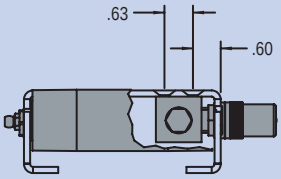
Motion detection can be used in all applications where it is necessary to know the conveyor belt is running while other machines are operating. QC's motion detection system monitors your conveyor and provides a "belt running" signal to your machine conrtrol system or PLC.

- Compact design
- Easy to retrofit into existing conveyors
- Magnetic proximity sensor allows for dependable operation in harsh operating environments
- Provides one pulse per tail pulley revolution









1 BROWN (+)
2 N/A
3 BLUE (-)
4 N/A

PIN CONFIGURATION

Electrical Specifications:
Supply Voltage - 24 VDC
Load Current - 200 mA, normally open

Operating Temperature:
-25° to +70°C (-13°F to +158°F)

Motion Detection Retrofit Kit

Conveyor Width	Part No.
2 in.	125-0335-02
3 in.	125-0335-03
4 in.	125-0335-04
6 in.	125-0335-06
8 in.	125-0335-08
10 in.	125-0335-10
12 in.	125-0335-12
18 in.	125-0335-18
24 in.	125-0335-24

Includes:

- (1) 4-pin two wire male connector
- (1) 4-pin two wire female connector
- (1) Mounting block and spring assembly
- (1) Mounting hardware kit
- (1) Template for mounting hole transfer
- (1) Detectable tail assembly
- (1) Proximity sensor

Note: This kit can only be ordered for installation of motion detection into an existing conveyor in the field

Note: Holes to be drilled in the field by the customer.

Installed Motion Detection Kit

Conveyor Width	Part No.
2 in.	125-0340-02
3 in.	125-0340-03
4 in.	125-0340-04
6 in.	125-0340-06
8 in.	125-0340-08
10 in.	125-0340-10
12 in.	125-0340-12
18 in.	125-0340-18
24 in.	125-0340-24

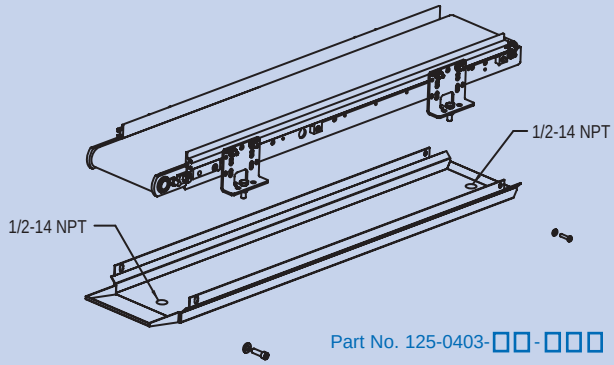
Includes:

- (1) 4-pin two wire male connector
- (1) 4-pin two wire female connector
- (1) Mounting block and spring assembly
- (1) Mounting hardware kit
- (1) Detectable tail assembly exchanged for the standard tail assembly
- (1) Proximity sensor
- (1) Installation of sensor kit into conveyor

Note: This kit can only be ordered with the purchase of a new conveyor

Note: Please denote a "D" in the tail pulley portion of conveyor part number

Drip Pans



Part No. 125-0403-□□-□□□

Features:
Attaches to standard width and length conveyors, and is ideal for recapturing oils and lubricants.

Note: Designed for use with fixed side rails that use side rail clamps and the universal adjustable side mount only.

To Order:
Fill in the last five digits of the part number with the width and length of the conveyor it is to be used on.
Part No. 125-0403-WW-LLL

Automation Accessories

90° Transfer Plate

Conveyor Width	Part No.
2 in.	125-0230-02
3 in.	125-0230-03
4 in.	125-0230-04
6 in.	125-0230-06
8 in.	125-0230-08
10 in.	125-0230-10
12 in.	125-0230-12
18 in.	125-0230-18
24 in.	125-0230-24

Notes:
Transfer plates are not intended for use with high friction or cleated belts.

Discharge conveyor must be pushing.

Customer to drill screw holes to mount plate.

Inline Transfer Plate

Conveyor Width	Part No.
2 in.	125-0220-02
3 in.	125-0220-03
4 in.	125-0220-04
6 in.	125-0220-06
8 in.	125-0220-08
10 in.	125-0220-10
12 in.	125-0220-12
18 in.	125-0220-18
24 in.	125-0220-24

Note:
Transfer plates are not intended for use with high friction or cleated belts.

Pivot Mount Set

Note:

The pivot mount attaches to the tail end of the conveyor and enables a pivot point from which other devices can lift the conveyor. Includes left and right hand mount.

To Order:
Part No. 125-0172-00

Custom Rolling Nosebars

Note:

The rolling nosebar can be used with a conveyor running less than 60 fpm and carrying less than 5 lbs. per inch of conveyor width.

To Order:
Please denote an 'SAF' in the belt portion of the conveyor part number, and an 'R' for the tail pulley part of the conveyor part number.

Example: 1ESBH04-048-ASR-SAF

Adjustable Stops

To Order:

1. Select an adjustable stop for 1" sides, 2" sides, or single tee slot (See pages 22 -24)

2. Using the chart below, fill in the part number using the nominal width of the conveyor for the last two digits of the part number

	Part No.
1" Sides	125-0232-WW
2" Sides	125-0234-WW
Single Tee Slot	125-0233-WW

Example: 125-0232-04
End Stop for a 4" wide conveyor that has 1" aluminum side rails with wear strip

Adjustable Diverters

Note:

The adjustable diverter comes with a 5' piece of UHMW rail and (2) mounting assemblies that the user can utilize to help orient the product around a 90° transfer.

To Order:
Part No. 125-0250-000