

How to Install Gravity Conveyor with H-Stands

1. Check to make sure you have all the components and tools you will need for installation.
 - a. Conveyors
 - b. Supports
 - c. Fasteners
 - d. Tools
 - e. Concrete anchors (optional)

2. Set your support heights (TOS) to reflect the Top of Roller (TOR) that you require.

TOS = TOR - (Height the roller sits above the frame) - (Frame Height)

Example: If you are using an Ashland Conveyor Products 2-1/2" frame with a 1-3/8" roller, your roller will sit 1/4" above the frame. If you would like your TOR to be 35", then TOS = 35 - .25 - 2.5, or 32-1/4"

You will need to slope your conveyor run to allow your product to move smoothly down the line. Slopes will vary depending on what product you are moving; use the chart to the side as a guide. After your slope is determined, use the TOS calculation to set the remainder of your supports to the correct heights.

Example: You have a starting TOS of 32-1/4" and you will be moving a 100 lb tote over 20'. Your required slope is 2-1/2" drop per 10'. The TOS of your second and third supports should be set at 29-3/4" and 27-1/4".

*These calculations and charts are a guide, a field test should be completed to assure proper flow.

3. Set your first support in place and use either a fork lift or manpower (depending on weight of conveyor) to lift a section of conveyor. Place it just on top of the bracket (called the smiley bracket) of the first support. Use your fasteners to attach the conveyor and bracket together.
4. Repeat step 3 with the second and third supports. Keep in mind that the second support will bridge both the first and second sections of conveyor, so make sure to attach one fastener on each of the conveyors splitting the smiley bracket between the two units.
5. Install any accessories at this point. Ie. Guard rail or end stops
6. Check the flow of product down the conveyor. Make any necessary adjustments to get the desired flow. Once product moves satisfactorily, check all fasteners to make sure they are tight.

Item	Weight (Lbs.)	Slope Required To Start And Move Product	
		Inches/Foot	Inches/10'
Firm Cartons	5	7/8"	9"
	10	3/4"	7-1/2"
	50	1/2"	5"
	100	3/8"	3-3/4"
Steel Drums	150	3/8"	3-3/4"
	300	1/4"	2-1/2"
Tote	10	1/2"	5"
	25	3/8"	3-3/4"
	50	5/16"	3-1/8"
	100	1/4"	2-1/2"
Pallet With Runners	50	1/2"	5"
	100	7/16"	4-3/8"
	250	3/8"	3-3/4"
	500	5/16"	3-1/8"



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