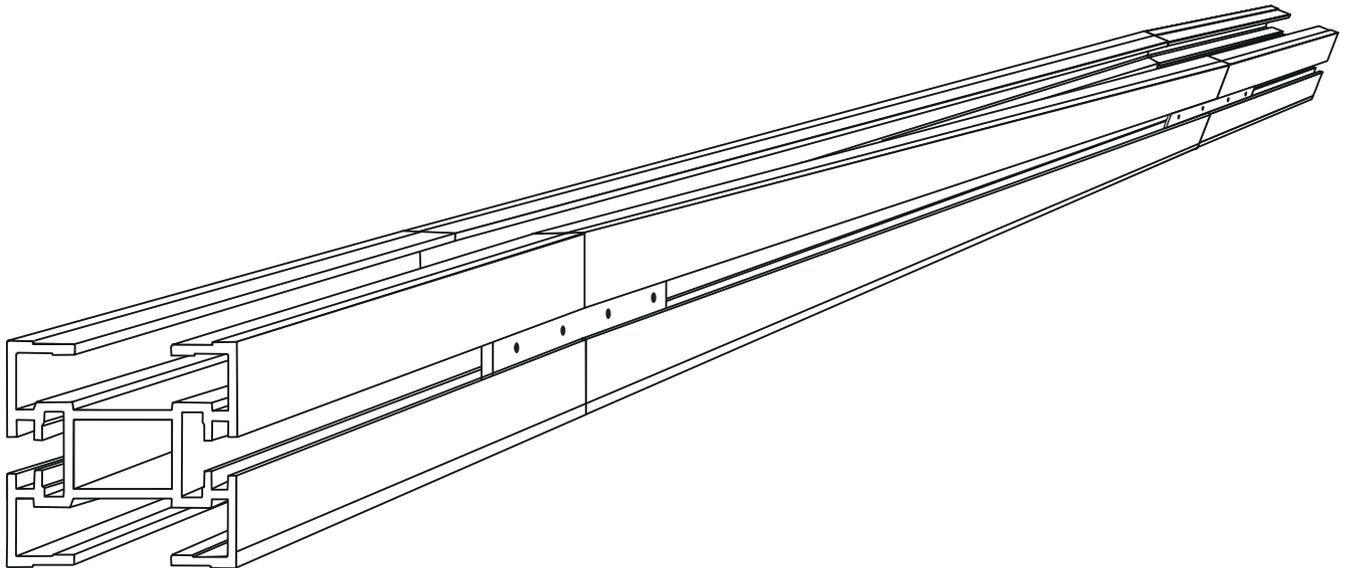


Assembly instruction- Conveyor system X45H, XL, X65, XM, X85 and XH



Twisted Beams

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

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

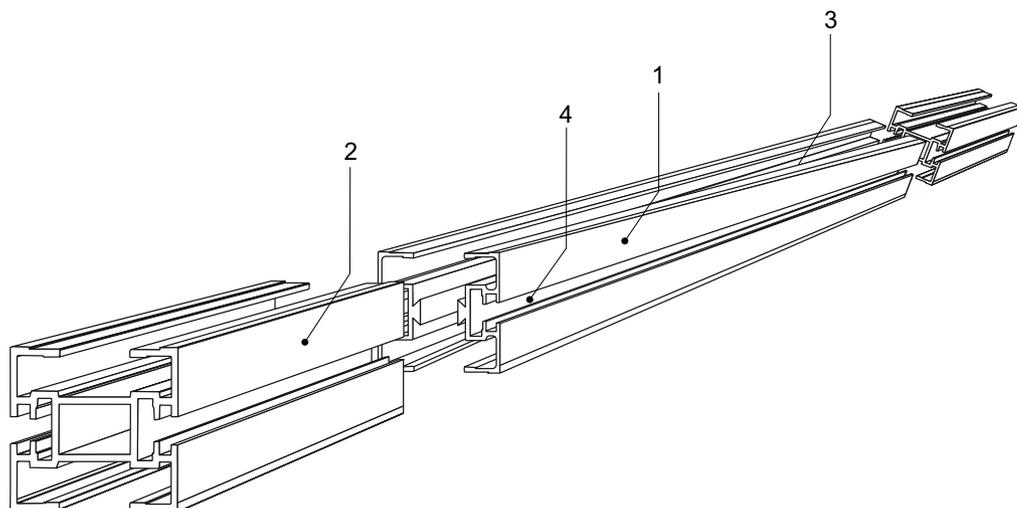
This bulletin is an instruction on how to make twisted beams

Twisted beam

Components

A twisted beam consists of three beam sections: two short pieces of standard conveyor beam and one split beam section. Note that slide rail XLCR 3 T (stainless steel) is not suitable for twisted beams.

The illustration and tables below show what components the twisted beam consists of. Page 4 contains a short instruction on how to twist the split beam.



Conveyor system X45H

Position	Amount	Designation	Description
1	2	XTCB 6 H	XT split beam
2	2	XTCB L	XT standard beam, 160 mm
3	See following page	XTVCE 19x20	Complete mounting clips
4	8	XLCJ 5x140	Connecting strip

Conveyor system XL

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

Conveyor system X65

Position	Amount	Designation	Description
1	2	XLCB 3A65H	X65 split beam
2	2	XLCB LA65	X65 standard beam, 160 mm
3	See following page	XLCE A65	Spacer
4	4	XLCJ A65	Connecting bracket

Conveyor system XM

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

Conveyor system XH

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

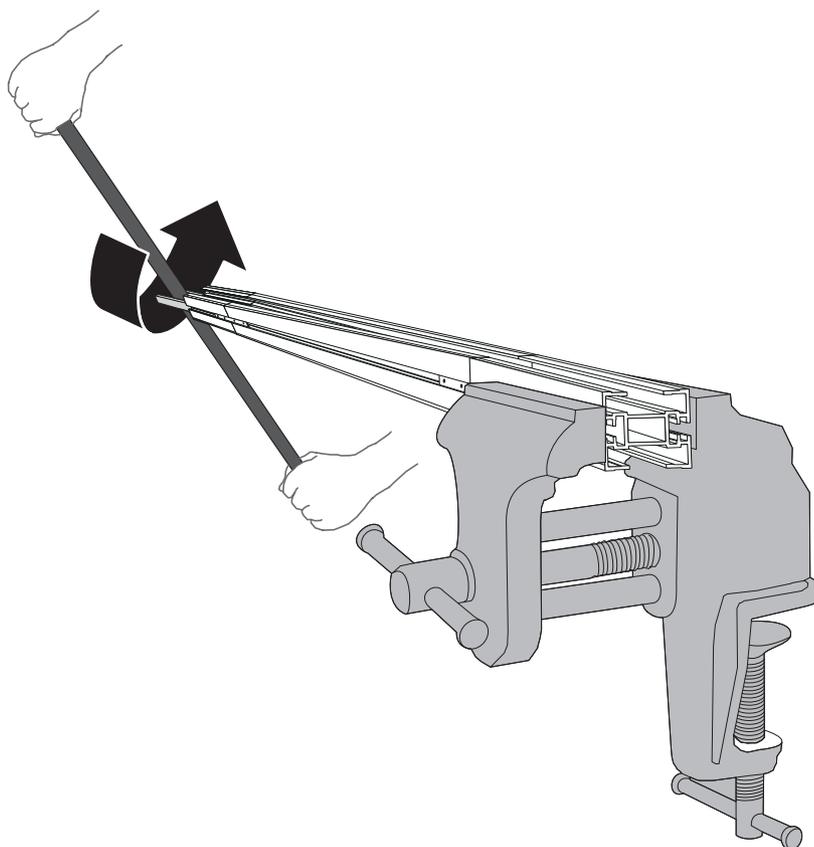
Conveyor system X85

Position	Amount	Designation	Description
1	2	5043914	X85 split beam
2	2	XBCB LA85	X85 standard beam, 160 mm
3	See following page	XBCE 42x20	Complete mounting clips
4	8	XSCJ 6x130	Connecting strip

Twisting a split beam

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

The twist degree of the split beam has to be proportional with the length and type of beam required (X45H, XL, X65 XM, X85 or XH). See tables below for further details.



Conveyor system XL, X45H, X65

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

Conveyor system XM

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

Conveyor system XH

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

Conveyor system X85

Twist degree (left or right)	Cutting length (mm)	Number of clips required
± 15°	1050	5 pcs
± 20°	1150	6 pcs
± 30°	1700	9 pcs
± 45°	2500	13 pcs
± 60°	3350	17 pcs
± 90°	5000	25 pcs