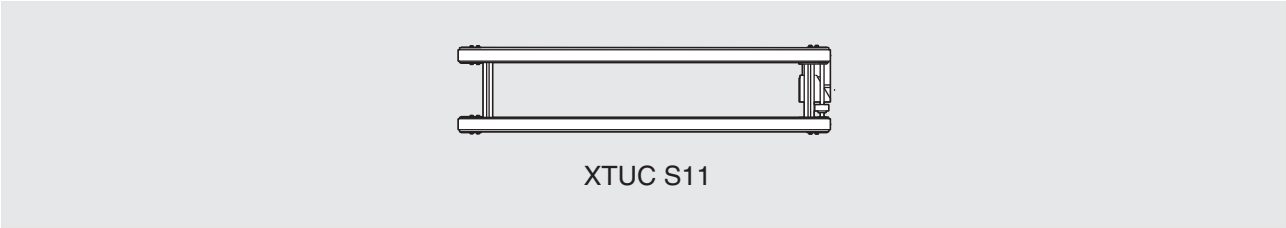


Contents

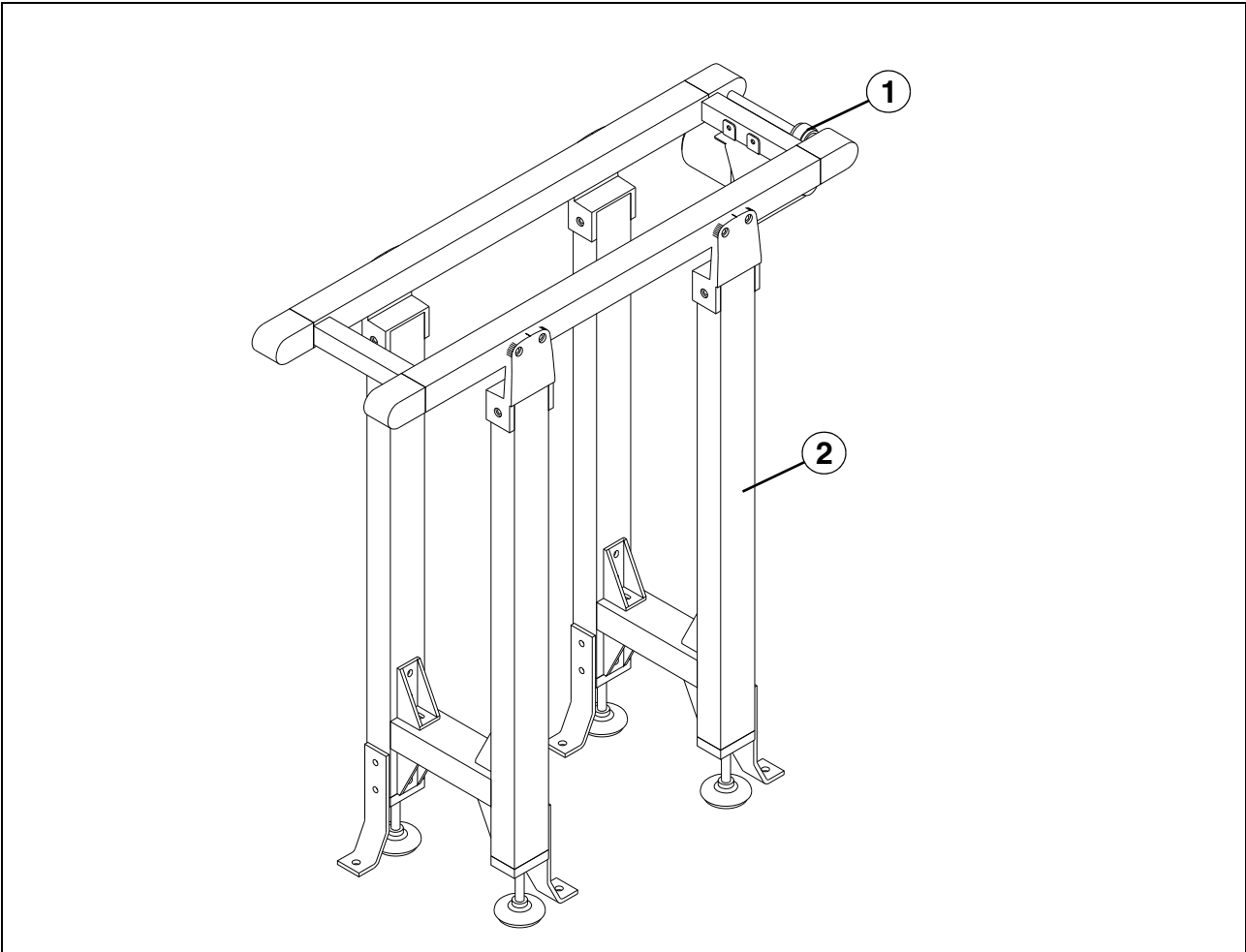
Conveyor module XTUC S11	6
Conveyor module XTUC S51	6
Conveyor module XTUC J51/J52	6
Conveyor module XTUC L51/L52	6
Conveyor module XTUC U51/U52	6
Conveyor module XTUC Z51/Z52	6
Conveyor module XTUC F51/F52	6
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Support module XTUF S01A	6
Support module XTUF S02A	6
Support module XTUF S03A	6
Support module XTUF S04	6
Stop function module XTUS P11	6
Locating function module XTUL P11A	6
Transfer function module XTUT S10 A	6
Transfer function module XTUT S11 A	6
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Transfer function module XTUT R12 A	6
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Work station function module XTUW R11 A	6
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Conveyor module S11 Compact

Overview

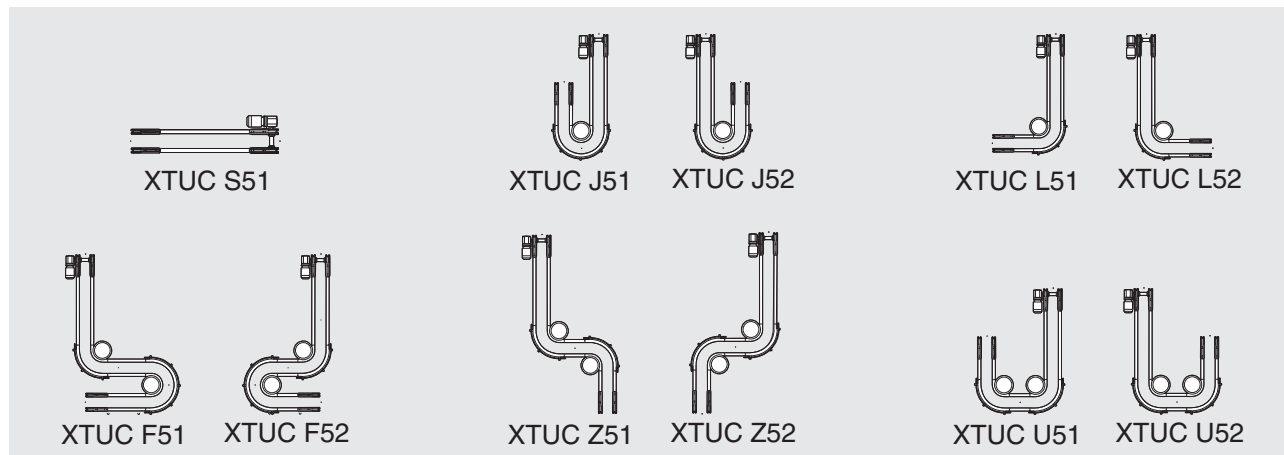


Assembly order

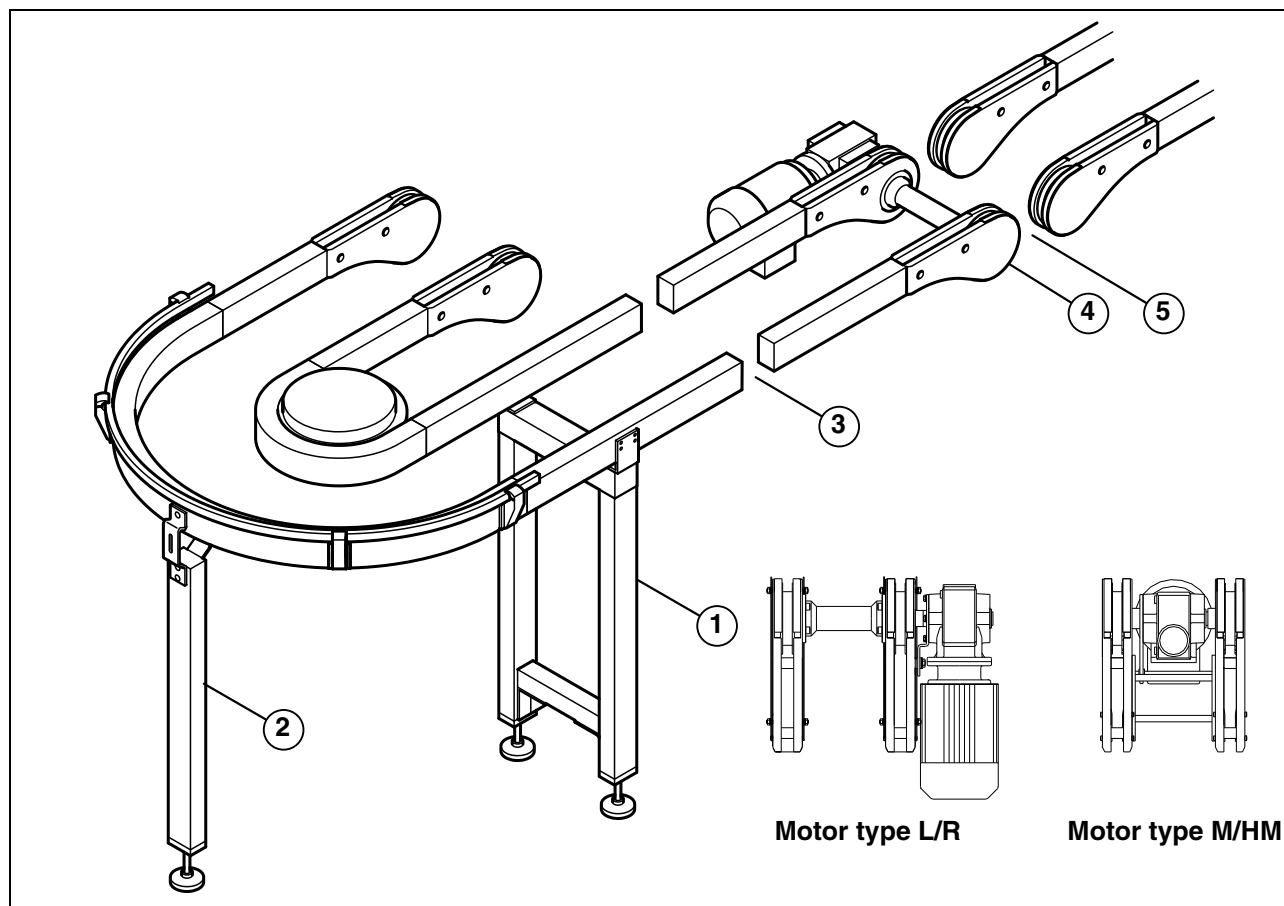


Pos	Name	Instruction
1	Connecting motor	See page 19
2	Mounting support module	See page 35

Overview

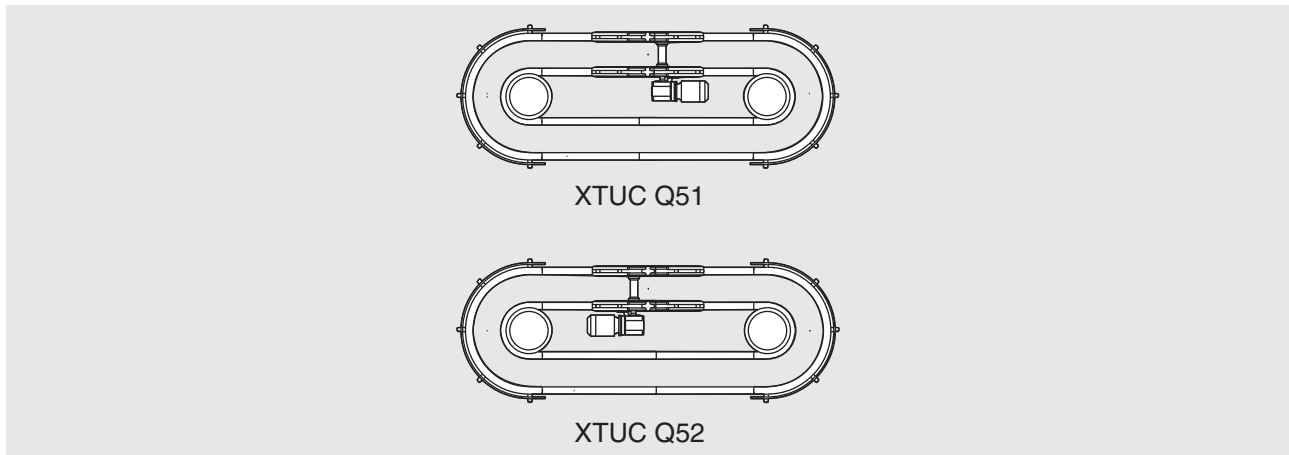


Assembly order

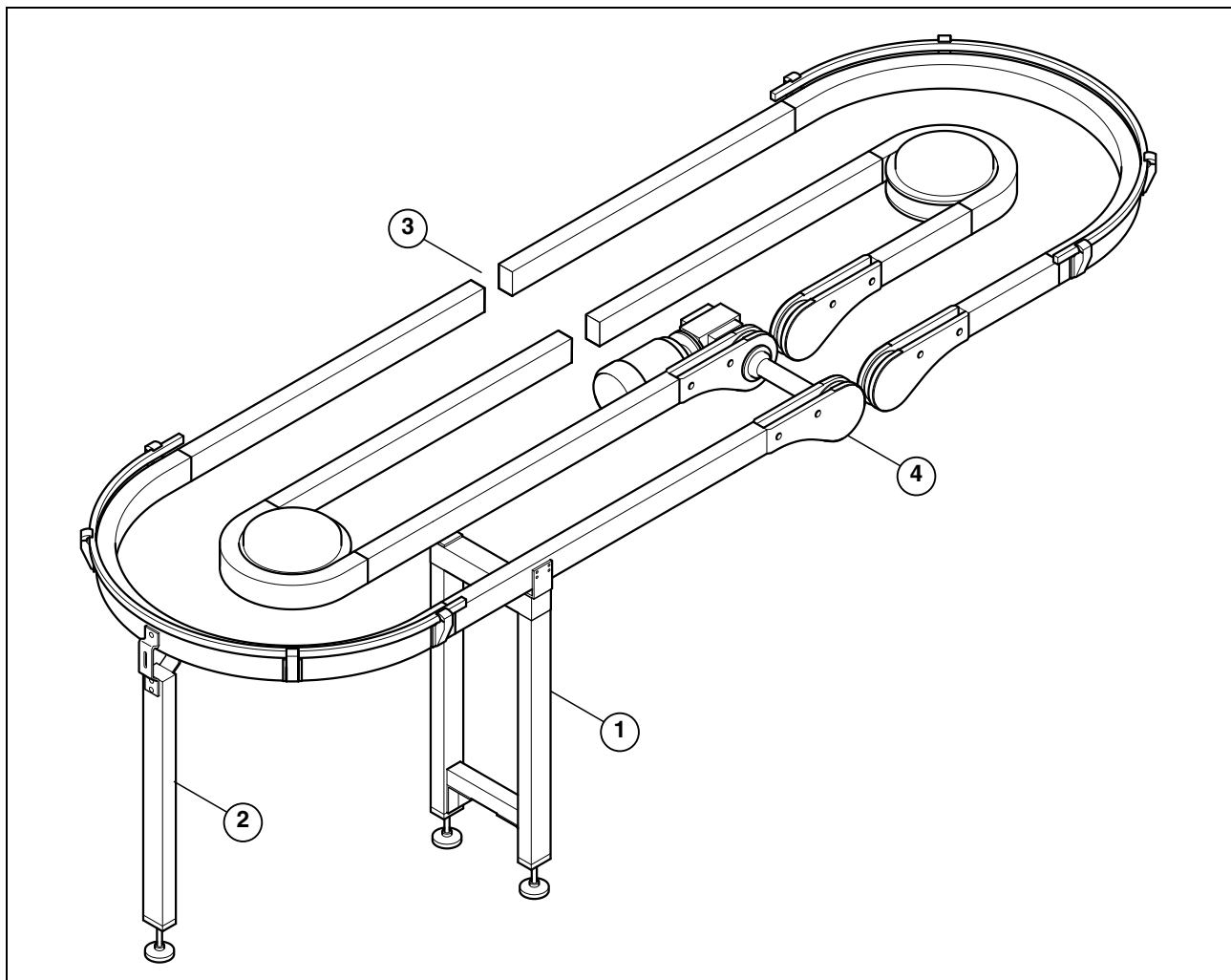


Pos	Name	Instruction
1	Mounting support module	See page 35
2	Mounting support module in bend	See page 35
3	Docking XT conveyor sections	See page 20
4	Mounting chain to XT conveyor modules	See page 22
5	Connecting an XT conveyor module in line with another XT conveyor:	
	-Motor type L or R	See page 31
	-Motor type M or HM	See page 33

Overview

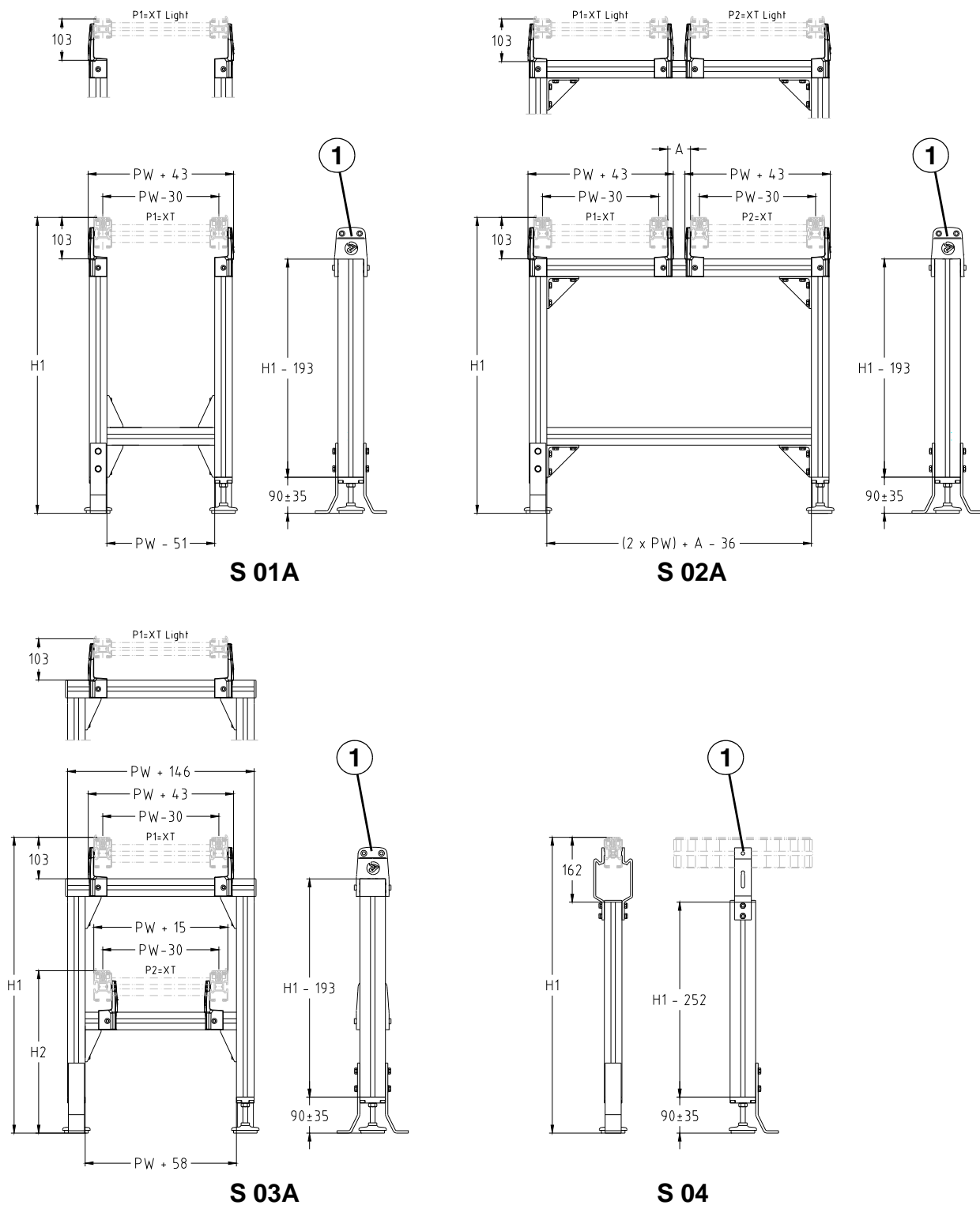


Assembly order



Pos	Name	Instruction
1	Mounting support module	See page 35
2	Mounting support module in bend	See page 35
3	Docking XT conveyor sections	See page 20
4	Mounting chain to XT conveyor module	See page 26

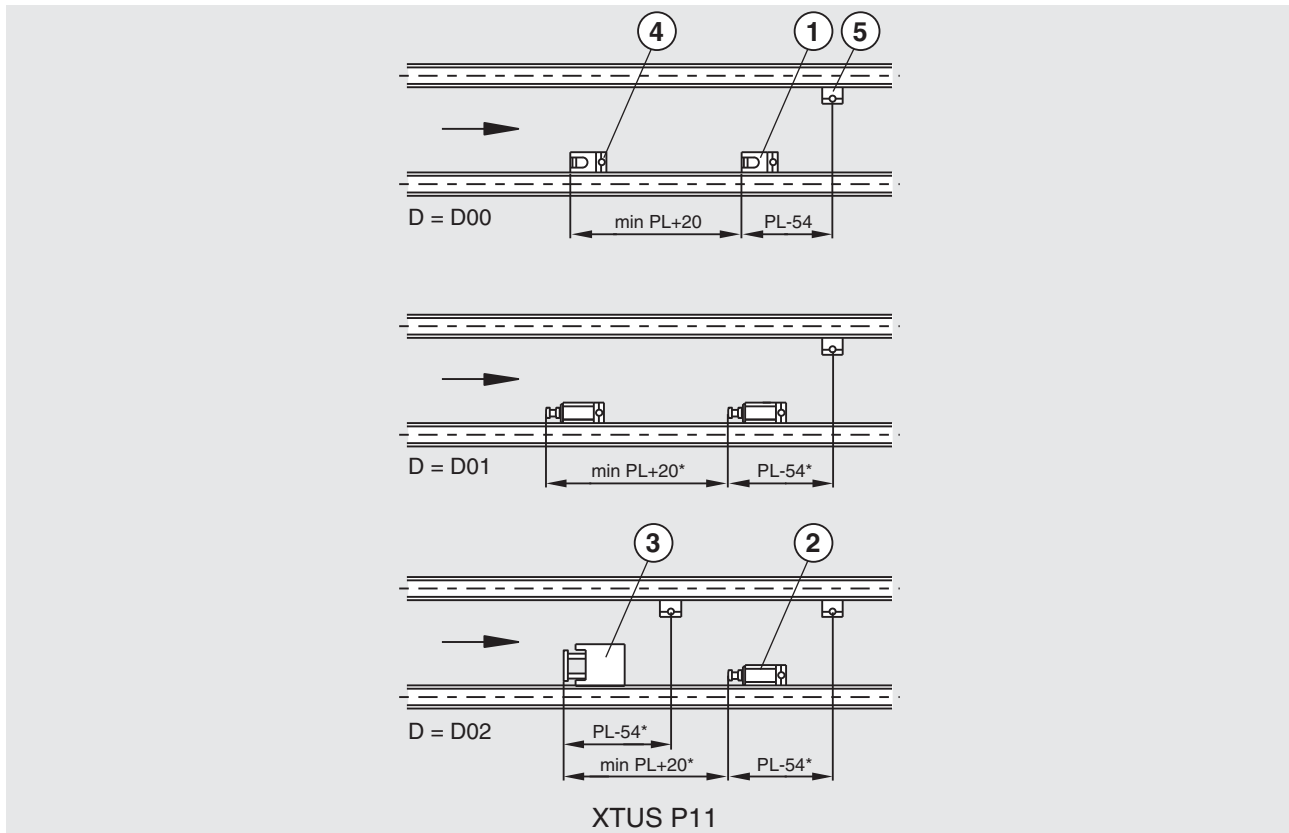
Overview



Pos	Name
1	Mounting support module

Instruction
See page 35

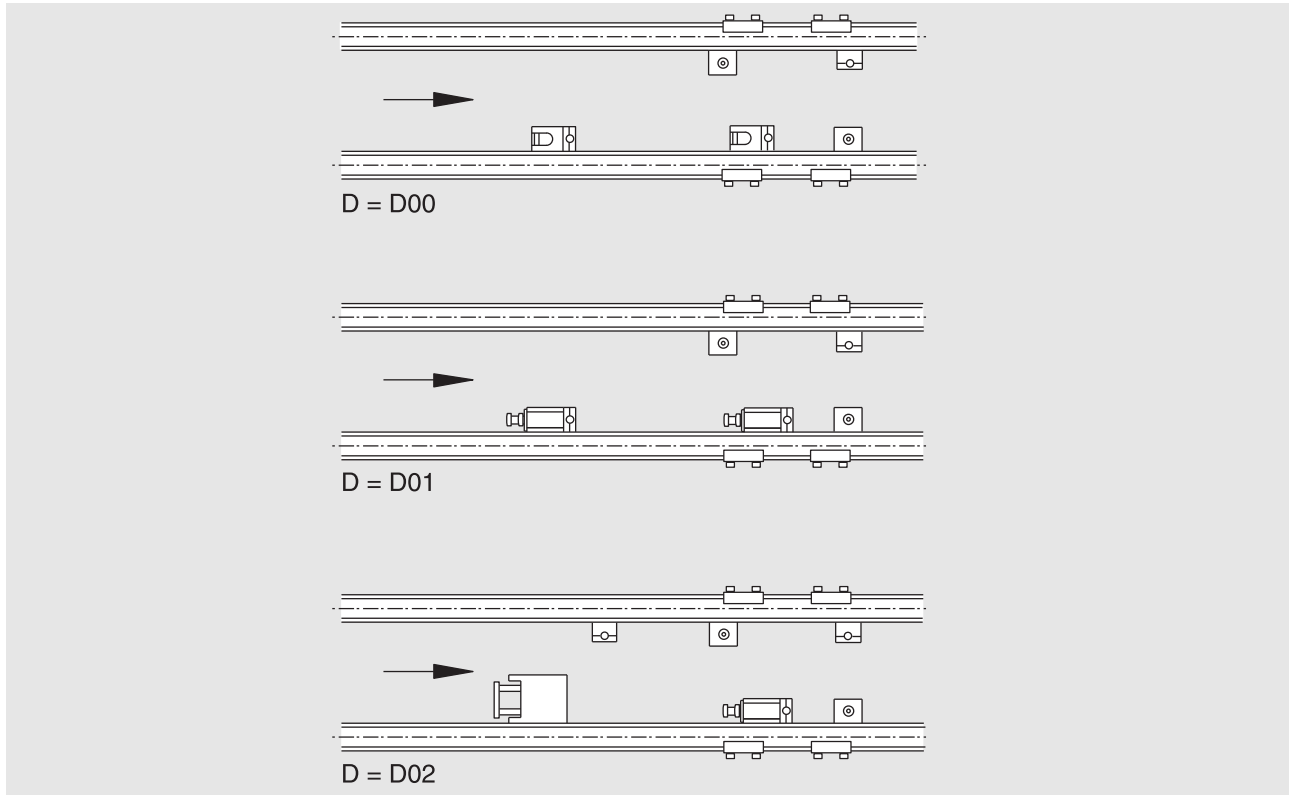
Overview



* With stop heel compressed

Pos	Name	Designation	Instruction
1	Pallet stop device	XTPD U200	See page 38
2	Pallet stop device damped	XTPD D35	See page 40
3	Pallet stop device damped	XTPD D100	See page 42
4	Sensor bracket	XTPB V001	See page 43
5	Sensor bracket	XTPB V002	See page 45

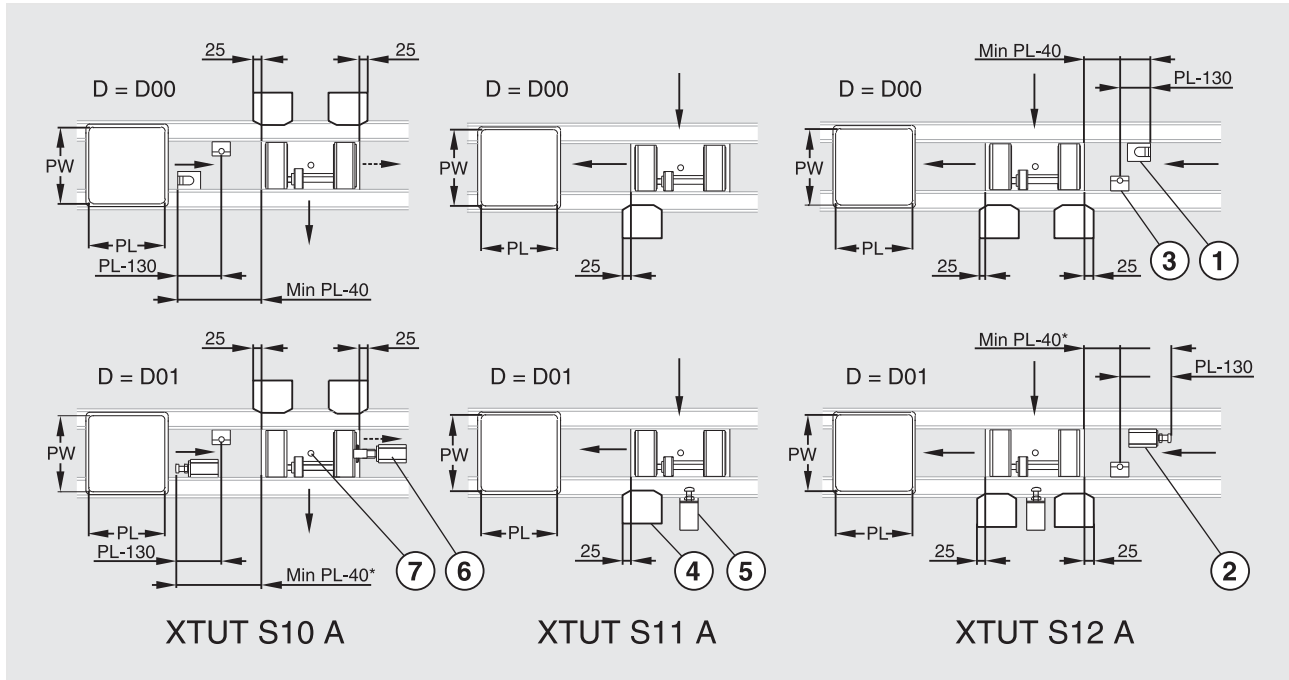
Overview



Placement of stop and sensor brackets, see Stop function module P11.

Pos	Name	Designation	Instruction
1	Pallet stop device	XTPD U200	See page 38
2	Pallet stop device damped	XTPD D35	See page 40
3	Pallet stop device damped	XTPD D100	See page 42
4	Sensor bracket	XTPB V001	See page 43
5	Sensor bracket	XTPB V002	See page 45
6	Locating station	XTPX P11A	See page 52

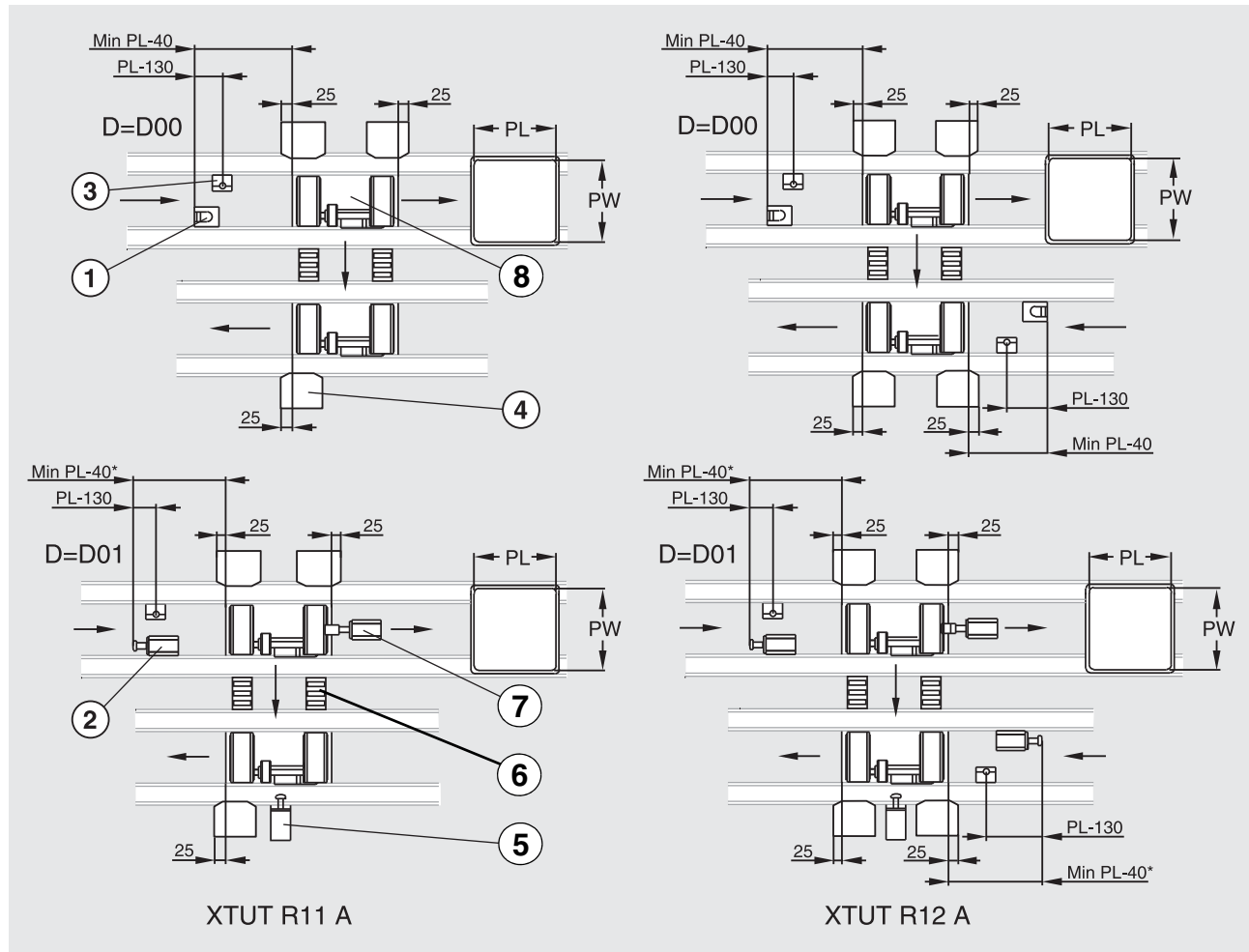
Overview



* With stop heel compressed

Pos	Name	Designation	Instruction
1	Pallet stop device	XTPD U200	See page 38
2	Pallet stop device damped	XTPD D35	See page 40
3	Sensor bracket	XTPB V002	See page 45
4	Position sensor	XTPB V003	See page 46
5	Damper	XTPA CM35	See page 49
6	Damper	XTPA MC35 PW A	See page 57
7	Mounting transfer unit	XTPT	See page 57

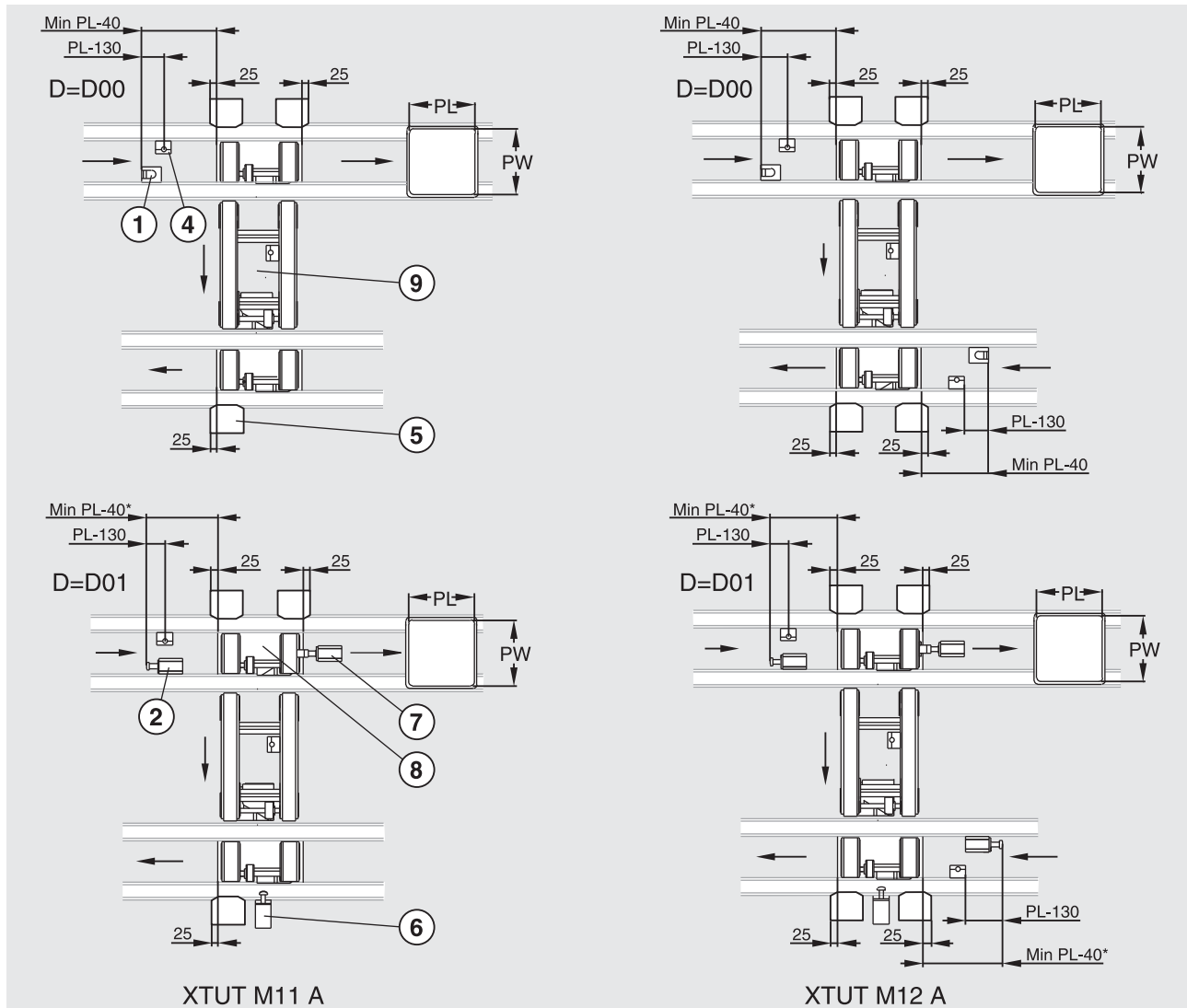
Overview



* With stop heel compressed

Pos	Name	Designation	Instruction
1	Pallet stop device	XTPD U200	See page 38
2	Pallet stop device damped	XTPD D35	See page 40
3	Sensor bracket	XTPB V002	See page 45
4	Position sensor	XTPB V003	See page 46
5	Damper	XTPA CM35	See page 49
6	Roller kit	5049865, 5050117	See page 50
7	Damper	XTPA MC35 PW A	See page 57
8	Mounting transfer unit	XTPT	See page 57

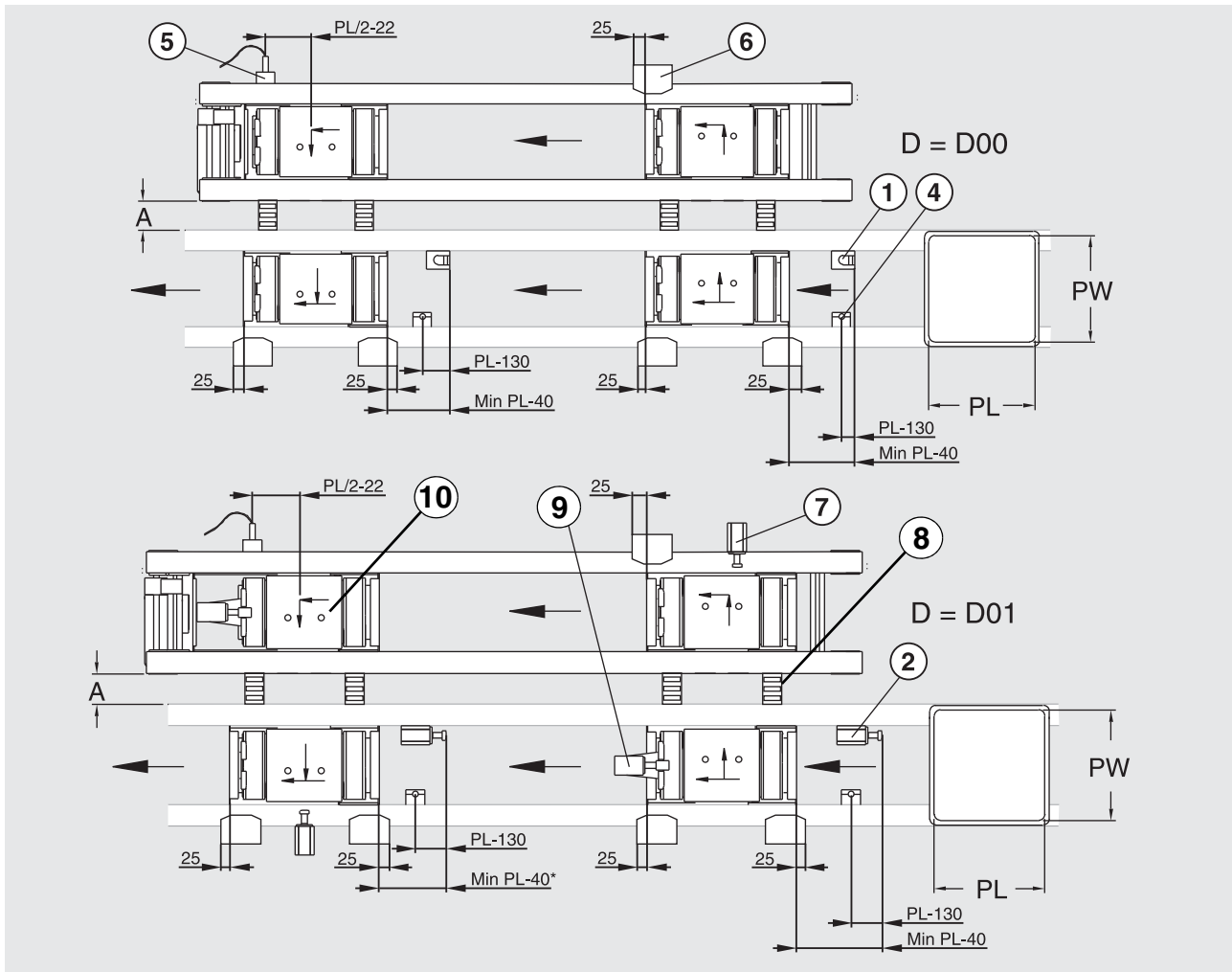
Overview



* With stop heel compressed

Pos	Name	Designation	Instruction
1	Pallet stop device	XTPD U200	See page 38
2	Pallet stop device damped	XTPD D35	See page 40
3	Sensor bracket (not in picture)	XTPB V001	See page 43 (only for option Q01)
4	Sensor bracket	XTPB V002	See page 45
5	Position sensor	XTPB V003	See page 46
6	Damper	XTPA CM35	See page 49
7	Damper	XTPA MC35 PW A	See page 57
8	Mounting transfer unit	XTPT	See page 57
9	Mounting connecting kit	5050034	See page 51

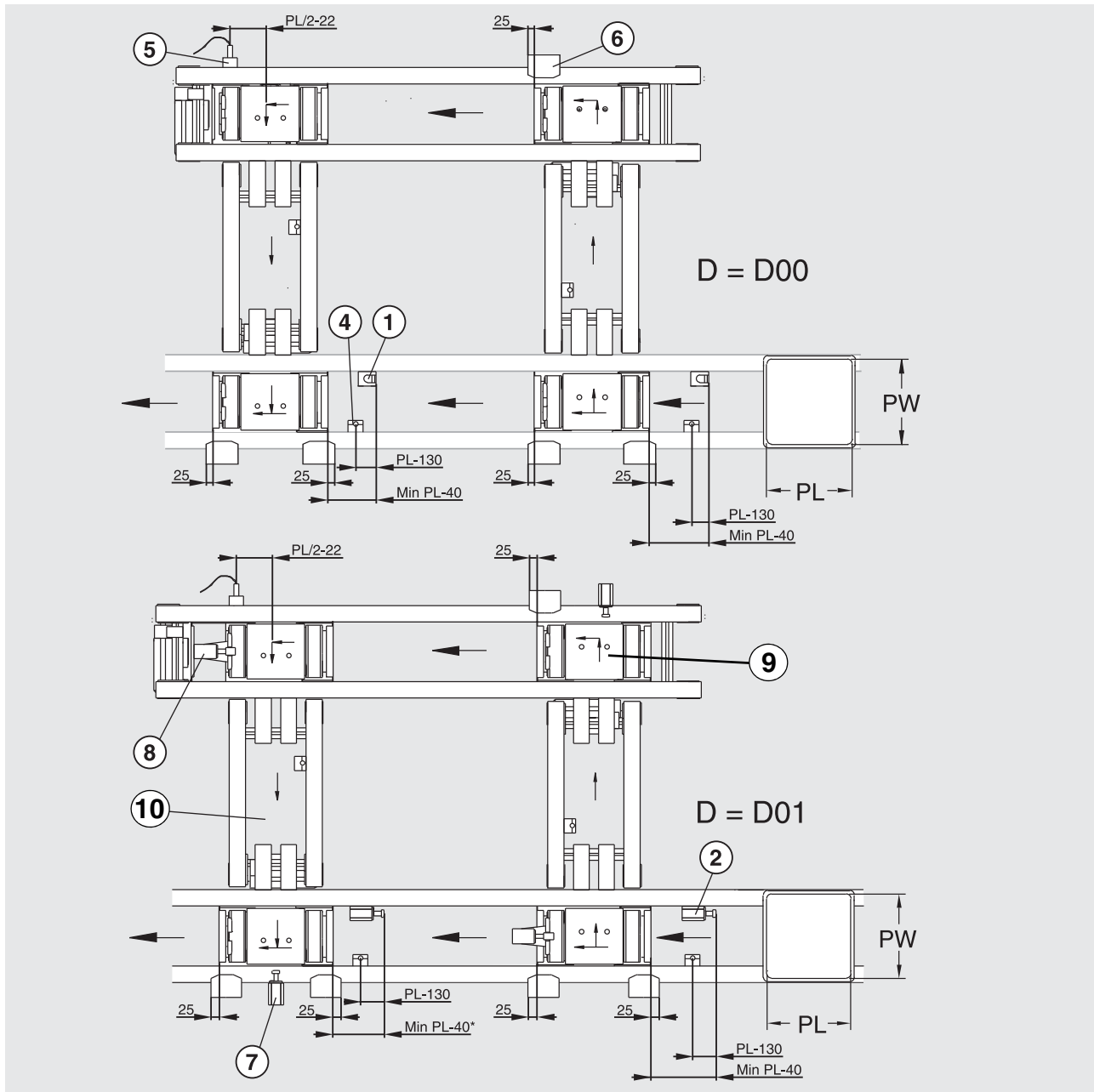
Overview



* With stop heel compressed

Pos	Name	Designation	Instruction
1	Pallet stop device	XTPD U200	See page 38
2	Pallet stop device damped	XTPD D35	See page 40
3	Sensor bracket (not in picture)	XTPB V001	See page 43 (only for option S01 & L01).
4	Sensor bracket	XTPB V002	See page 45
5	Sensor bracket	XTPB H001	See page 48
6	Position sensor	XTPB V003	See page 46
7	Damper	XTPA CM35	See page 49
8	Roller kit	5049865, 5050117	See page 50
9	Damper	XTPA MC35 PW A	See page 57
10	Mounting transfer unit	XTPT	See page 57

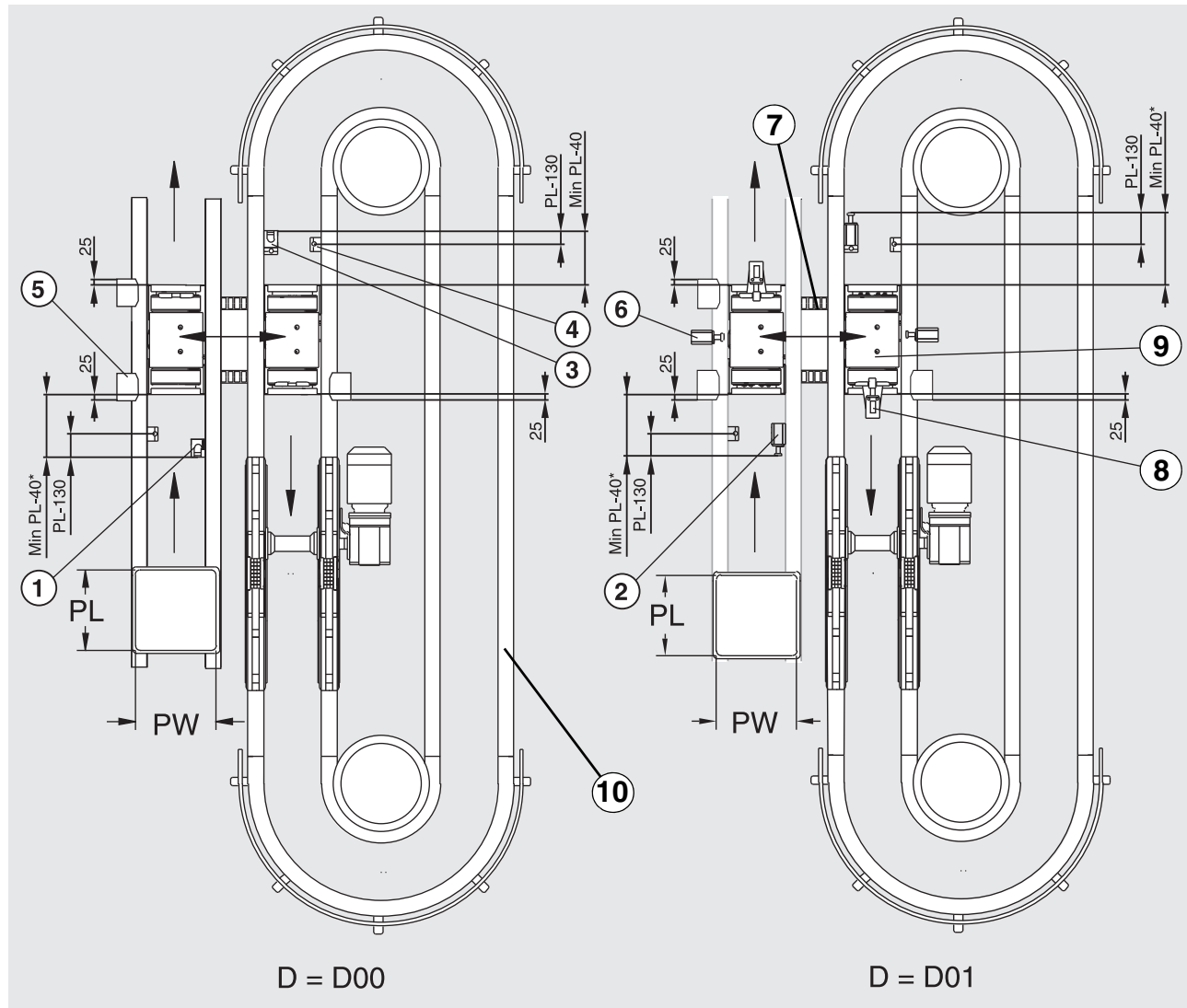
Overview



* With stop heel compressed

Pos	Name	Designation	Instruction
1	Pallet stop device	XTPD U200	See page 38
2	Pallet stop device damped	XTPD D35	See page 40
3	Sensor bracket (not in picture)	XTPB V001	See page 43 (only for option Q01, S01 & L01).
4	Sensor bracket	XTPB V002	See page 45
5	Sensor bracket	XTPB H001	See page 48
6	Position sensor	XTPB V003	See page 46
7	Damper	XTPA CM35	See page 49
8	Damper	XTPA MC35 PW A	See page 57
9	Mounting transfer unit	XTPT	See page 57
10	Mounting connecting kit	5050034	See page 51

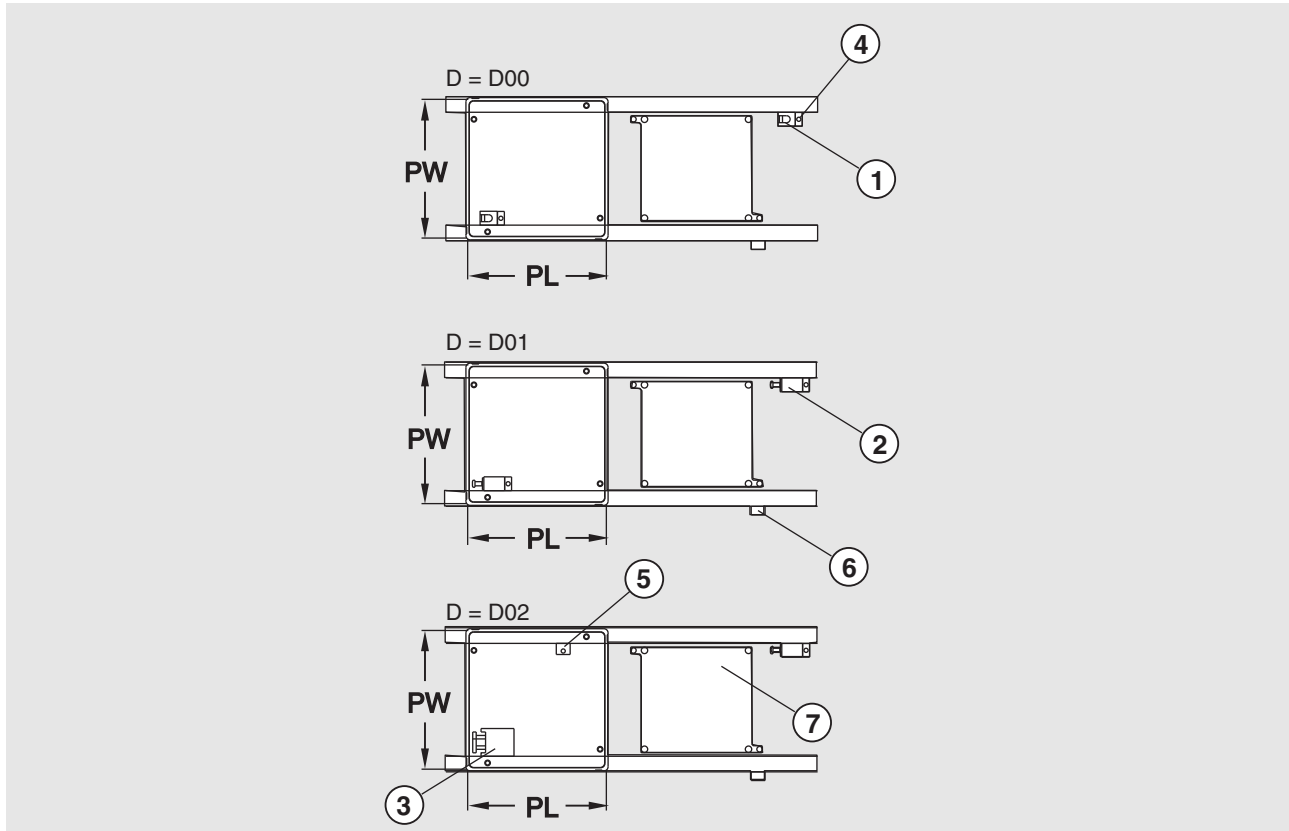
Overview



* With stop heel compressed

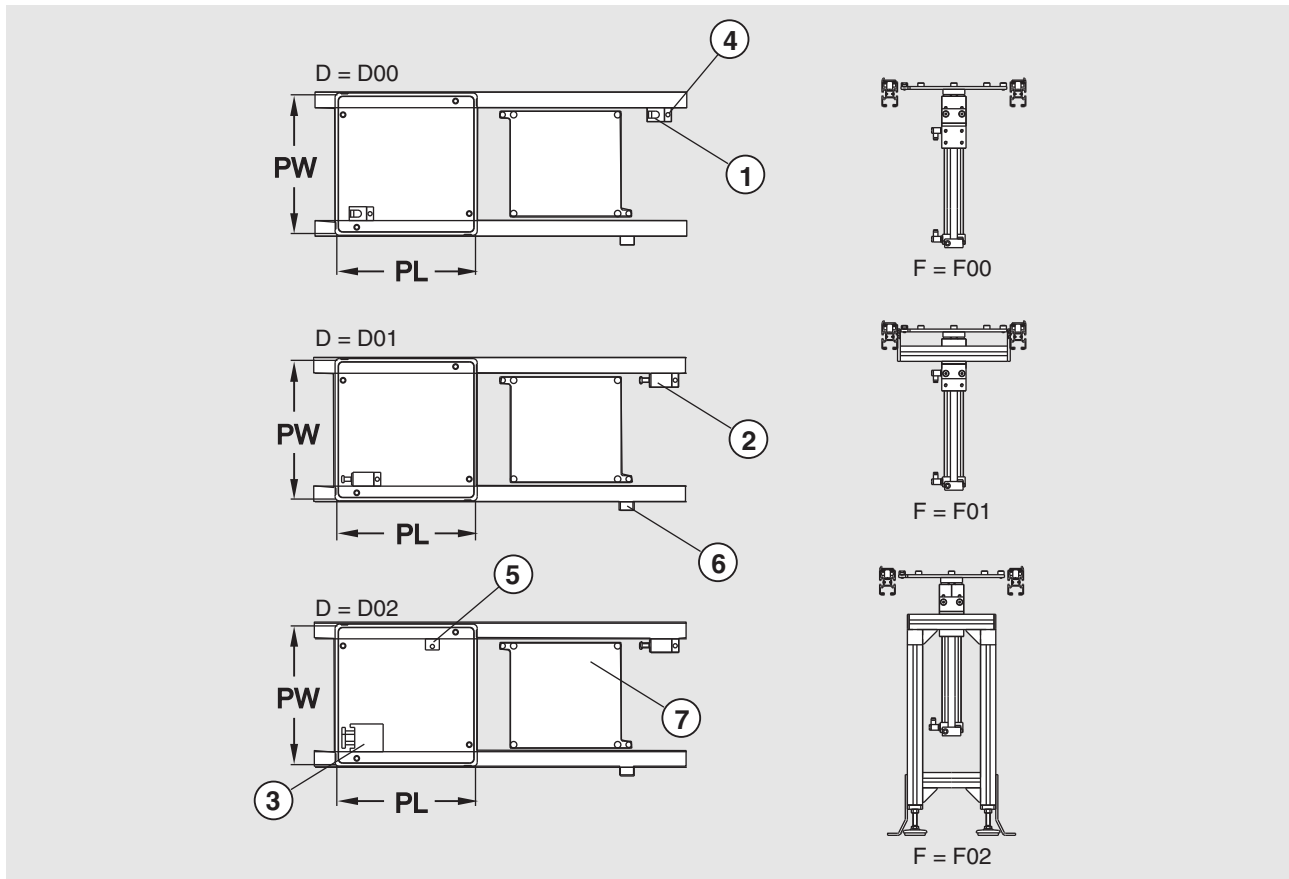
Pos	Name	Designation	Instruction
1	Pallet stop device	XTPD U200	See page 38
2	Pallet stop device damped	XTPD D35	See page 40
3	Sensor bracket	XTPB V001	See page 43
4	Sensor bracket	XTPB V002	See page 45
5	Position sensor	XTPB V003	See page 46
6	Damper	XTPA CM35	See page 49
7	Roller kit	5049865, 5050117	See page 50
8	Damper	XTPA MC35 PW A	See page 57
9	Mounting transfer unit	XTPT	See page 57
10	Mounting conveyour module	XTUC Q51	See page 5

Overview



Pos	Name	Designation	Instruction
1	Pallet stop device	XTPD U200	See page 38
2	Pallet stop device, damped	XTPD D35	See page 40
3	Pallet stop device, damped	XTPD D100	See page 42
4	Sensor bracket	XTPB V001	See page 43
5	Sensor bracket	XTPB V002	See page 45
6	Sensor bracket	XTPB H001	See page 48
7	Mounting lift and rotate unit	XTUR P11	See page 68

Overview



Pos	Name	Designation	Instruction
1	Pallet stop device	XTPD U200	See page 38
2	Pallet stop device, damped	XTPD D35	See page 40
3	Pallet stop device, damped	XTPD D100	See page 42
4	Sensor bracket	XTPB V001	See page 43
5	Sensor bracket	XTPB V002	See page 45
6	Sensor bracket	XTPB H001	See page 48
7	Mounting lift and locate unit	XTUL P12	See page 70

Mounting instructions

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Mounting pallet stop device XTPD U200	38
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Mounting pallet stop device XTPD D100	42
Mounting sensor bracket XTPB V001	43
Mounting sensor bracket XTPB V002	45
Mounting position sensor XTPB V003	46
Mounting sensor bracket XTPB H001	48
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Mounting connecting kit 5050034	51
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Mounting transfer unit XTPT M2	60
Mounting transfer unit XTPT L	63
Mounting damper MC 35 PW A	67
Mounting lift and rotate unit XTUR P11	68
Mounting lift and locate unit XTUL P12	70

Connecting motor XTUC S11

Introduction

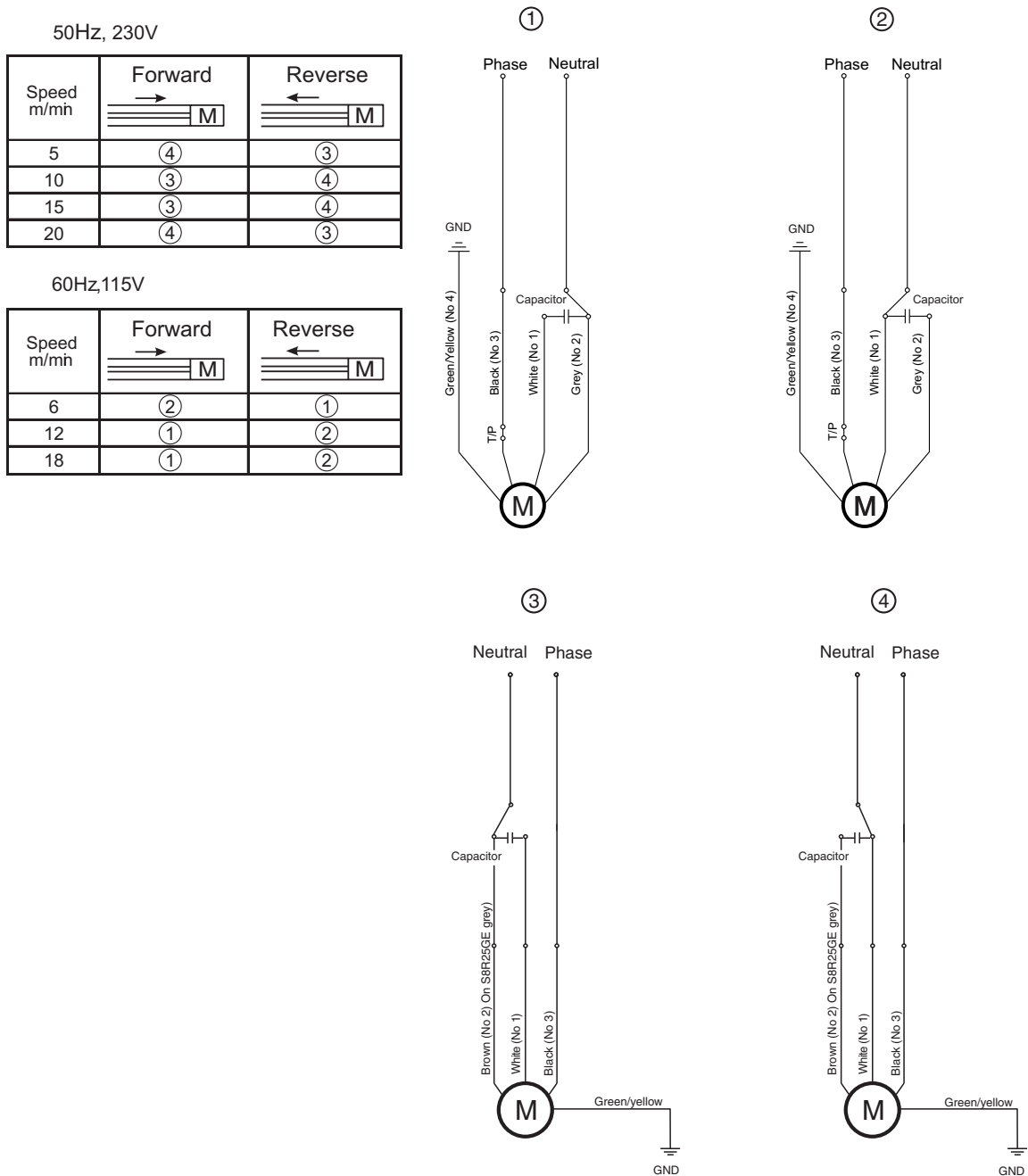
NOTE! The capacitor must always be encapsulated to prevent electric shock.

Tools

-

Instruction

- 1 Connect the motor according to wiring diagram below.



Introduction

This instruction is only valid for conveyor XT.

NOTE! A short or narrow conveyor can easily fall over.
Always anchor the conveyor to the floor!

Tools

Allen key 4 mm

Instruction

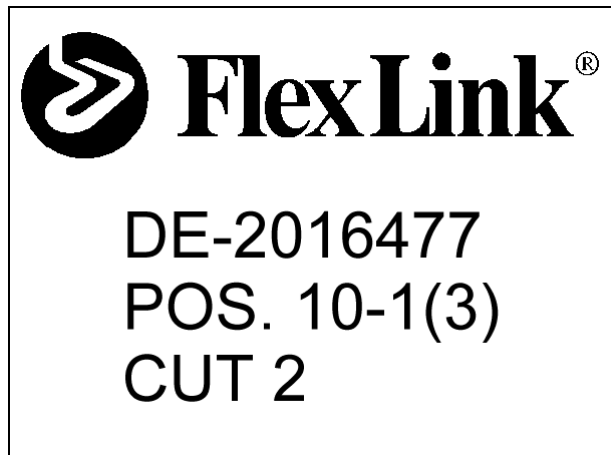
- 1 The section labels indicate following:

First row is the order number.

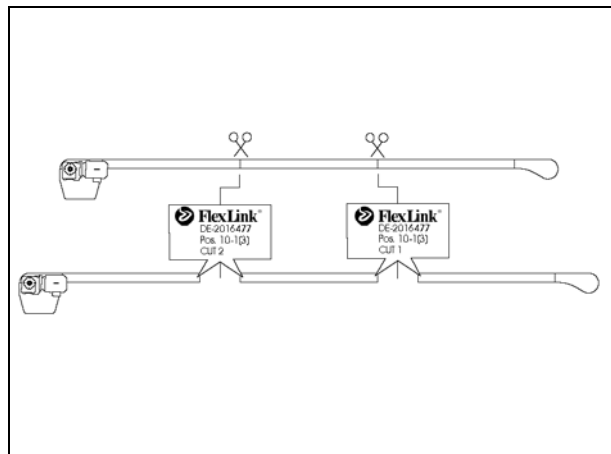
Second row indicates the item position on the order and which individual among a quantity, e.g. Pos. 10 first conveyor of three.

The third row indicates which cut it is.

Two sections with identical labels should be connected to each other.



- 2 Unpack the conveyor sections and arrange them so that beam ends with identical labels are facing each other. Place the conveyor sections on the same level and in line with each other.



- 3 Dock the conveyor sections to each other.



- 4 Make sure that the conveyor section ends fit together properly.



- 5 Tighten the screws. Use the 4 mm allen key.
Torque value for tightening: 6 Nm



- 6 Press the slide rail in place.



Introduction

Valid for motor types M and HM (centre mounted motor) and L and R (side mounted motor). If nothing else is specified the instruction step is valid for both centre and side mounted motor.

Tools

Box wrench	10 mm
Box wrench	7 mm
Skip joint pliers	
Pin insertion tool	
Screwdriver	

Instruction

1 Side mounted motor:

Use the screwdriver to remove the plastic cap on the motor. Loosen the screw for the motor with the 10 mm socket wrench.

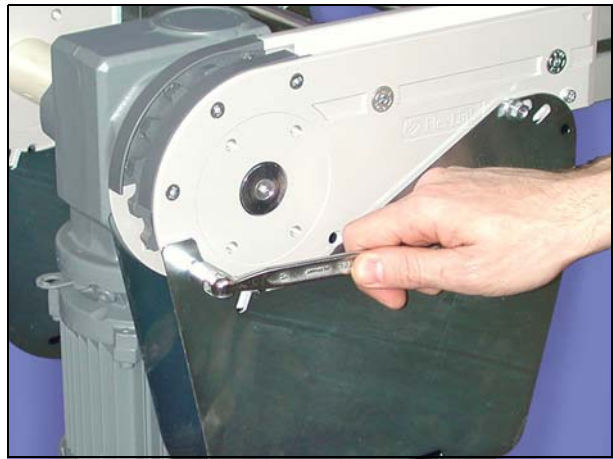


2 Side mounted motor:

Lift off the motor and remove the plastic sleeve.



- 3 Remove the nuts for the slack protection. Use a 10 mm box wrench.



- 4 Notice the label Left and Right on the chain. Mount the chain to the conveyor with similar mark.



- 5 Insert the chain from below, with the nose forward.
Repeat the same procedure with the other chain.



- 6 Feed the chains into the conveyor until they reach the drive wheel at the driving end.



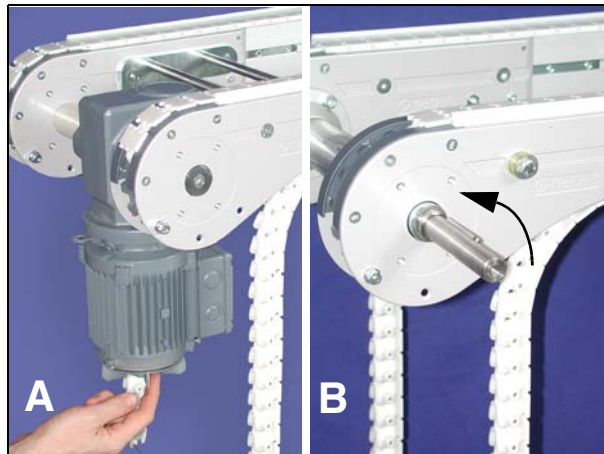
7 Centre mounted motor (A):

Remove the fan cover. Use the 7 mm box wrench. Feed the chains to the drive wheel and turn the fan until the chains are hanging a bit below the conveyor.

Side mounted motor (B):

Feed the chains to the drive wheel and turn the drive shaft until the chains are hanging a bit below the conveyor.

CAUTION! Make sure that the chain enters the drive wheel correctly. Risk for the plastic guides to brake.

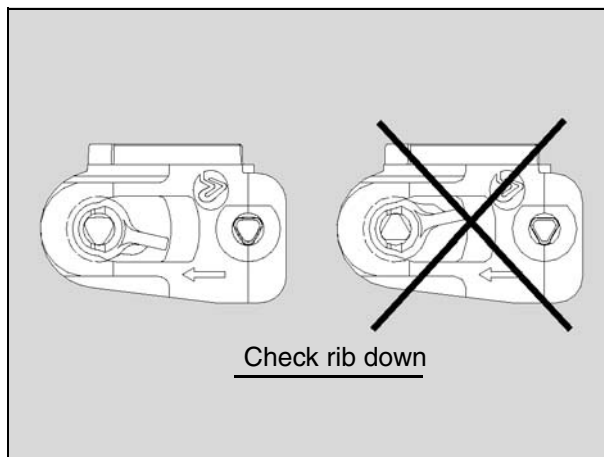


- 8 Use a pair of slip joint pliers to insert the pin half-way into the chain link.



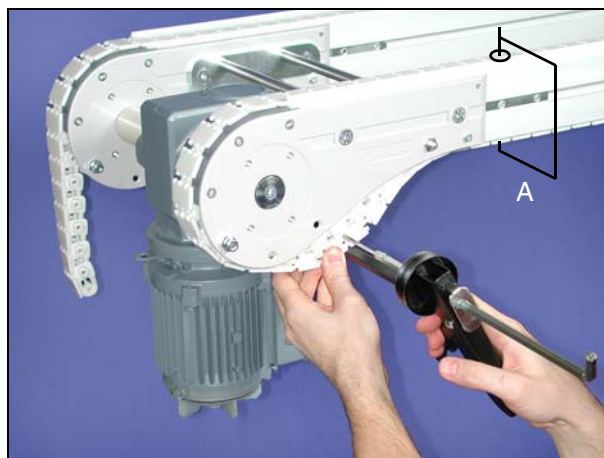
- 9 Join the chain ends. Make sure that the joint ball has not been removed and re-assembled upside down.

CAUTION! Wrongly positioned joint ball will lead to chain damage when running the chain.

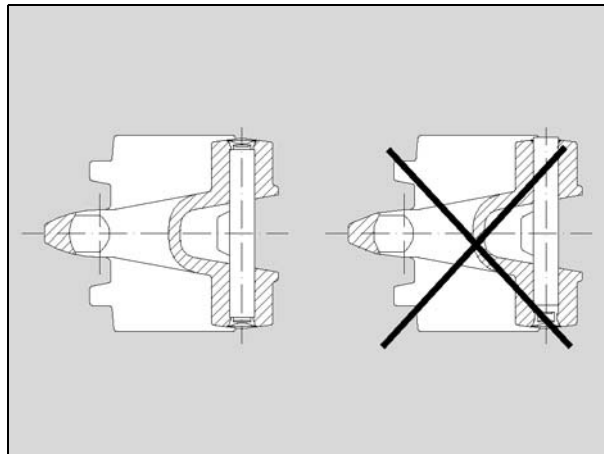


- 10 Press the pin through the chain. Use the pin insertion tool.

TIP! Use a clamp (A) to keep the chain stretched.



- 11 Make sure that the pin snaps in to the correct position (centered).



12 Centre mounted motor:

Fit the fan cover to the motor and tighten the screws. Use the 7 mm box wrench. Fit the slack protections and tighten the nuts. Use the 10 mm box wrench.

Side mounted motor:

Fit the slack protections and tighten the nuts. Use the 10 mm box wrench.



13 Side mounted motor:

Fit the plastic sleeve on the drive shaft.



14 Side mounted motor:

Fit the motor on the drive shaft and tighten the screw. Use a 10 mm socket wrench. Fit the plastic cap.

CAUTION! Make sure that the torque arm fork has entered the cage in a correct way. An unlocked rotating motor can cause personal injury.



Introduction

The chain only runs on top of the conveyor.

Tools

Box wrench	10 mm
------------	-------

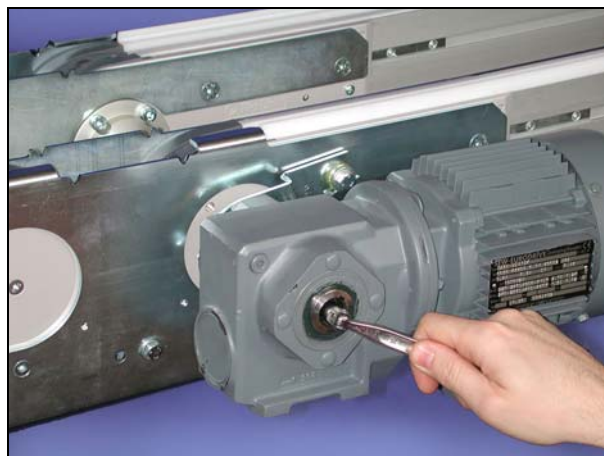
Skip joint pliers

Pin insertion tool

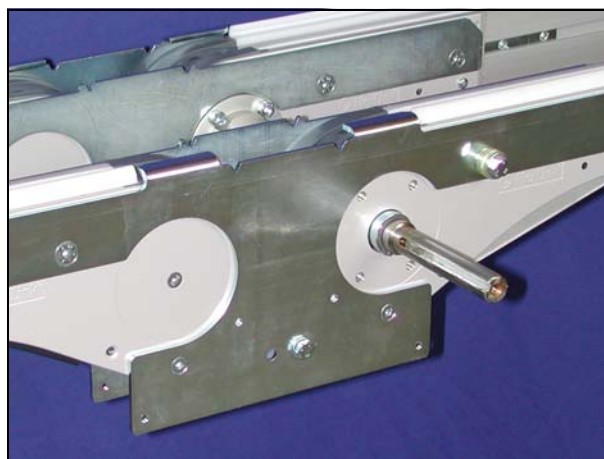
Screwdriver

Instruction

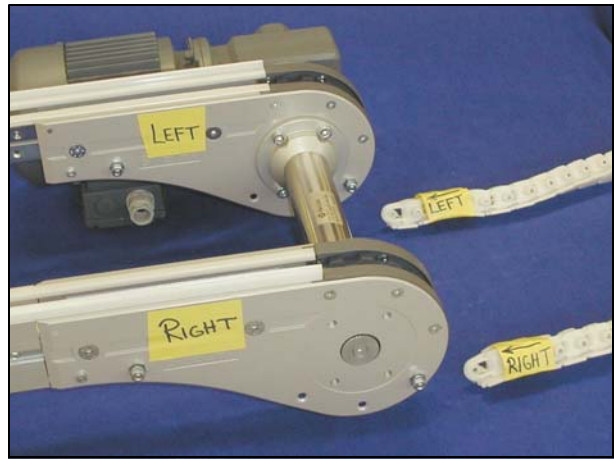
- 1 Use the screwdriver to remove the plastic cap on the motor. Loosen the screw for the motor with the 10 mm socket wrench.



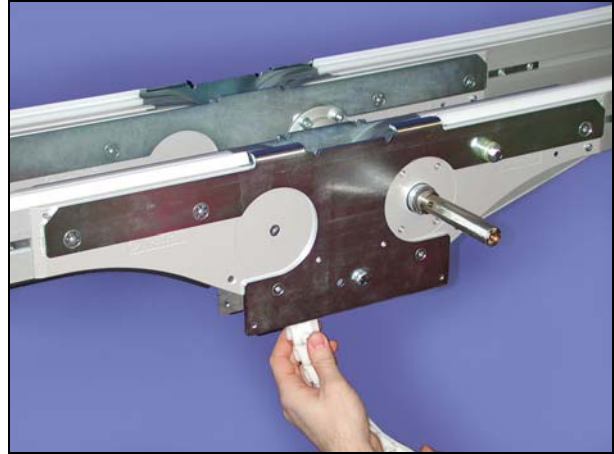
- 2 Lift off the motor and remove the plastic sleeve.



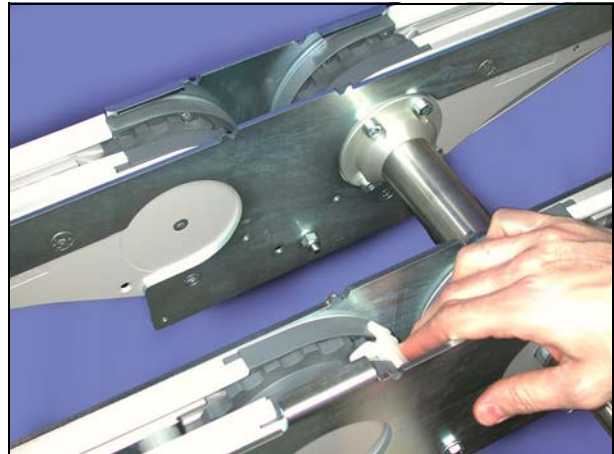
- 3 Notice the label Left and Right on the chain. Mount the chain to the conveyor with similar mark.



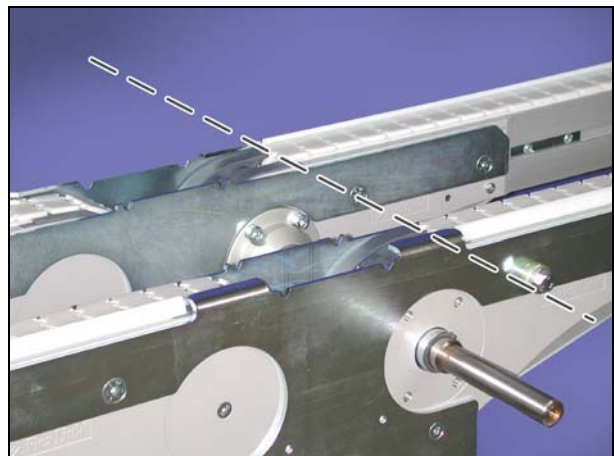
- 4 Insert the chain from below, with the nose forward.
- CAUTION! Make sure that you start feeding the chain in the idler end unit and towards the driving unit or it might lead to a chain damage.



- 5 Catch the chain and feed it via the idler end into the conveyor. Repeat the same procedure with the other chain.

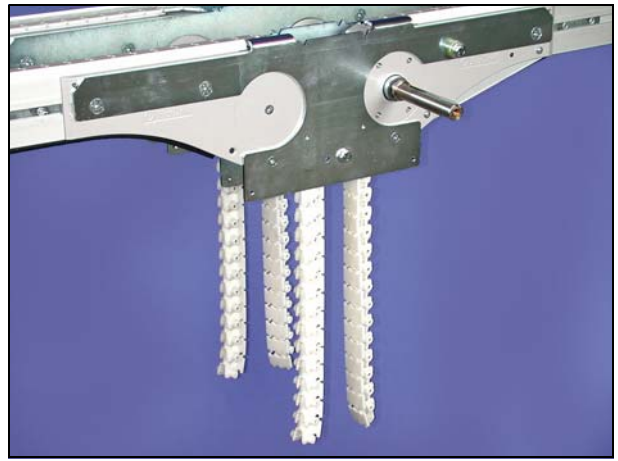


- 6 Feed the chains into the conveyor until they reach the drive wheel at the driving end.



- 7 Feed the chains to the drive wheel and turn the drive shaft until the chains are hanging a bit below the conveyor.

CAUTION! Make sure that the chain enters the drive wheel correctly. Risk for the plastic guides to brake.

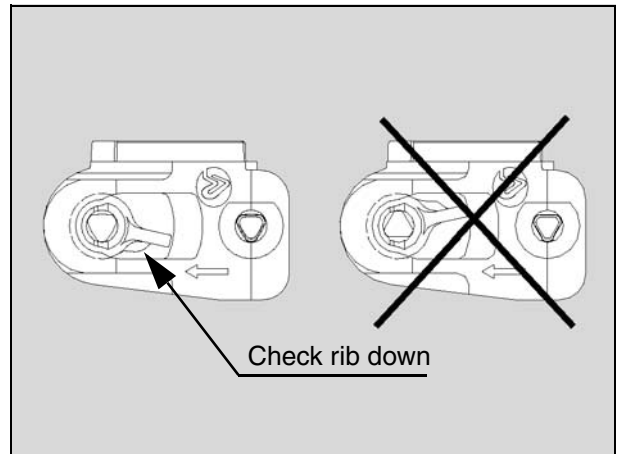


- 8 Use a pair of slip joint pliers to insert the pin half-way into the chain link.



- 9 Join the chain endings. Make sure that the joint ball has not been removed and re-assembled upside down.

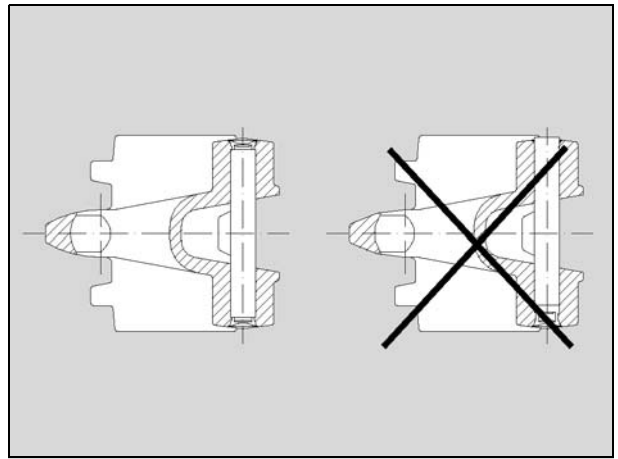
CAUTION! Wrongly positioned joint ball will lead to chain damage when running the chain.



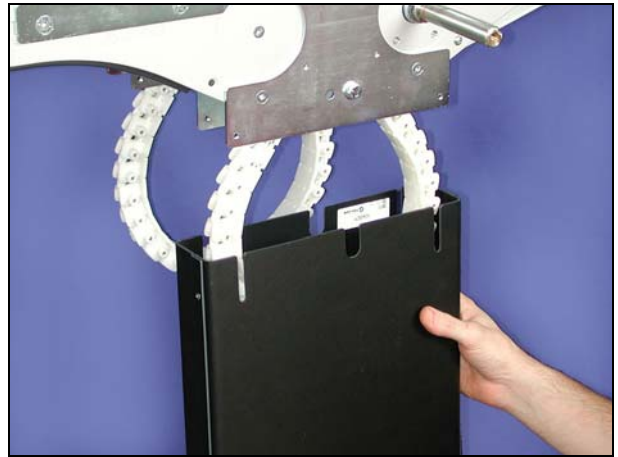
- 10 Press the pin through the chain. Use the pin insertion tool.



11 Make sure that the pin snaps in to the correct position (centered).



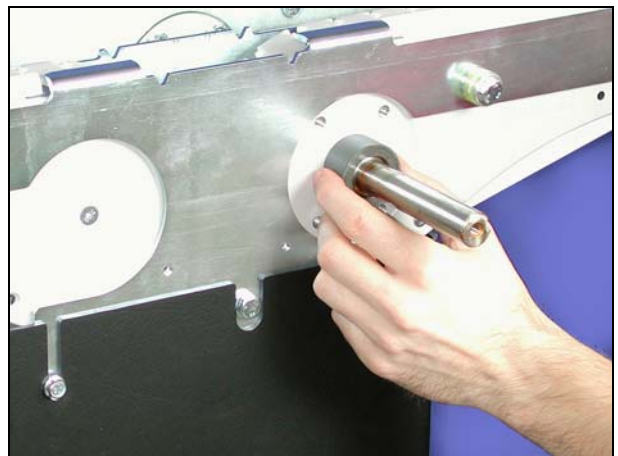
12 Fit the slack protection covers to end position.



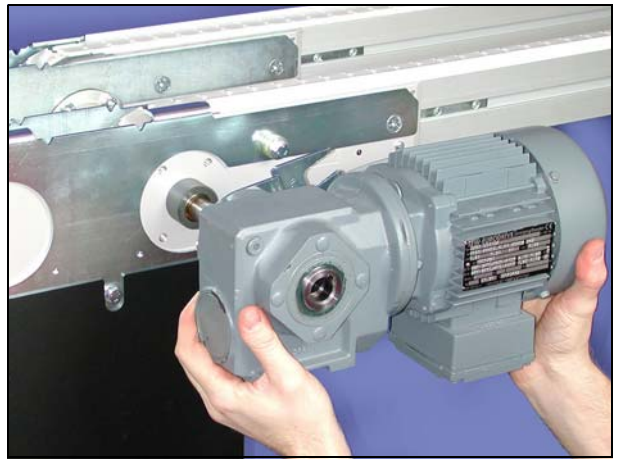
13 Fit and tighten the screws (4 x M6). Use the 10 mm box wrench.



14 Fit the plastic sleeve on the drive shaft.

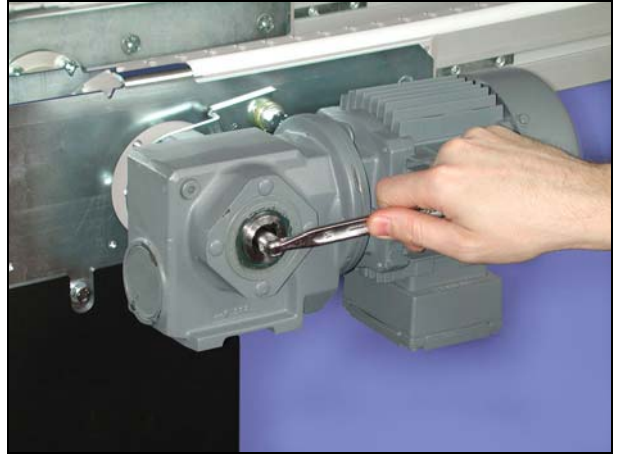


15 Fit the motor on the drive shaft.

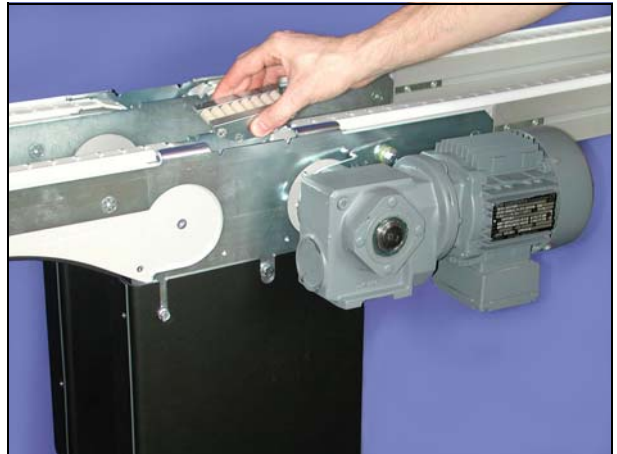


16 Fit and tighten the screw. Use the 10 mm socket wrench. Fit the plastic cap.

CAUTION! Make sure that the torque arm fork has entered the cage in a correct way. An unlocked rotating motor can cause personal injury.



17 Place the roller bridge between the conveyors.



Connecting an XT conveyor module, side mounted motor in line with another XT conveyor

Introduction

Use connecting kit 5049594, which connects a side mounted end drive unit (L and R), to an idler end unit.

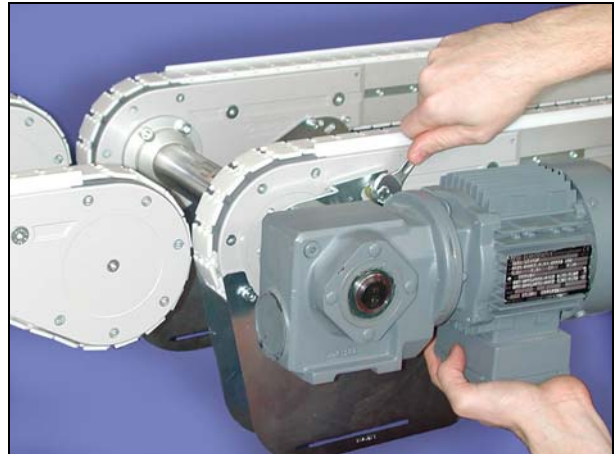
CAUTION! Fit one connecting plate at a time to ensure the unit remains intact, never loosen screws for more than one connecting plate at a time.

Tools

Allen key	5 mm
Box wrench	13 mm

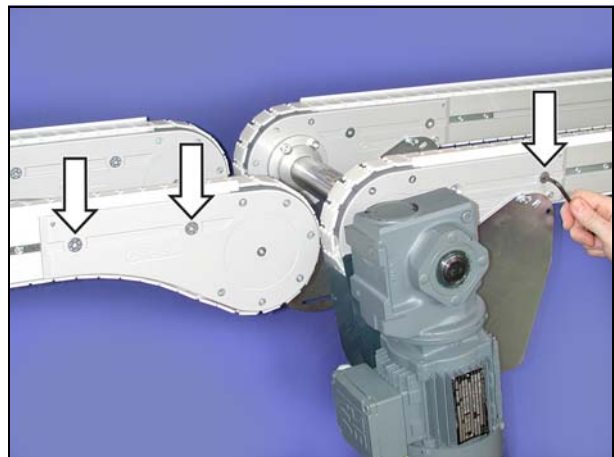
Instruction

- 1 Make sure that the conveyors are on the same level and in line with each other.
Loosen the screw for the torque arm. Use the 13 mm box wrench. Lower the motor.

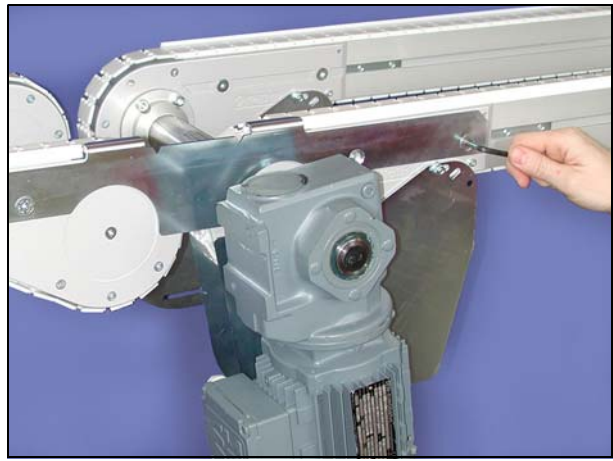


- 2 Loosen the screws (3 x M8) on the side plates. Use the 5 mm allen key.

CAUTION! Fit one connecting plate at a time to ensure the unit remains intact, never loosen screws for more than one connecting plate at a time.

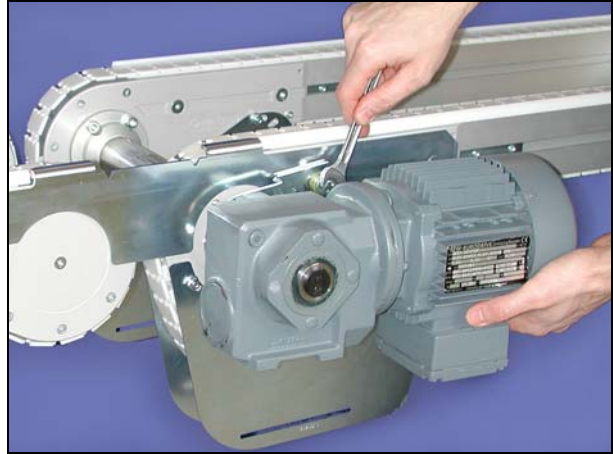


- 3 Fit the connecting plate and tighten the screws.
Use the 5 mm allen key.



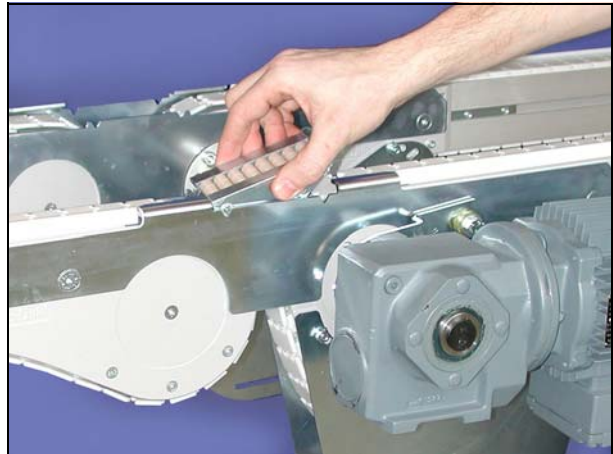
- 4 Turn up the motor. Fit and tighten the screw for torque arm. Use the 13 mm box wrench.

CAUTION! Make sure that the torque arm fork has entered the cage in a correct way. An unlocked rotating motor can cause personal injury.



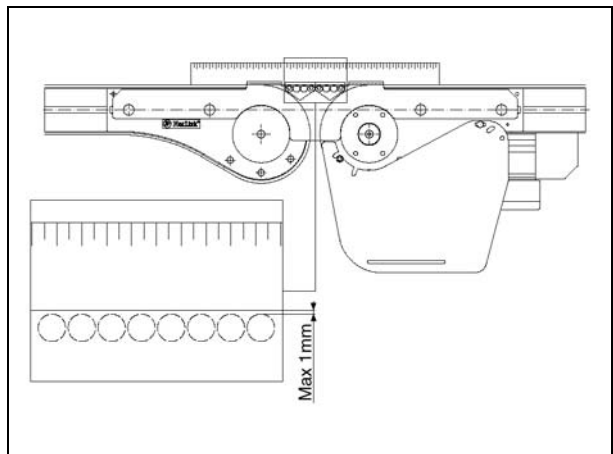
- 5 Fit the remaining connecting plates. Place the roller bridge between the conveyors.

CAUTION! Fit one connecting plate at a time to ensure the unit remains intact, never loosen screws for more than one connecting plate at a time.



- 6 Use a ruler to make sure that the roller bridge is in the correct vertical position. Max distance between ruler and roller: 1 mm.

If needed, loosen the screws for the connecting plates again and adjust until the necessary space is obtained.



Connecting an XT conveyor module, centre mounted motor in line with another XT conveyor

Introduction

Use connecting kit 5050564, which connects a centre mounted end drive unit (M and HM), to an idler end unit.

CAUTION! Fit one connecting plate at a time to ensure the unit remains intact, never loosen screws for more than one connecting plate at a time.

Tools

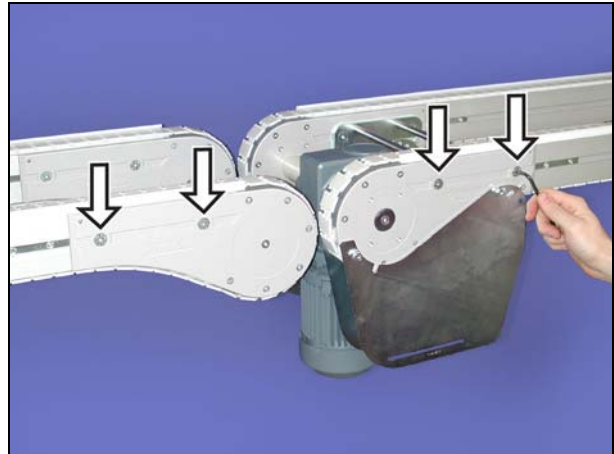
Allen key	5 mm
Box wrench	13 mm

Instruction

- 1 Make sure that the conveyors are on the same level and in line with each other.

Loosen the screws (4 x M8) on the side plates. Use the 5 mm allen key.

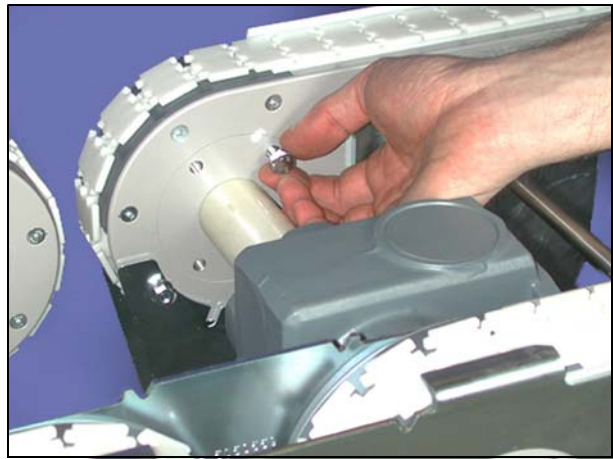
CAUTION! Fit one connecting plate at a time to ensure the unit remains intact, never loosen screws for more than one connecting plate at a time.



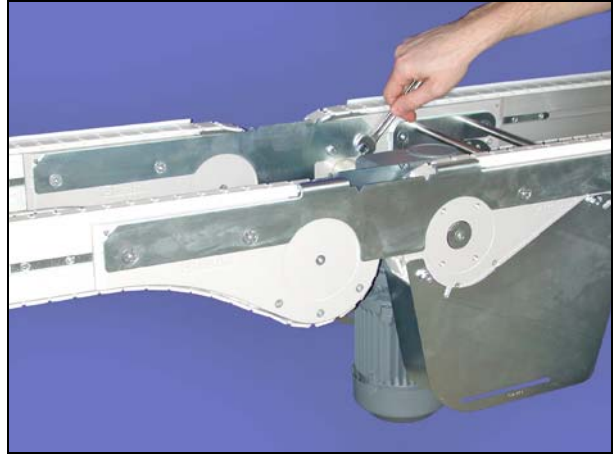
- 2 Fit the connecting plate and tighten the screws. Use the 5 mm allen key.



- 3 Fit the screws (4 x M8) to the inside of the side plates at the driving end

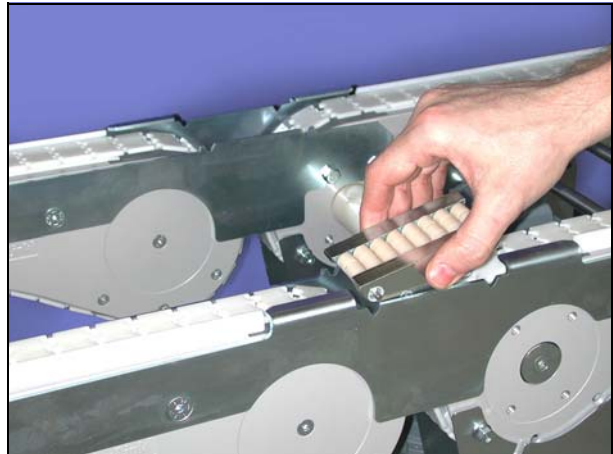


- 4 Loosen the screws on the inside of the side plate at the idler end. Use the 5 mm allen key. Fit the inner connecting plate and tighten the screws. Use a 13 mm box wrench and 5 mm allen key.



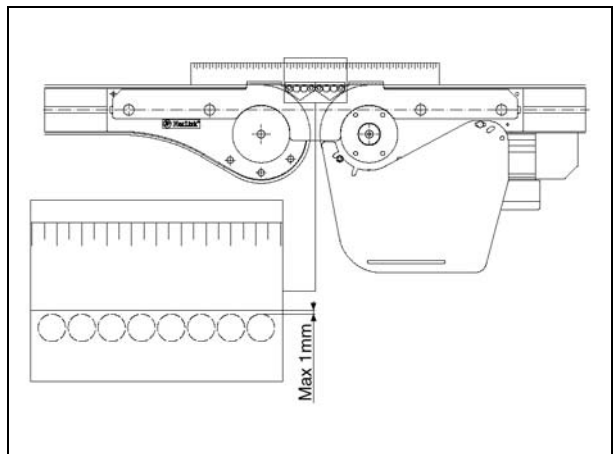
- 5 Fit the remaining plates. Place the roller bridge between the conveyors.

CAUTION! Fit one connecting plate at a time to ensure the unit remains intact, never loosen screws for more than one connecting plate at a time.



- 6 Use a ruler to make sure that the roller bridge is in the correct vertical position. Max distance between ruler and roller: 1 mm.

If needed, loosen the screws for the connecting plates again and adjust until the necessary space is obtained.



Mounting support module

Introduction

NOTE! Always place a support module near the motor, where the weight is high.

If nothing else is specified the instruction steps are valid for all support modules.

CAUTION! A short conveyor, which has the point of gravity near the motor, can easily cause the conveyor to tilt.

Tools

Allen key	5 mm
Allen key	6 mm
Box wrench	13 mm
Box wrench	19 mm
Drilling-machine	

Instruction

- 1 Place the support modules beside each other. Make sure that the support modules has the same height. If needed, adjust the feet. Use the 19 mm box wrench.

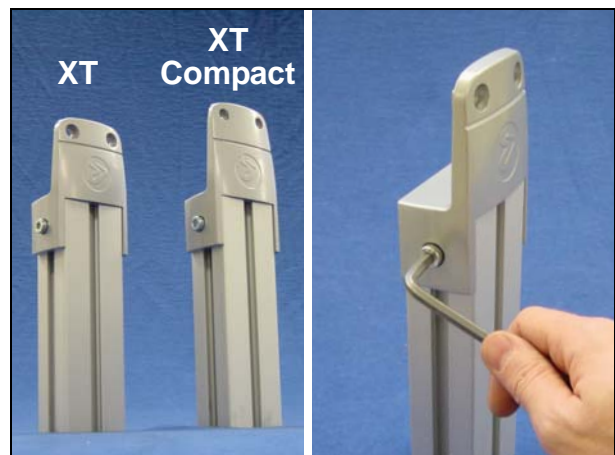


2 XTUF S01A/S02A/S03A

There are different brackets for fitting the support module on to an XT or XT Compact conveyor. The XT bracket is a little bit lower than the XT Compact bracket and uses M8 screws instead of M5.

Loosen the screws (2xM8) on one of the brackets of the support module using a 6 mm Allen key.

NOTE! If the support is made for more than one conveyor loosen one bracket in a pair for each conveyor.



3 XTUF S01A/S02A/S03A

XT Conveyor:

Insert the slot nuts (4 x M8) in the conveyor T-slot. Place the support module in the correct position by tilting aside the loose bracket. Fit the screws (4 x M8) and tighten with the 6 mm Allen key. Tighten the screws (2 x M8) on the loose bracket using the 6 mm Allen key.

XT Compact Conveyor:

Insert the slot nuts (4 x M5) in the conveyor T-slot. Place the support module in the correct position by tilting aside the loose bracket. Fit the screws (4 x M5) and tighten with the 5 mm Allen key. Tighten the screws (2 x M8) on the loose bracket using the 6 mm Allen key.



4 XTUF S04

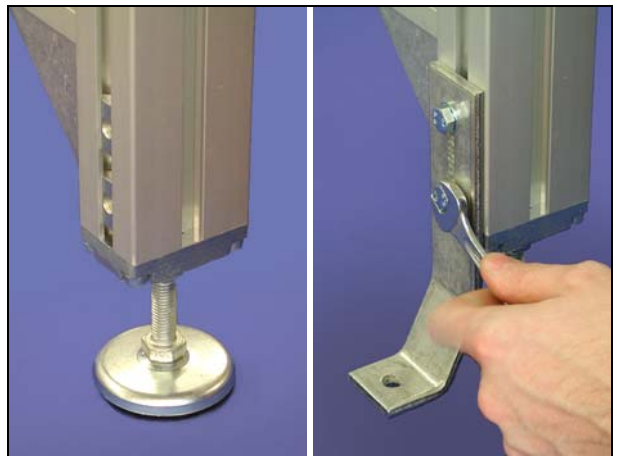
Insert the slot nuts (2 x M8) in the conveyor T-slot at the centre of the bend.

Place the support module in correct position. Fit and tighten the screws (2 x M6). Use the 13 mm box wrench.

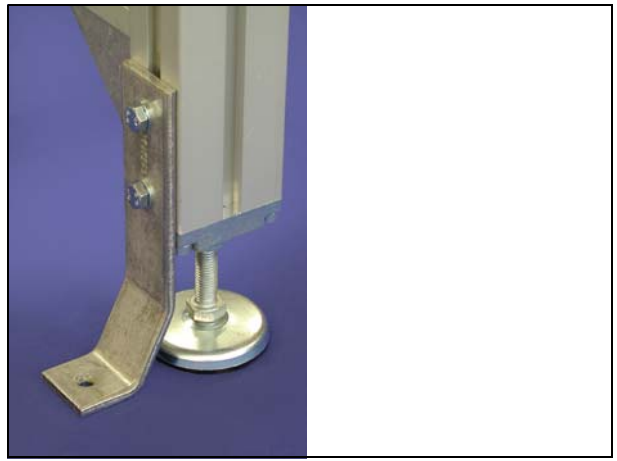


5 Fit the slot nuts (2 x M8) to the support beam T-slot.

Fit the foot and tighten the screws (2 x M8). Use the 13 mm box wrench.



6 Mount the foot to the surface.



Introduction

The stop can be placed on the inside of the conveyor at either the left (stop at pallet front) or right side (stop at pallet back). If nothing else is specified the instruction steps are valid for both XT and XT Compact conveyors.

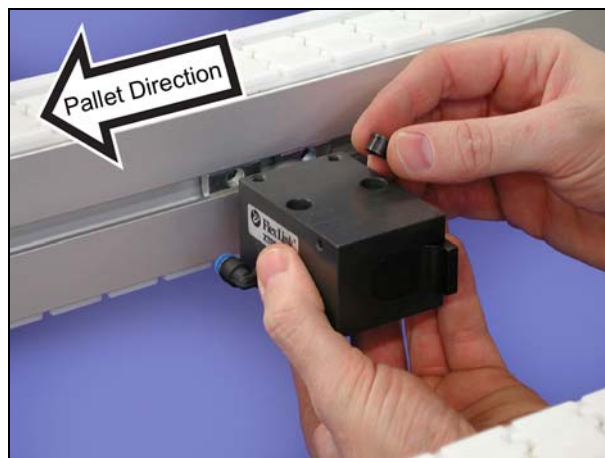
Tools

Allen key	6 mm
Allen key	5 mm

Instruction

1 XT conveyor:

Insert the slot nuts (2 x M8) in the conveyor T-slot. Insert the bushings to the stop unit.



2 XT conveyor:

Fit the screws (2 x M8).

NOTE! The stop flange shall face against the pallet direction of travel.



3 XT conveyor:

Use the 6 mm Allen key to tighten the screws.
Torque value for tightening: 25 Nm.



4 XT Compact conveyor:

Mount the bracket on the unit. Fit and tighten the screws (2 x M6) with the 5 mm Allen key. Torque value for tightening: 10 Nm.

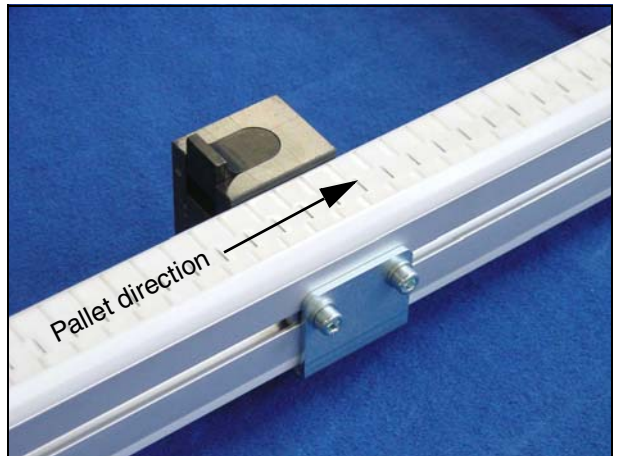


5 XT Compact conveyor:

Insert the slot nuts (2 x M6) in the conveyor T-slot.

Fit and tighten the screws (2 x M6). Use the 5 mm Allen key. Torque value for tightening: 10 Nm.

NOTE! The stop flange shall face against the pallet direction of travel.



Introduction

The stop can be placed on the inside of the conveyor at either the left (stop at pallet front) or right side (stop at pallet back). If nothing else is specified the instruction steps are valid for both XT and XT Compact conveyors.

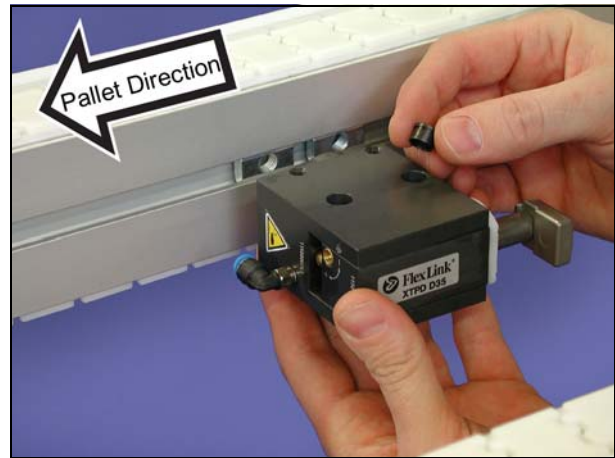
Tools

Allen key	6 mm
Allen key	5 mm

Instruction

1 XT conveyor:

Insert the slot nuts (2 x M8) in the conveyor T-slot. Insert the bushings to the stop unit.



2 XT conveyor:

Fit the screws (2 x M8).

NOTE! The stop flange shall face against the pallet direction of travel.



3 XT conveyor:

Use the 6 mm Allen key to tighten the screws. Torque value for tightening: 25 Nm.

CAUTION! Too high torque can cause the unit to get jammed.



4 XT Compact conveyor:

Mount the bracket on the unit. Fit and tighten the screws (2 x M6) with the 5 mm Allen key. Torque value for tightening: 10 Nm.

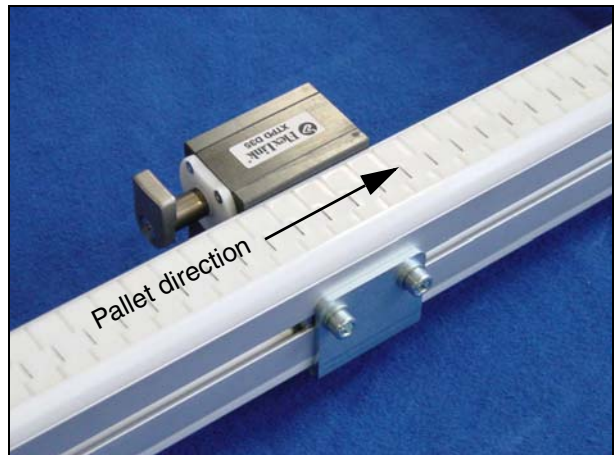


5 XT Compact conveyor:

Insert the slot nuts (2 x M6) in the conveyor T-slot.

Fit and tighten the screws (2 x M6). Use the 5 mm Allen key.

NOTE! The stop flange shall face against the pallet direction of travel.



6 Pre adjust the damping screw according to the following:

a) Turn the screw clockwise towards the “+” sign until it reaches the end position. When you have reached the end position turn it counter clockwise 360° towards the “-” sign.

b) Fine adjust the damping when the system is running. Turn the screw to the “+” sign to increase the damping and to the “-” sign to decrease the damping.

CAUTION! Heavy pallets in combination with an over damped stop can damage the stop.



7 Mount the cover.



Mounting pallet stop device XTPD D100

Introduction

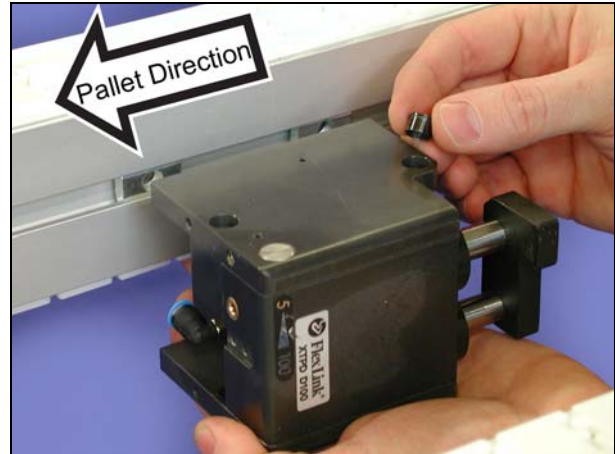
Mount the stop inside of the XT conveyor beam.

Tools

Allen key	6 mm
-----------	------

Instruction

- 1 Insert the slot nuts (2xM8) in the conveyor T-slot.
Insert the bushings to the stop unit.



- 2 Fit the screws (2 x M8).
NOTE! The stop flange shall face against the pallet direction of travel.



- 3 Tighten the screws with the 6 mm Allen key.
Torque value for tightening: 25 Nm.



Mounting sensor bracket XTPB V001 to pallet stop device XTPD U200 or XTPD D35

Introduction

The sensor is not included in sensor bracket V001. If nothing else is specified the instruction steps are valid for both XTPD U200 and XTPD D35.

Tools

Allen key	3 mm
Screwdriver	

Instruction

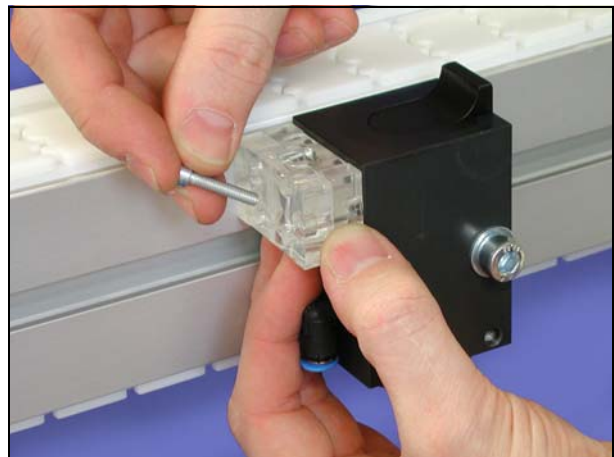
1 XTPD D35

Remove the cover with a screwdriver.



2 XTPD U200

Use the screws (2 x M4) to mount the sensor bracket to the stop unit.

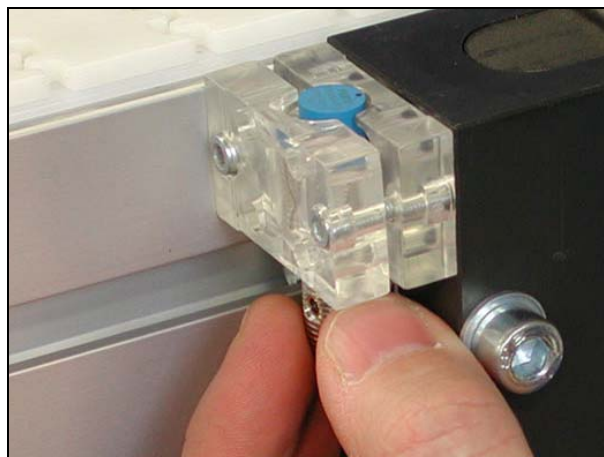


3 XTPD D35

Use the screws (2 x M4) to mount the sensor bracket to the stop unit.



4 Fit the sensor to the sensor bracket.



5 Tighten the screws. Use the 3 mm Allen key.



Mounting sensor bracket XTPB V002

Introduction

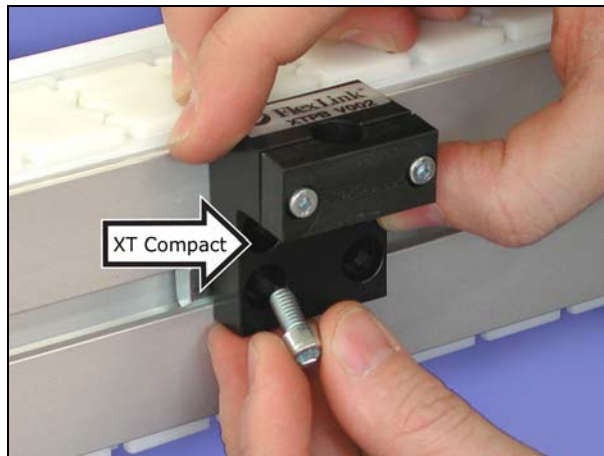
The sensor is not included in sensor bracket XTPB V002.

Tools

Allen key	5 mm
Allen key	3 mm

Instruction

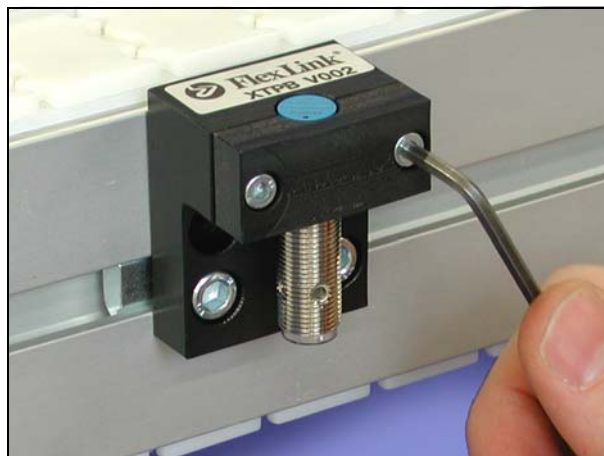
- 1 Insert the slot nuts (2 x M6) in the conveyor T-slot. Fit the screws (2 x M6). The arrow shows the upper holes for fitting on XT Compact conveyor.



- 2 Use the 5 mm Allen key to tighten the screws.



- 3 Fit the sensor to the sensor bracket. Tighten the screws. Use the 3 mm Allen key.



Introduction

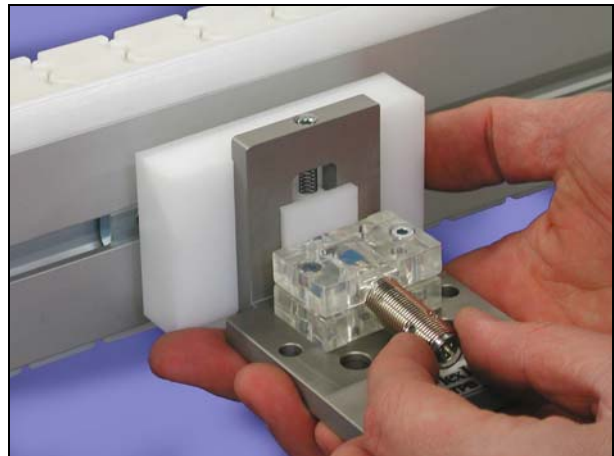
The sensor is not included in position sensor XTBP V003. Mount the position sensor on the outside of conveyor XT or XT Compact. If nothing else is specified the instruction steps are valid for both XT and XT Compact conveyors.

Tools

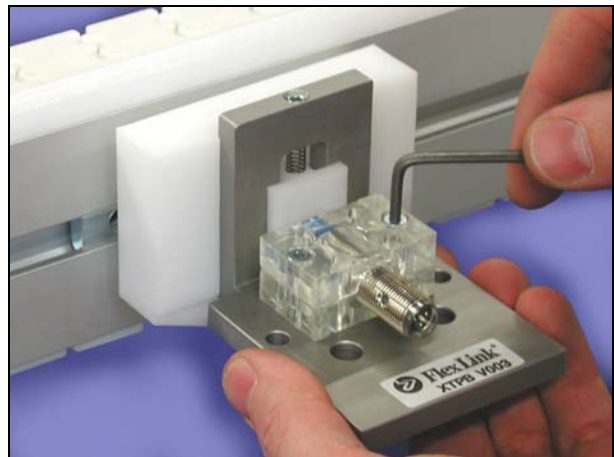
Allen key	3 mm
Allen key	5 mm
Allen key	6 mm

Instruction

- 1 Fit the sensor to the sensor bracket.



- 2 Tighten the screws. Use the 3 mm Allen key.



3 XT conveyor:

Insert the slot nuts (2 x M8) in the conveyor T-slot. Mount the bushings to the sensor bracket.

XT Compact conveyor:

Insert the slot nuts (2 x M6) in the conveyor T-slot.

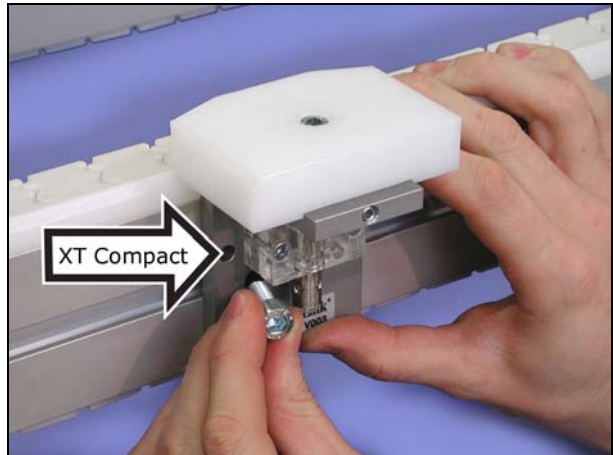


4 XT conveyor:

Fit the screws (2 x M8).

XT Compact conveyor:

Fit the screws (2 x M6). The arrow shows the upper holes for fitting on XT Compact conveyor.

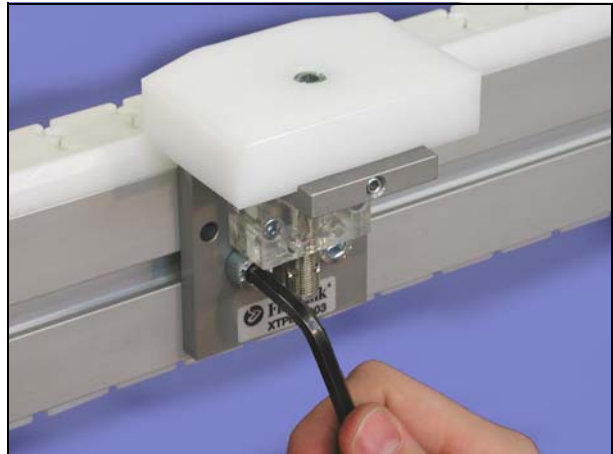


5 XT conveyor:

Use the 6 mm Allen key to tighten the screws.

XT Compact conveyor:

Use the 5 mm Allen key to tighten the screws.



Introduction

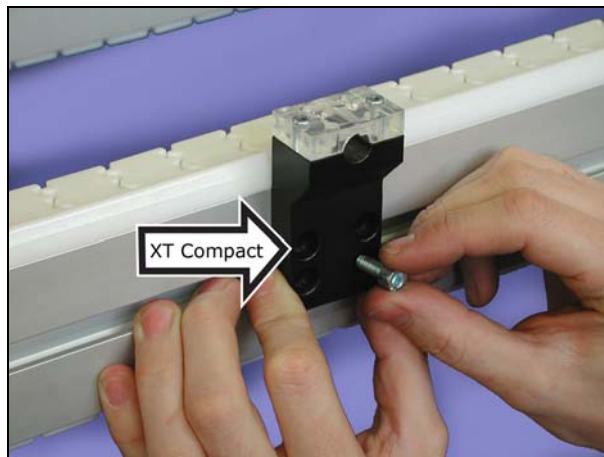
The sensor is not included in sensor bracket XTBP H001. Mount the bracket on the outside of conveyor XT or XT Compact.

Tools

Allen key	3 mm
Allen key	5 mm

Instruction

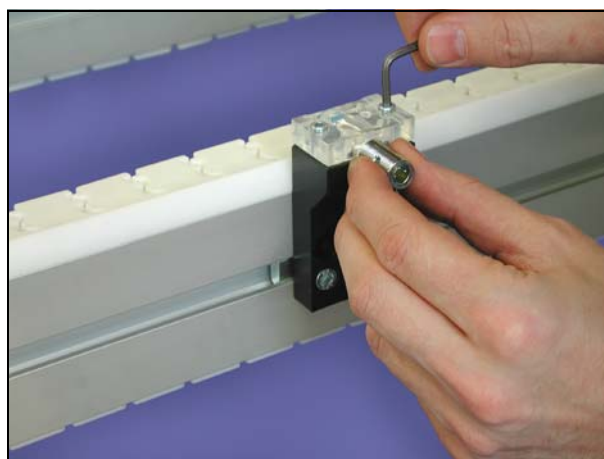
- 1 Insert the slot nuts (2 x M6) in the conveyor T-slot. Fit the screws (2 x M6). The arrow shows the upper holes for fitting on XT Compact conveyor.



- 2 Use the 5 mm Allen key to tighten the screws.



- 3 Fit the sensor to the sensor bracket. Tighten the screws. Use the 3 mm Allen key.



Mounting damper CM 35

Introduction

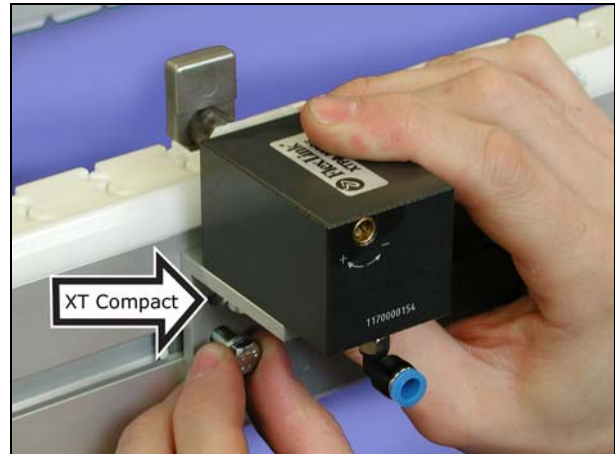
Mount the damper outside of conveyor XT or XT Compact.

Tools

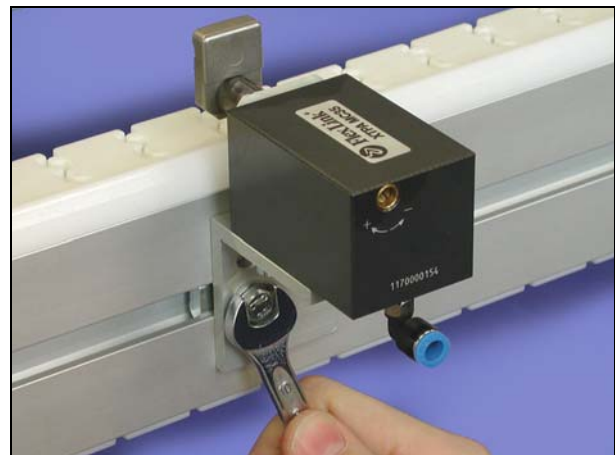
Box wrench	10 mm
Screwdriver	

Instruction

- 1 Insert the slot nuts (2 x M6) in the conveyor T-slot. Fit the screws (2 x M6).
The arrow shows the upper holes for fitting on XT Compact conveyor.



- 2 Tighten the screws. Use the 10 mm box wrench.



- 3 Pre adjust the damping screw according to the following:
 - a) Turn the screw clockwise towards the "+" sign until it reaches the end position. When you have reached the end position turn it counter clockwise 360° towards the "-" sign.
 - b) Fine adjust the damping when the system is running. Turn the screw to the "+" sign to increase the damping and to the "-" sign to decrease the damping.

CAUTION! Heavy pallets in combination with an over damped stop can damage the stop.



Mounting roller kit

Introduction

Use roller kit 5049865 (65 mm) or roller kit 5050117 (45 mm).

Tools

Box wrench	10 mm
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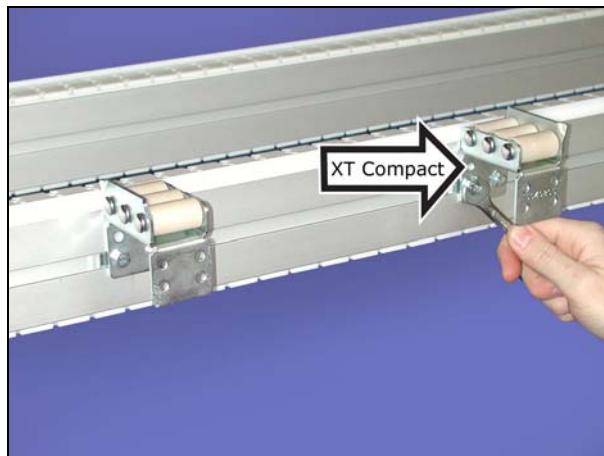
Instruction

- 1 Insert the slot nuts (4 x M6) in the conveyor T-slot.



- 2 Mount the roller to the conveyor. Fit and tighten the screws (4 x M6). Use the 10 mm box wrench. The arrow shows the upper holes for fitting on XT Compact conveyor.

The distance between the two flanges shall be:
 $\text{Pallet Length (PL)} + 2 \text{ mm}$.



- 3 Place the conveyors parallel to each other. Make sure that the conveyors are on the same level and in a horizontal position.

Fit and tighten the screws (4 x M6). Use the 10 mm box wrench.



Mounting XT Compact conveyor perpendicular to XT or XT Compact conveyor

Introduction

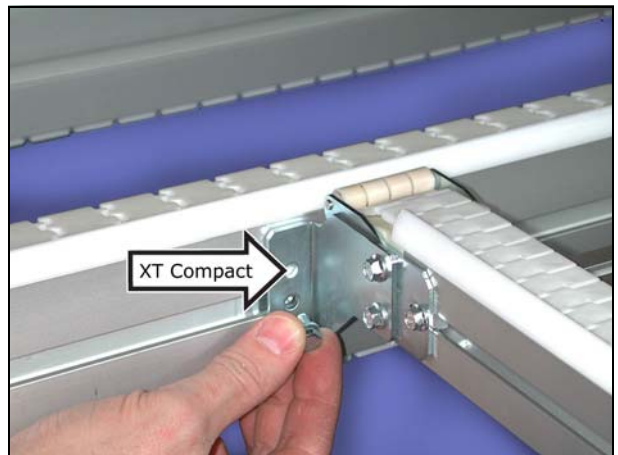
Use connecting kit 5050034.

Tools

Box wrench	8 mm
------------	------

Instruction

- 1 Loosen the screws on the XT Compact conveyor (2 x M5). Use the 8 mm box wrench. Insert the slot nut (1 x M5) in the conveyor T-slot.
- 2 Mount the bracket. Fit and tighten the screws (2 x M5). Use the 8 mm box wrench.
- 3 Fit and tighten the screw (1 x M5). Use the 8 mm box wrench. The arrow shows the upper holes for fitting on XT Compact conveyor.



Introduction

Mount the locating station on conveyor XT or XT Compact. If nothing else is specified the instruction step is valid for both XT and XT Compact conveyor.

Tools

Soft faced hammer	
Allen key	6 mm
Adjustable wrench	
Box wrench	10 mm
Piece of slide rail	4 pcs

Instruction

- 1 Mount the pins to the locating units.



- 2 Use a soft faced hammer and hit the pin carefully until it reaches the end position.



3 XT conveyor:

Insert the slot nuts (2xM8) in the conveyor T-slot.
Mount the bushings to the locating unit.

XT Compact conveyor:

Insert the slot nuts (2xM6) to the conveyor.

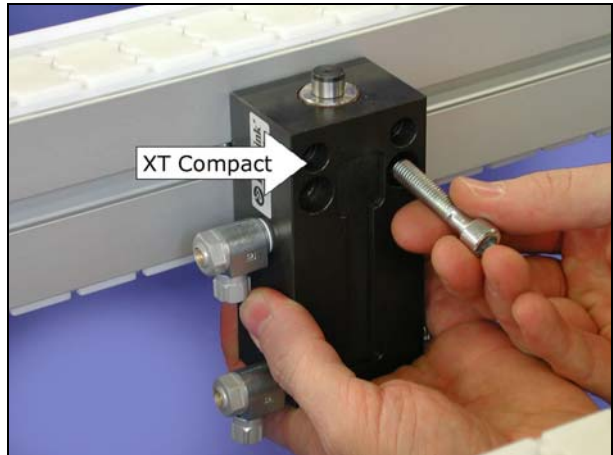


4 XT conveyor:

Fit the screws (2 x M8).

XT Compact conveyor:

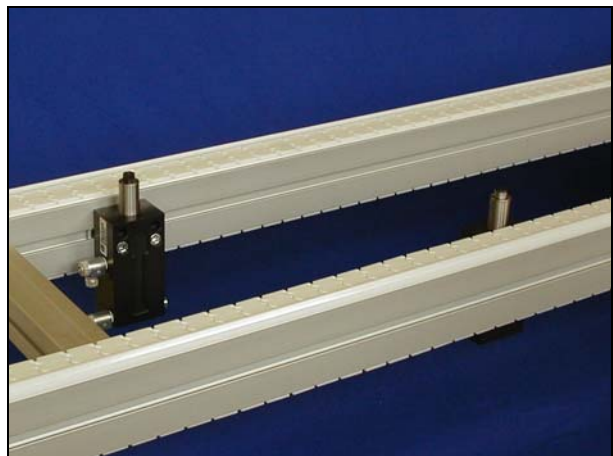
Fit the screws (2 x M6). The arrow shows the upper holes for fitting on XT Compact conveyor.



5 Do not tighten the screws permanently. Use the 6 mm Allen key.



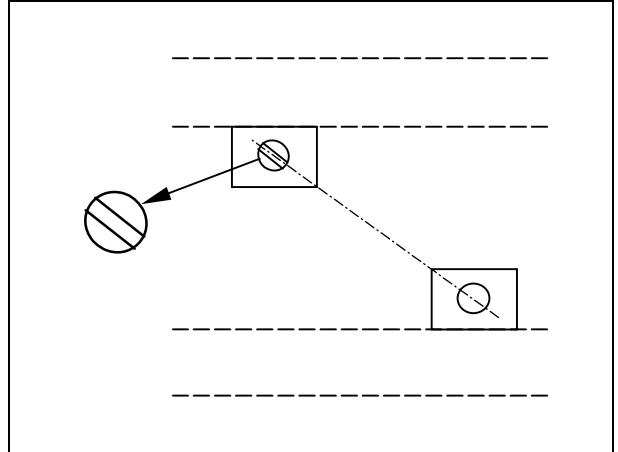
6 Press the pistons out.



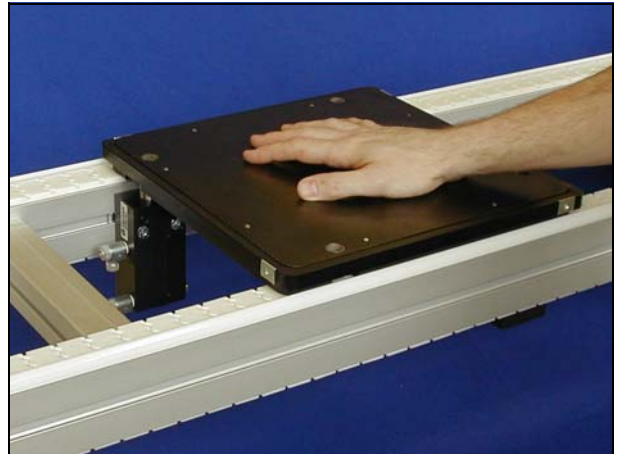
- 7 Use an adjustable wrench to turn the non-cylindrical locating pin to a position according to step 8.



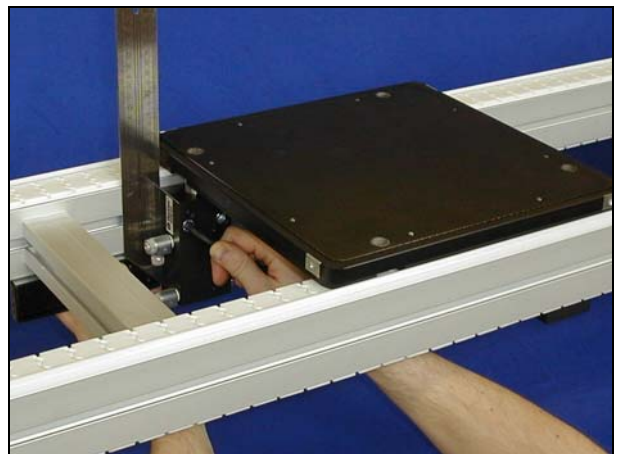
- 8 Locating pin position.



- 9 Place a pallet on top of the locating pins and press the pallet down to the conveyor surface.



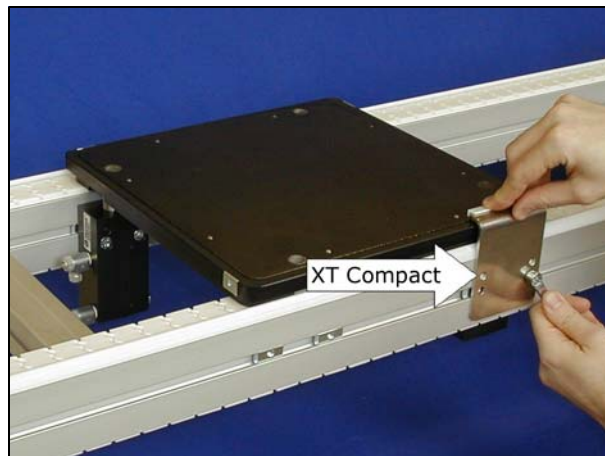
- 10 Tighten the two locating units to the conveyor beams. Use a set-square to get the pistons in line with the pallet bushings. Use the conveyor beam as a reference.



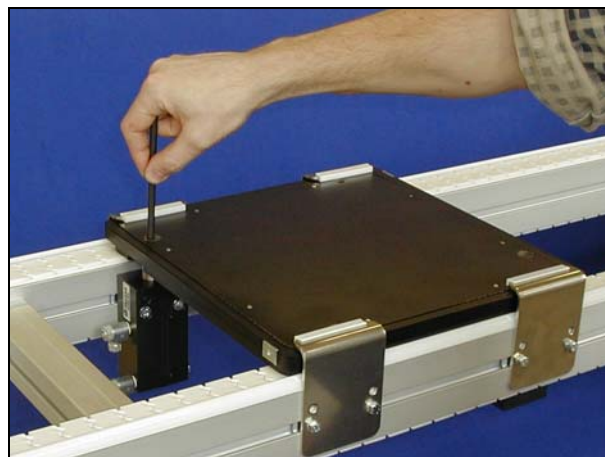
- 11 Mount the four brackets. To get the correct vertical space between pallet and bracket use a piece of slide rail (thickness approx. 2 mm) as a temporary distance piece at each bracket.

Press each bracket down towards the pallet before tightening the screws. Use the 10 mm box wrench.

The arrow shows the upper holes for fitting on XT Compact conveyor.



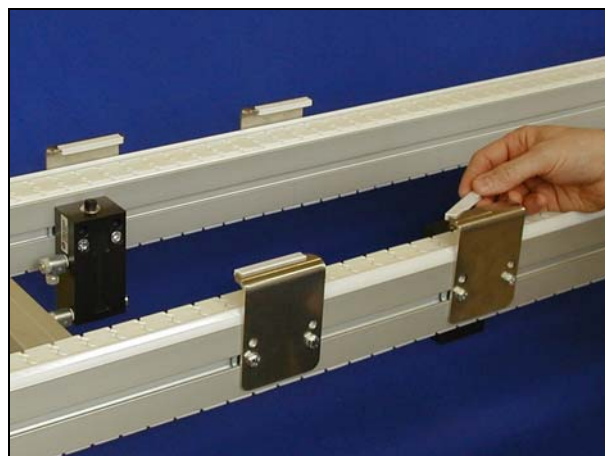
- 12 When all brackets are mounted use the 6 mm Allen key to gently press the two pistons down.



- 13 Remove the pallet.

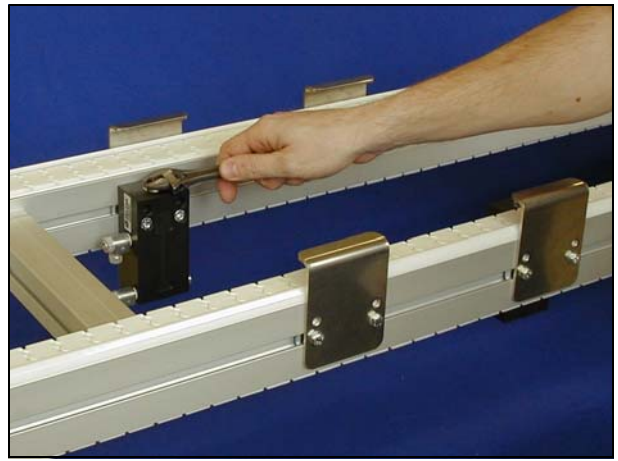


- 14 Dismount the temporary distance pieces (slide rails) from the brackets.

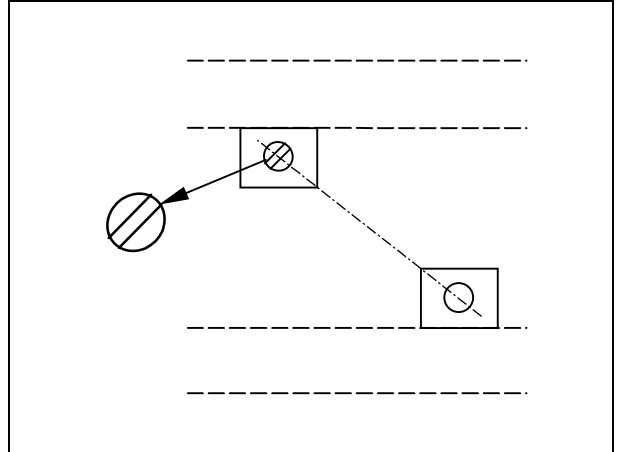


15 Finally, turn the non-cylindrical locating pin to a position according to step 16.

Doing this, the locating station is no longer sensitive to the individual pallet tolerances that may occur between the two pallet bushings.



16 Locating pin position.

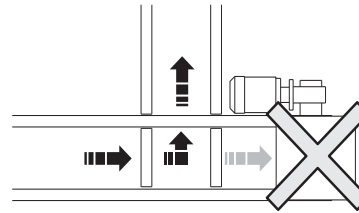


Mounting transfer unit XTPT M1

Introduction

Mount the transfer unit on the inside of conveyor XT or XT Compact.

CAUTION! Ensure that a pallet can not fall off the conveyor if it should pass the transfer unit by mistake.

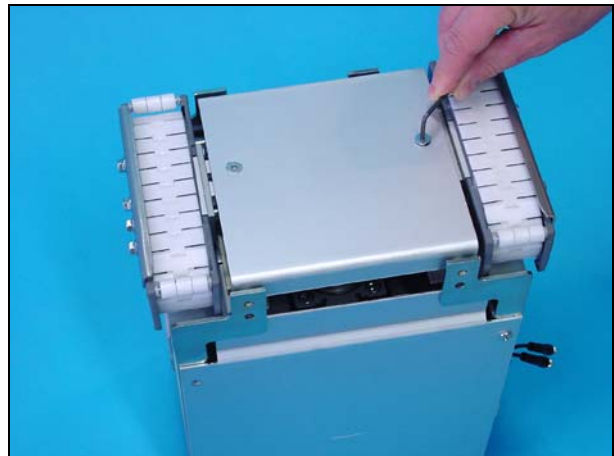


Tools

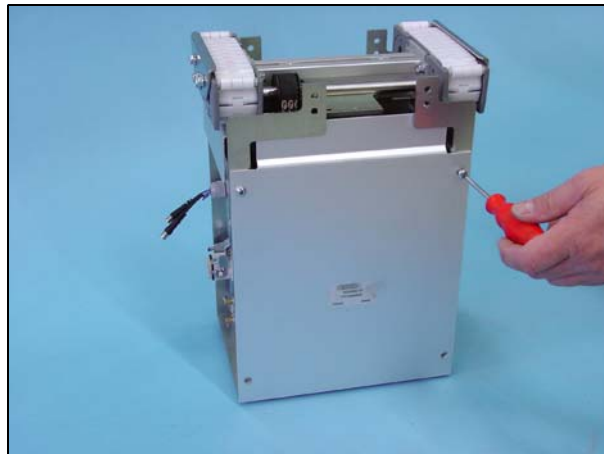
Allen key	3 mm
Box wrench	8 mm
Box wrench	10 mm

Instruction

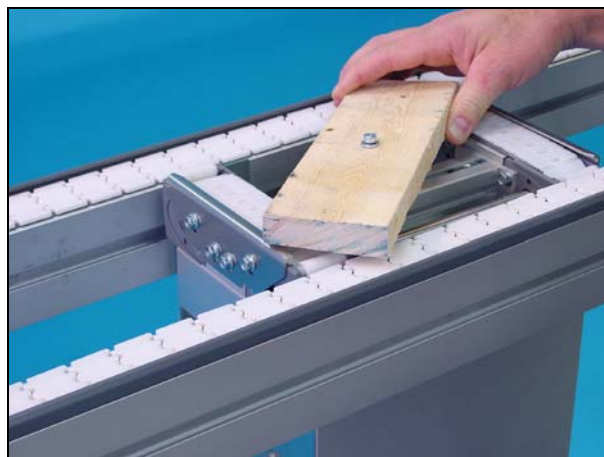
- 1 Loosen the screws (2×M5) that hold the top cover plate. Use the 3 mm Allen key. Please note the two loose washers under the cover plate.
- 2 In the plastic bag enclosed in the shipment you find the necessary slot nuts and bolts to attach the transfer to the conveyor. Insert the slot nuts in the T-slots on the conveyor beam. For conveyor XT use XCAN 6 slot nuts (the larger ones) and M6x12 bolts, for XT Compact use XFAN 6 slot nuts and M6x10 bolts.



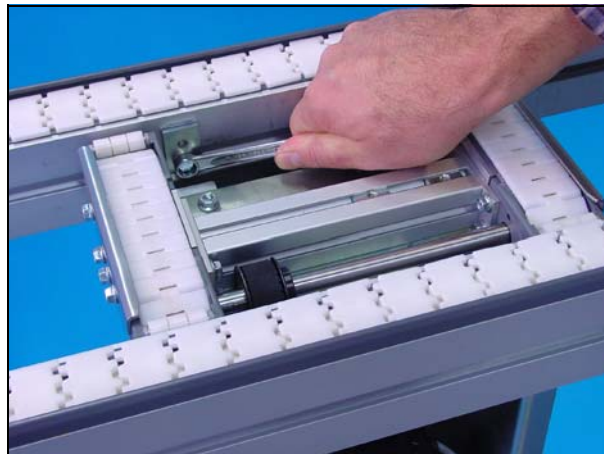
- 3 Loosen the screws that hold the side cover on the motor side. Use the cross-slotted screw driver. This is done to make attachment of the transfer easy.



- 4 Use a cross beam, e.g. a wood plank, to get the transfer hanging in position between the conveyor beams. The cross beam is fastened in one of the slot nuts for the top cover plate. Insert the bolts for the fastening of the transfer in the holes (4xM6). The upper holes are for conveyor XT Compact, the lower for conveyor XT.



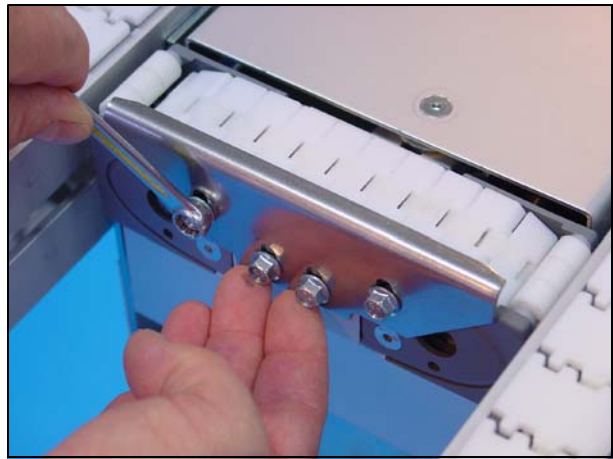
- 5 Remove the cross beam. Make sure that the transfer unit is hanging by its weight and in correct level. Tighten the screws. Use the 10 mm box wrench.



- 6 Mount the top cover plate. Do not forget the two washers working as distances. Use the 3 mm Allen key. Mount the side cover plate. Use the cross-slotted screw driver.



- 7 Check the pallet direction of travel. Loosen the four screws (4 x M5) that hold the guide plate that will act as a stop plate, lift the plate to its top position and tighten the screws. Use the 8 mm box wrench. If damped option, please see "Mounting damper MC 35 PW A" on page 67.



- 8 Attach the motor cable, the pneumatic tubes and the connections for the sensor cables.

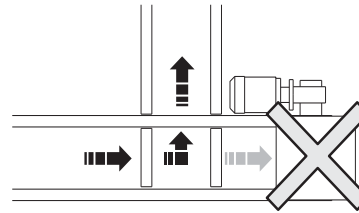


Mounting transfer unit XTPT M2

Introduction

Mount the transfer unit on the inside of conveyor XT or XT Compact.

CAUTION! Ensure that a pallet can not fall off the conveyor if it should pass the transfer unit by mistake.



Tools

Allen key	3 mm
Allen key	5 mm
Box wrench	8 mm
Box wrench	10 mm

Instruction

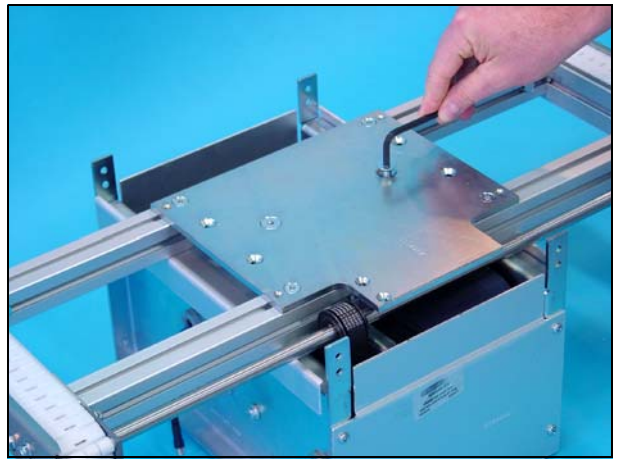
- 1 Loosen the screws (4x5 mm) that hold the top cover plate. Use the 3 mm Allen key.



- 2 In the plastic bag enclosed in the shipment you find the necessary slot nuts and bolts to attach the transfer to the conveyor. Insert the slot nuts in the T-slots on the conveyor beam. For conveyor XT use XCAN 6 slot nuts (the larger ones) and M6x12 bolts, for XT Compact use XFAN 6 slot nuts and M6x10 bolts.

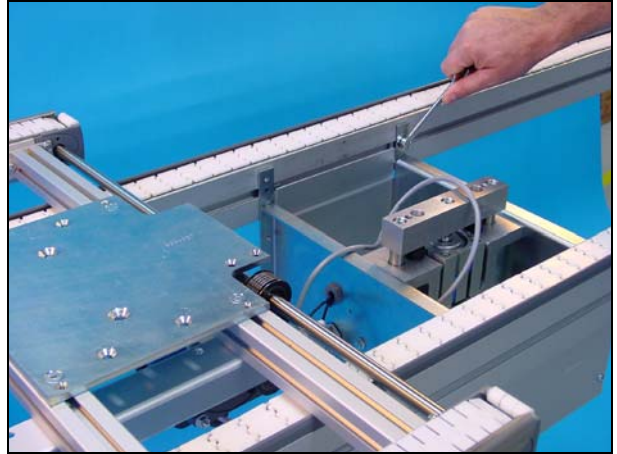


- 3 Loosen the screws (2×M8) that connect the drive unit to the transfer unit. Use the 5 mm Allen key.

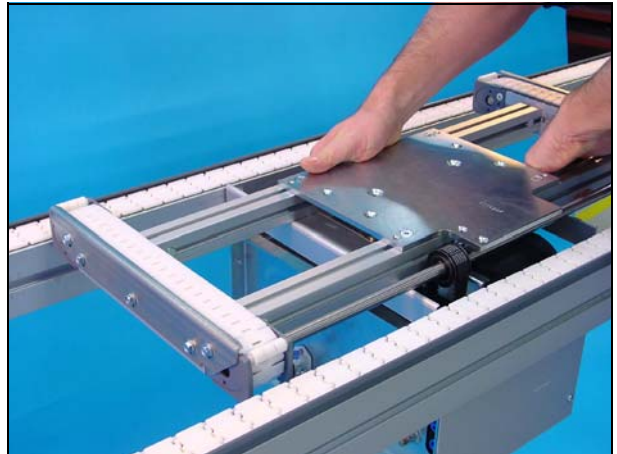


- 4 Put the drive unit on top of the beams of the main conveyor next to the position where you are to mount the transfer unit.

- 5 Fit the transfer unit to the conveyor beams. Use the 10 mm box wrench.



- 6 Fit the drive unit back into the transfer unit. Make sure that the motor cable is put in a safe position, e.g. not directly under the adjusting screw or too close to the cylinder. Attach the screws, 2×M8. Use the 5 mm Allen key.



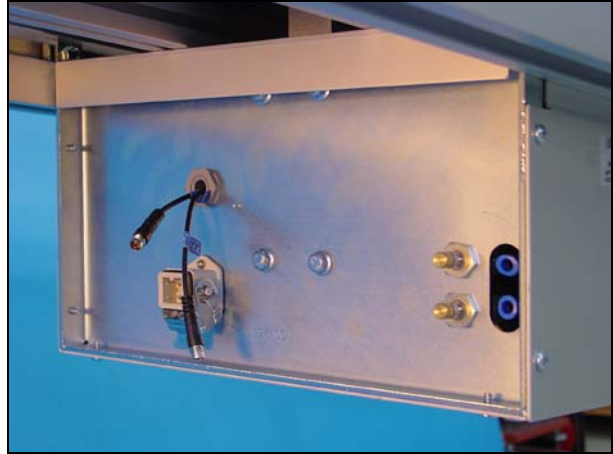
- 7 Attach the top cover plate. Use the 3 mm Allen key.



- 8 Check the pallet direction of travel. Loosen the four screws (4xM5) that hold the guide plate that will act as a stop plate. Lift the plate to its top position and tighten the screws. Use the 8 mm box wrench. If damped option, please see "Mounting damper MC 35 PW A" on page 67.



- 9 Attach the motor cable, the pneumatic tubes and the connections for the sensor cables.

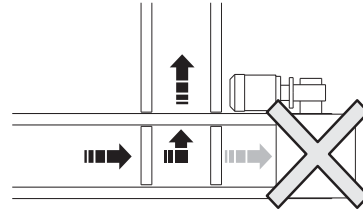


Mounting transfer unit XTPT L

Introduction

Mount the transfer unit on the inside of conveyor XT or XT Compact.

CAUTION! Ensure that a pallet can not fall off the conveyor if it should pass the transfer unit by mistake.

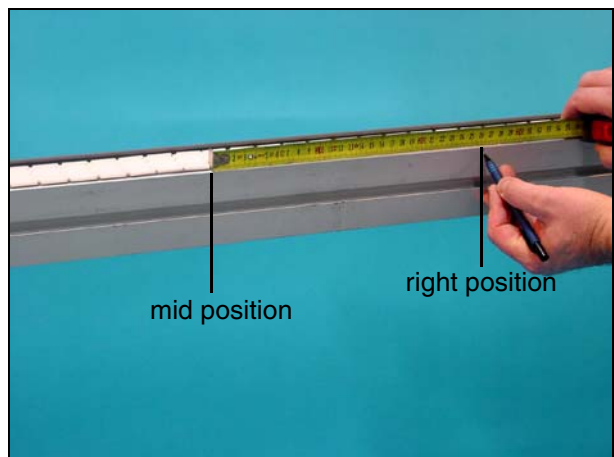
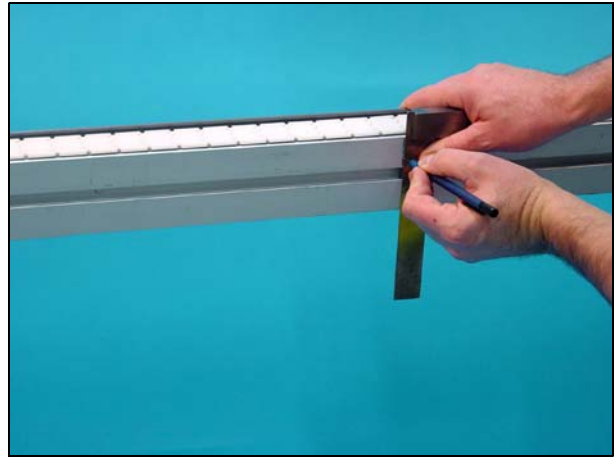


Tools

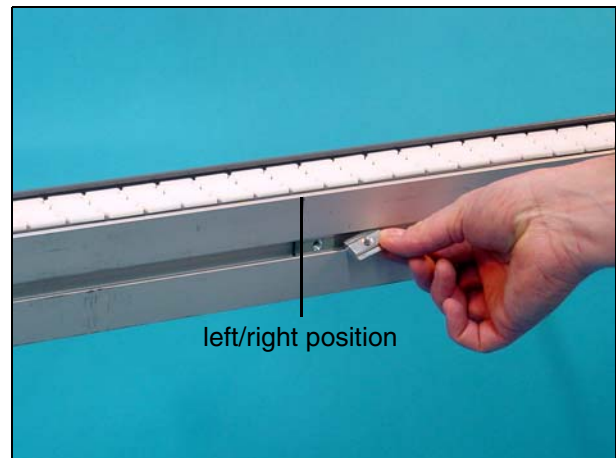
Allen key	5 mm
Box wrench	10 mm

Instruction

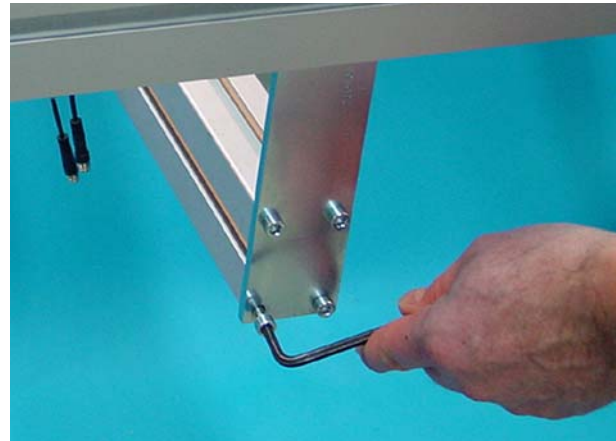
- 1 Find the mid position of the transfer unit's position on the conveyor beam.
- 2 Measure $(PW - 90)/2$ to the left and to the right of the centre position.



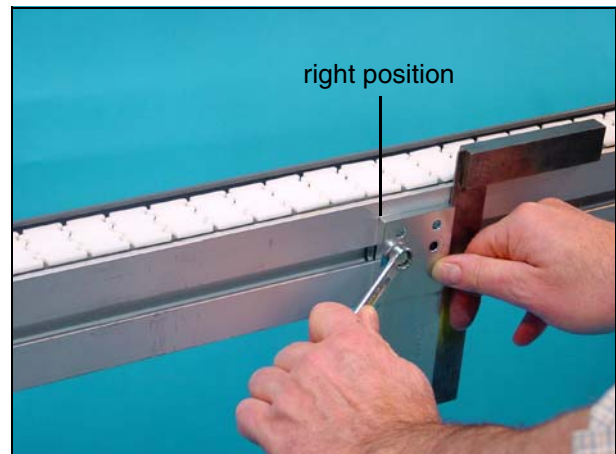
- 3 In the plastic bag enclosed in the shipment you find the necessary slot nuts and bolts to attach the transfer to the conveyor. Insert the slot nuts in the T-slots on the conveyor beam. For conveyor XT use XCAN 6 slot nuts (the larger ones) and M6×16 bolts, for XT Compact use XFAN 6 slot nuts and M6×14 bolts.



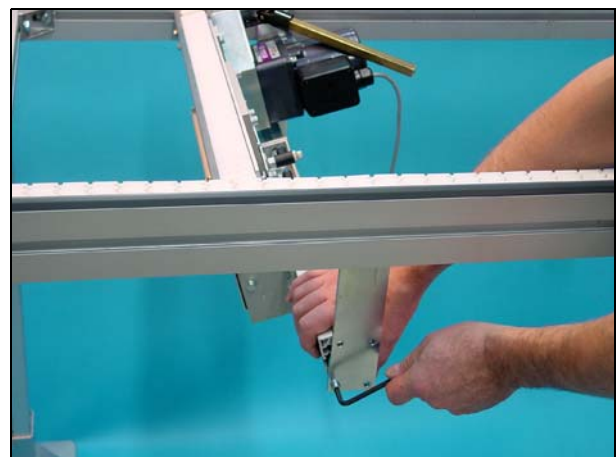
- 4 Disassemble the four mounting brackets.



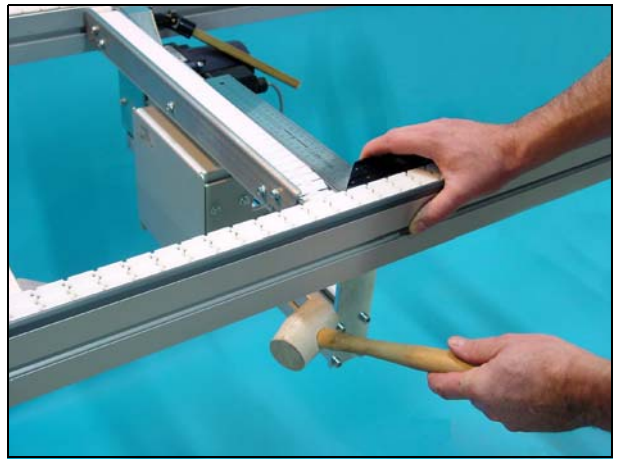
- 5 Mount the four mounting brackets on the conveyor beam at the measured position found in instruction no. 2. Use the 10 mm box wrench. Make sure that the brackets are perpendicular to the conveyor beam.



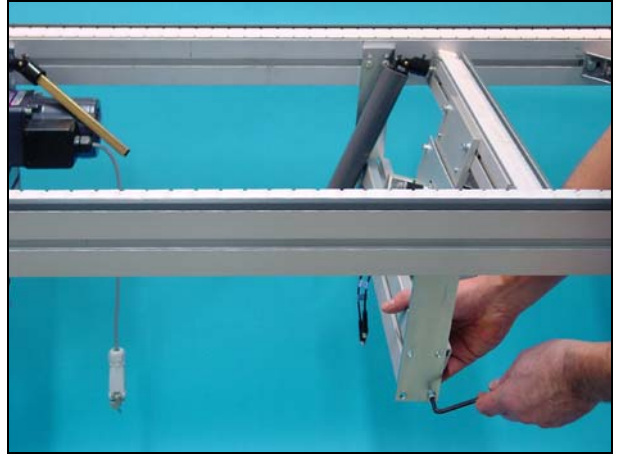
- 6 Mount the motor half of the transfer unit to the brackets using the eight M6 screws. Use the 5 mm Allen key.



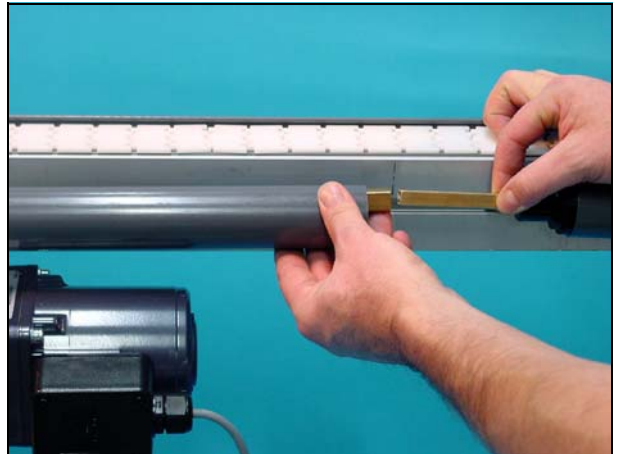
- 7 Adjust the motor half of the transfer unit to make it perpendicular to the conveyor beam.



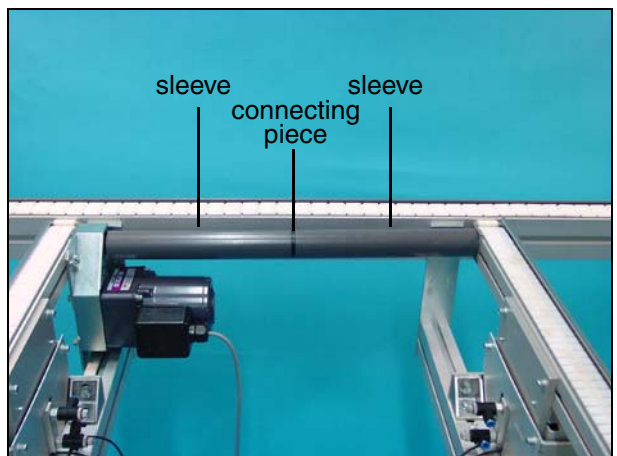
- 8 Mount the other half of the transfer unit to the brackets. Use only one screw on each side of the transfer unit. This is to make the unit half able to rotate.



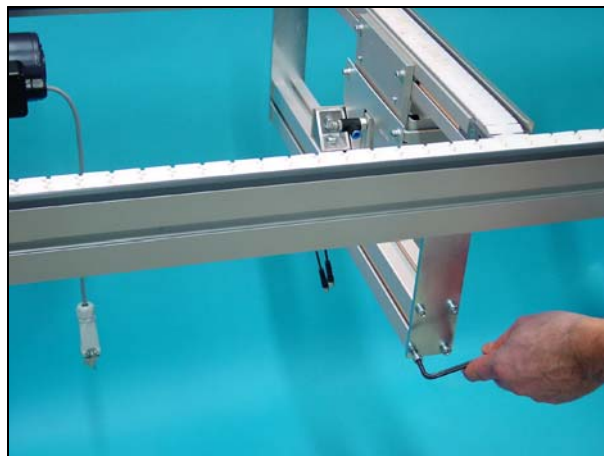
- 9 Dock the two transfer unit halves by connecting the telescopic shaft. Do not forget the sleeve on the shaft of the motor half of the transfer unit.



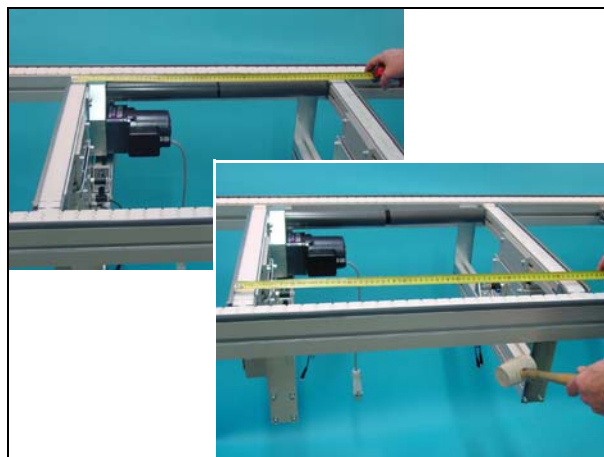
- 10 Docking is complete.



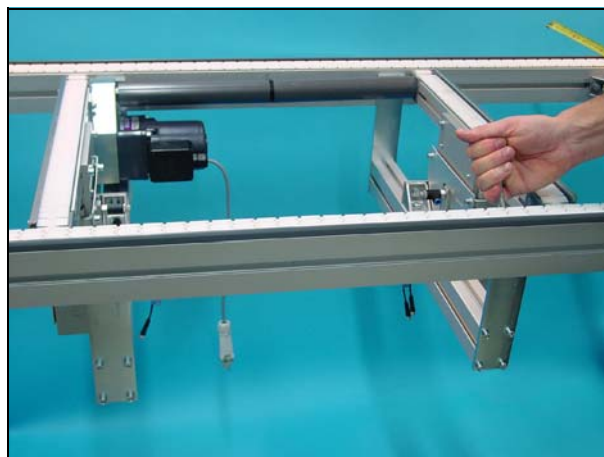
- 11 Use the remaining six screws to fasten the transit unit half without motor.



- 12 Measure the transfer unit regarding the pallet length (PL). From guide to stop the measure should be PL+3 mm (approx). Adjust the transfer unit half without motor to make it parallel to the other transfer unit half.



- 13 Tighten the final screws holding the mounting brackets on the transfer half without motor. Use the 10 mm box wrench.



Mounting damper MC 35 PW A

Introduction

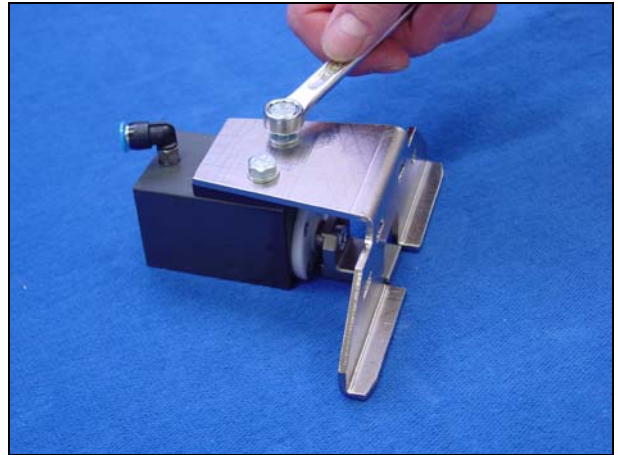
Mount the damper on the transfer unit.

Tools

Box wrench	8 mm
Box wrench	10 mm

Instruction

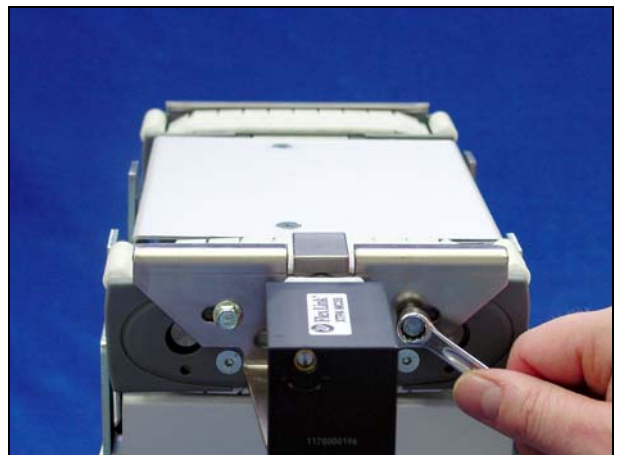
- 1 Fit the damper MC35 to the stop plate sent along with the damping kit. Tighten the screws (2×M6). Use the 10 mm box wrench. Do not forget the steel washer.



- 2 Loosen the screws (4 or 5×M5) that hold the stop plate that is already on the transfer unit. Use the 8 mm box wrench. Remove the stop plate.



- 3 Fit the stop plate with the damper and tighten the screws (4 or 5×M5). Use the 8 mm box wrench.



Mounting lift and rotate unit XTUR P11

Introduction

If nothing else is specified the instruction steps are valid for both XT and XT Compact conveyors.

CAUTION! Running this module without enclosure can cause personal injury.

Tools

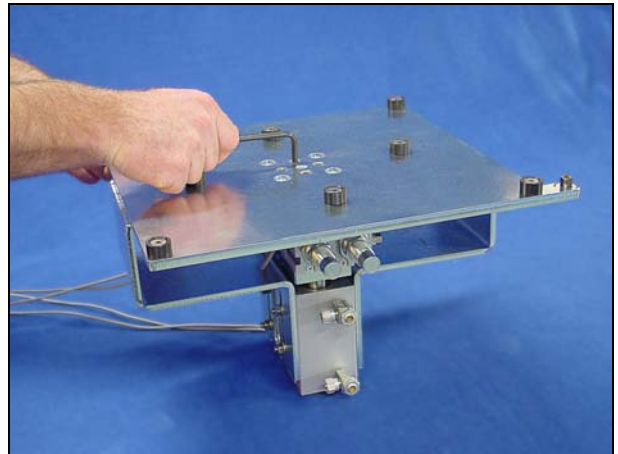
Allen key	4 mm
Allen key	5 mm
Allen key	6 mm
Box wrench	10 mm
Box wrench	19 mm
Box wrench	24 mm

Instruction

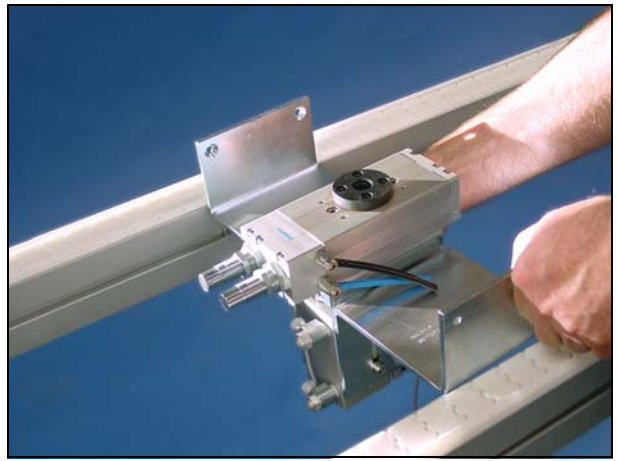
- 1 Insert the four M6 slot nuts into the conveyor T-slot.



- 2 Loosen the four M6 screws holding the top plate using the 5 mm Allen key. Remove the top plate.



- 3 Fit the lift and locate unit from above. Fit the four M6 screws and tighten them with a 4 mm Allen key.



- 4 Fit the top plate and tighten the four M6 screws using the 5 mm Allen key. Torque value for tightening: 10 Nm.

Note! Make sure that the top plate has not been turned 90° by mistake. The top plate must be positioned according to the picture when the rotate actuator has reached end position.



- 5 To adjust the height of the module, use the 5 mm Allen key and a 10 mm box wrench to loosen the four M6 screws on the brackets.

XT Compact conveyor – press the unit down to bottom end position.

XT conveyor – press the unit up to upper end position.

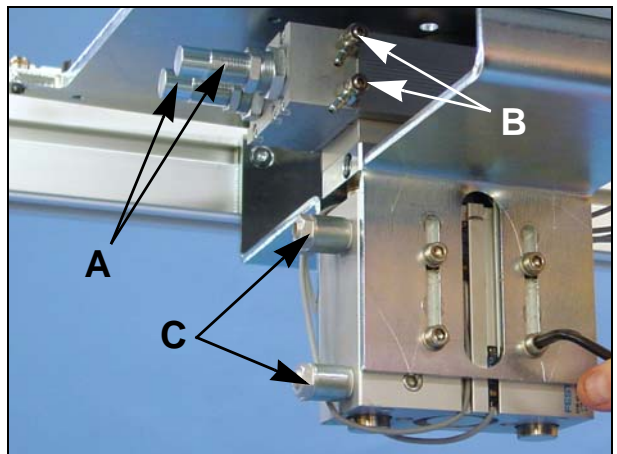
Tighten the four screws.



- 6 If necessary, fineadjust the end positions (A) of the rotate actuator. Use a 19 mm and 24 mm box wrench.

Use the non-return throttle valves (B) to adjust the speed of the pneumatic rotate actuator. Use a small screwdriver.

Use the non-return throttle valves (C) to adjust the speed of the pneumatic lift cylinder. Use a small screwdriver.



Introduction

If nothing else is specified this instruction step is valid for all mounting options (F00, F01 and F02).

CAUTION! Running this module without enclosure can cause personal injury.

Tools

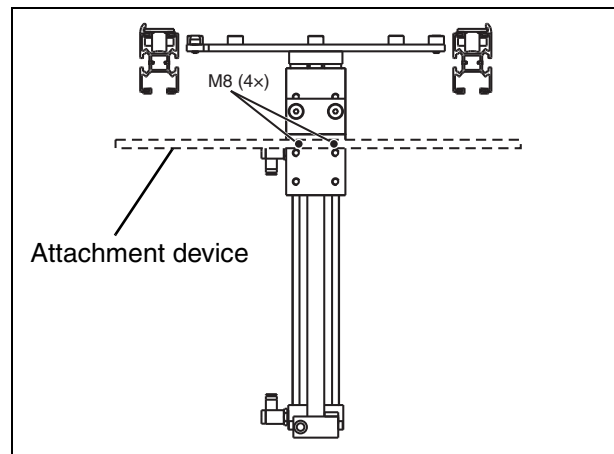
Allen key	4 mm
Allen key	5 mm
Allen key	6 mm
Box wrench	19 mm
Box wrench	24 mm

Instruction

1 If F=F00

Place the unit on your attachment device and tighten the four M8 screws using a 5 mm Allen key.

NOTE! The horizontal plane on the attachment device and the plane on the conveyor chains must be parallel.



2 If F=F01

Insert the four M6 slot nuts into the conveyor T-slot. Mount the support frame onto the conveyor and tighten the four M6 screws using a 4 mm Allen key.

The upper holes on the brackets are for mounting the support frame onto an XT Compact conveyor.

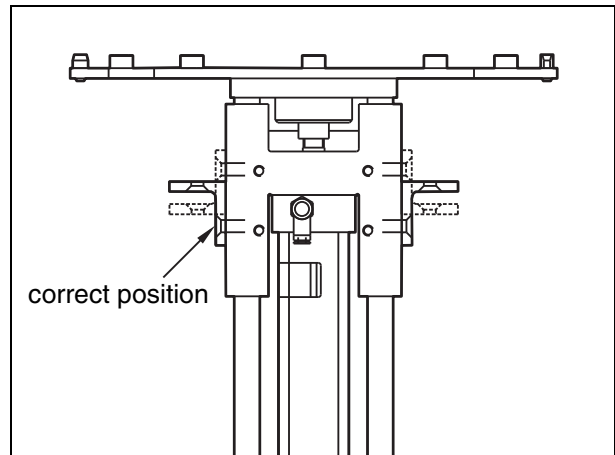


3 If F=F01

Insert the four M8 slot nuts into the T-slot on the underside of the support frame beams.

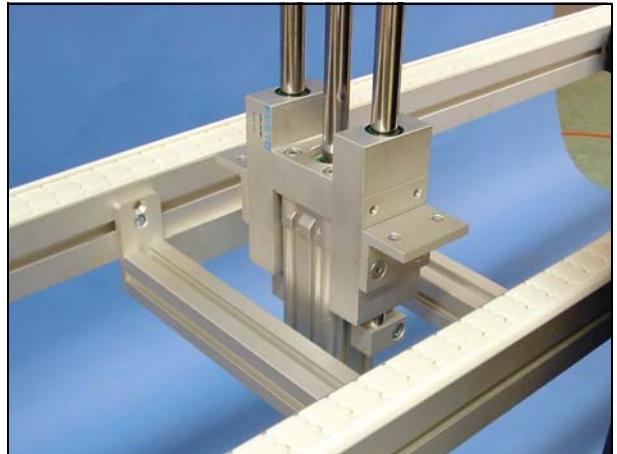


- 4 Move the angle brackets on the lift and locate unit down to their bottom position. Turn them 180°.



5 If F=F01

Pull the top plate to its fully ejected position. Fit the lift and locate unit from above by turning it 90° so that the angle brackets do not collide with the support frame beams. Lower the unit until the angle brackets are below the support frame beams and turn it back 90°.



6 If F=F01

Fit the four M8 screws and tighten them with a 5 mm Allen key.



7 If F=F02

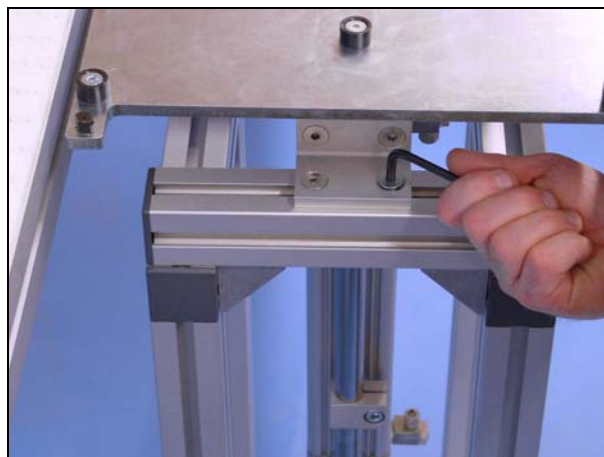
Put the support frame in position below and between the conveyor beams. Insert the four M8 slot nuts into the T-slot on the upper side of the support frame beams.

CAUTION! The horizontal plane on the support frame and the plane on the conveyor chains must be parallel.

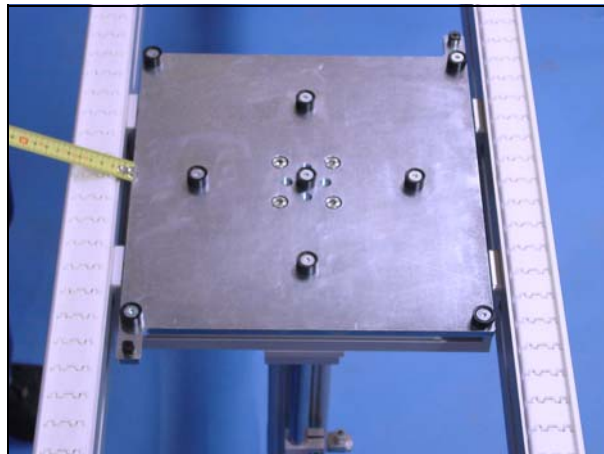


8 If F=F02

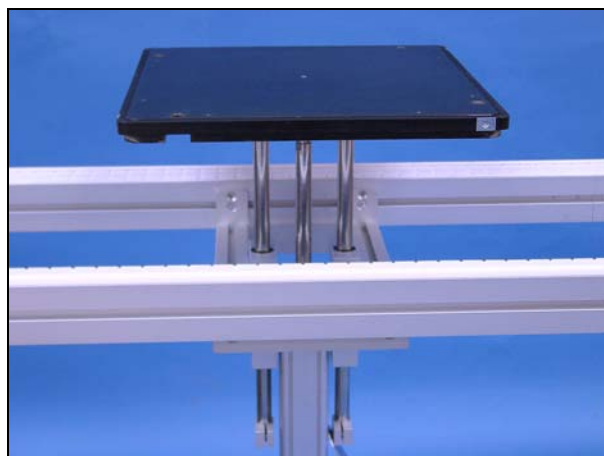
Mount the unit on top of the support frame and tighten the four M8 screws using a 5 mm Allen key.



9 Adjust the support, unit and/or the conveyor so that the lift and locate device is positioned correctly.

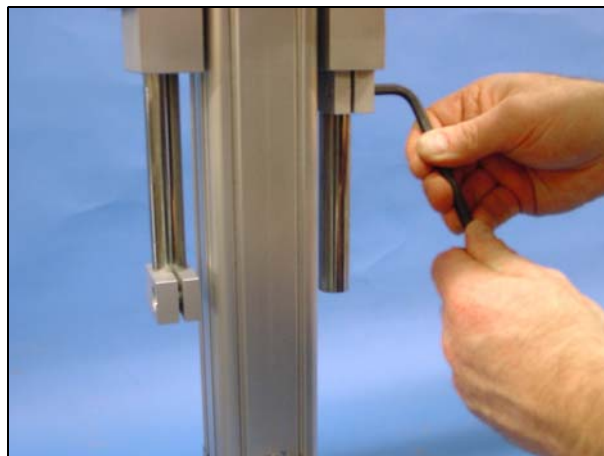


10 To adjust the height of the module stroke. Place a pallet on the top plate and press it up to the correct position. Fix the top plate in that position.



- 11 Use the 6 mm Allen key to loosen the screws on the clamps. Press the clamps tight to the guiding unit and tighten the screws. Torque value for tightening: 20 Nm.

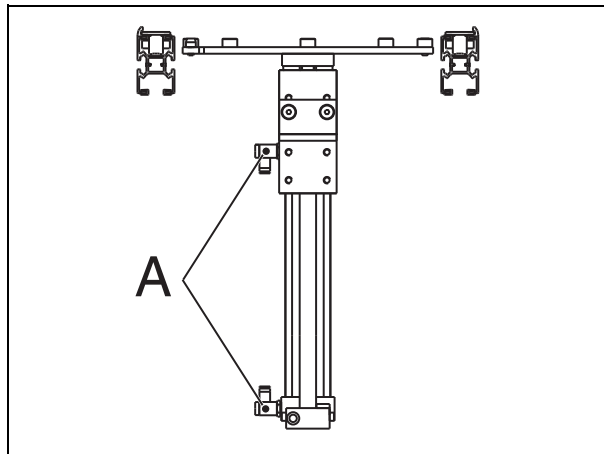
Lower the top plate again.



- 12 To fineadjust the height, loosen the check nut on the cylinder rod piston using a 24 mm and a 19 mm box wrench. Turn the rod piston with one box wrench and keep the top plate still with the other box wrench until the correct height is gained. Tighten the check nut.



- 13 Use the non-return throttle valves (A) to adjust the speed of the pneumatic cylinder. Use a small screwdriver.



EC Declaration of Incorporation Partly completed machinery



FlexLink Components AB
SE-41550 Göteborg
Sweden

We hereby declare that the following equipment is intended to be incorporated into a FlexLink conveyor system and thereby forming a machine. Operation is prohibited until it has been determined that the machine in which these products are incorporated, has been declared in conformity with the Machinery Directive 2006/42/EC, together with amendments which have entered into force as of the date of issue of this declaration, with particular reference to the essential health and safety requirements in connection with the design, construction and manufacture of the below specified equipment.

- **Conveyor modules (XTUC)**
XTUC S11, ..S51, .. J51, .. J52, .. L51, .. L52, .. Q51, .. Q52, .. U51, .. U52,
.. Z51, .. Z52, .. F51, .. F52
- **Transfer modules (XTUT)**
XTUT S10 A, .. S11 A, .. S12 A, .. R11 A, .. R12 A, .. M11 A, .. M12 A
- **Work station modules (XTUW)**
XTUW R11 A, .. M11 A, .. T11 A, .. Q51 A

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