Matveyor® ½” Pitch Conveyor Chains for Product Dynamic Division in Packaging Machines

611 and RR 611 Series
INDEX

ABSTRACT ............................................................................................................................................................................................ 3

KEY FEATURES AND BENEFITS ............................................................................................................................................................. 4

FIELDS OF APPLICATION ........................................................................................................................................................................ 5

CHAIN SELECTION ACCORDING TO THE PRODUCT CONVEYED .................................................................................................... 6

CONVEYOR CHAINS FOR PRODUCT DYNAMIC DIVISION - RANGE

● 611 Series .......................................................................................................................................................................................... 7
● RR 611 Series .................................................................................................................................................................................... 8

ACCESSORIES

● Combs for RR 611 Series ...................................................................................................................................................................... 9
● Sprockets for chains - overview ........................................................................................................................................................ 10
● Moulded sprockets ............................................................................................................................................................................. 11, 13, 15
● Machined sprockets .......................................................................................................................................................................... 12, 14, 16

ENGINEERING MANUAL

● Drive configuration ............................................................................................................................................................................... 17
● Combs positioning for RR 611 Series .............................................................................................................................................. 18
● Assembly / Disassembly ................................................................................................................................................................. 19
Regina Matveyor® 611 and RR 611 Series are ideal for product dynamic division within packaging machines. These Series represent a unique solution for the packaging industry:

- Most complete range of ½” pitch narrow chains available on the market, with solid top surface (611 Series) or raised rib surface (RR 611 Series) and widths that range from 29 mm to 76 mm. This comprehensive range makes it possible to convey all type of containers.

- Clipless assembly of the modules, easing chain installation on the machines with no risk of pin disassembly during application.

Regina Matveyor® 611 and RR 611 Series, with or without tracking guide, have the following geometrical and technical characteristics:

- Pitch: 12,7 mm (½”).

- Thickness: 8,7 mm (0.343”).

- Available widths for 611 Series: 29 mm; 34 mm; 37 mm; 51 mm; 76 mm.
  For RR 611 Series: 29 mm; 37 mm; 46 mm; 55 mm; 76 mm.

- Tracking guide: chains widths available with or without tracking guide.

- Top surface: solid (611 Series) or raised rib (RR 611 Series).

- Bottom surface: round.

- Minimum backflexing radius: 20 mm for 611 Series, 35 mm for RR 611 Series.

Regina Matveyor® 611 and RR 611 Series are realized in the following materials:

- Chain material: UP Ultra Performance Homopolymer Delrin®.

- Pin material: Polyester (PBT).

UP material (Dupont™ Delrin® Ultra Performance Special Homopolymer Acetal Resin), thanks to its limited low wear over time and low coefficient of friction in non-lubricated environment, is ideal for conveyor applications.

Pins manufactured in PBT material display superior wear resistance and therefore are suitable for high speed applications with short center to center distance.
### Key Features and Benefits

#### Features
- Short pitch 12.7 mm (½”).
- Curved bottom contour.
- Raised rib surface with special “Z” design (RR 611 Series).
- Availability of 8T sprocket.
- Clipless assembly of the modules.
- Reduced chain backflexing radius.

#### Effects
- Chordal effect minimization, down to 0.15 mm with a ¾” diameter nose bar.
- Maximization of contact area with nose bar / roller.
- Top surface without discontinuity.
- Chain vibrations minimization.
- Easy chain installation on the machines.
- Overall return section dimensions minimization.

#### Benefits
- Tight end-to-end transfer.
- Maximization of product stability during travel and head transfer.
- Dead plate width minimization.
- Belt and nose bar wear minimization.
- Compact conveyor structure.
- Vertical room saving.
- Cost saving: maintenance & assembly time.
Matveyor® ½” Pitch Conveyor Chains for Product Dynamic Division in Packaging Machines - 611 & RR 611 Series

FIELDS OF APPLICATION

Regina Matveyor® 611 and RR 611 Series comprise conveyor chains dedicated to the product dynamic dividing area of packaging machines. In this area, individual containers (made of plastic, metal or glass) are conveyed to the pack formation area, where the containers are clustered in the required format by dividing bars, electronically synchronized with the conveyor chains.

INDUSTRIES OF APPLICATION:

- Bottling and Canning
- Food Filling
- Pharmaceutical
- Consumer goods
CHAIN SELECTION ACCORDING TO THE PRODUCT CONVEYED

Regina Matveyor® 611 and RR 611 Series display the most complete range of ½” pitch narrow chains available on the market, with widths that range from 29 mm to 76 mm, therefore making it possible to convey all type of containers.

Regina Matveyor® RR 611 Series offers the best support for the most unstable products like PET bottles with petaloid bottom.

The graph below serves as guideline to select the best chain according the the container conveyed.
### 611 SERIES

8,7 mm (0.343”) thickness
Solid Top

#### MATERIALS

<table>
<thead>
<tr>
<th>PLATE</th>
<th>PIN</th>
<th>VERSION WITHOUT TRACKING GUIDE</th>
<th>VERSION WITH TRACKING GUIDE</th>
</tr>
</thead>
<tbody>
<tr>
<td>Ultra Performance Homopolymer Delrin®</td>
<td>PBT</td>
<td>WITHOUT TRACKING GUIDE</td>
<td>WITH TRACKING GUIDE</td>
</tr>
<tr>
<td>611A UP K 34</td>
<td>611AUPKAA/000</td>
<td>34</td>
<td>1.34</td>
</tr>
<tr>
<td>611A UP K 37</td>
<td>611AUPKAD/000</td>
<td>37</td>
<td>1.46</td>
</tr>
<tr>
<td>611A UP K 51</td>
<td>611AUPKB/000</td>
<td>51</td>
<td>2.01</td>
</tr>
<tr>
<td>611A UP K 76</td>
<td>611AUPKDA/000</td>
<td>76</td>
<td>2.99</td>
</tr>
<tr>
<td>Ultra Performance Homopolymer Delrin®</td>
<td>PBT</td>
<td>WITHOUT TRACKING GUIDE</td>
<td>WITH TRACKING GUIDE</td>
</tr>
<tr>
<td>611AG UP K 29</td>
<td>611AGPKWB/000</td>
<td>29</td>
<td>1.14</td>
</tr>
<tr>
<td>611AG UP K 34</td>
<td>611AGPKAA/000</td>
<td>34</td>
<td>1.34</td>
</tr>
<tr>
<td>611AG UP K 37</td>
<td>611AGPKAD/000</td>
<td>37</td>
<td>1.46</td>
</tr>
<tr>
<td>611AG UP K 51</td>
<td>611AGPKB/000</td>
<td>51</td>
<td>2.01</td>
</tr>
<tr>
<td>611AG UP K 76</td>
<td>611AGPKDA/000</td>
<td>76</td>
<td>2.99</td>
</tr>
</tbody>
</table>

**Standard packaging**
Rolls of 3.048 (10 ft)
Matveyor® ½” Pitch Conveyor Chains for Product Dynamic Division in Packaging Machines - 611 & RR 611 Series

RR 611 SERIES

8,7 mm (0.343”) thickness
Raised Rib

### MATERIALS

<table>
<thead>
<tr>
<th>Plate</th>
<th>Pin</th>
<th>VERSION DESCRIPTION</th>
<th>PART NUMBER</th>
<th>WIDTH W</th>
<th>INTERNAL GUIDE G</th>
<th>GUIDE TRACK A</th>
<th>WORKING LOAD (25°C/77°F)</th>
<th>WEIGHT</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td></td>
<td></td>
<td>RR611 A UP K 29</td>
<td>29</td>
<td>1.14</td>
<td>-</td>
<td>-</td>
<td>570</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td>RR611 A UP K 37</td>
<td>37</td>
<td>1.46</td>
<td>-</td>
<td>-</td>
<td>570</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td>RR611 A UP K 46</td>
<td>46</td>
<td>1.81</td>
<td>-</td>
<td>-</td>
<td>570</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td>RR611 A UP K 55</td>
<td>55</td>
<td>2.17</td>
<td>-</td>
<td>-</td>
<td>570</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td>RR611 A UP K 76</td>
<td>76</td>
<td>2.99</td>
<td>-</td>
<td>-</td>
<td>1067</td>
</tr>
<tr>
<td></td>
<td></td>
<td>ULTRA PERFORMANCE</td>
<td>RR611 A UP K 37</td>
<td>37</td>
<td>1.46</td>
<td>30.5</td>
<td>1.20</td>
<td>570</td>
</tr>
<tr>
<td></td>
<td></td>
<td>HOMOPOLYMER DELRIN®</td>
<td>RR611 A UP K 76</td>
<td>76</td>
<td>2.99</td>
<td>-</td>
<td>-</td>
<td>1067</td>
</tr>
</tbody>
</table>

**VERSION WITHOUT TRACKING GUIDE**

**VERSION WITH TRACKING GUIDE**

Standard packaging
Rolls of 3.048 (10 ft)
ACCESSORIES

COMBS FOR CHAINS

FULL PRODUCT RANGE OVERVIEW

Combs for:
• RR 611

MATERIALS

Combs  UP Ultra Performance Homopolymer Delrin®

---

COMB FOR K 29 CHAIN

PART NUMBER TC611-01

COMB FOR K 37 CHAIN

PART NUMBER TC611-03

COMB FOR K 46 CHAIN

PART NUMBER TC611-04

COMB FOR K 55 CHAIN

PART NUMBER TC611-06

COMB FOR K 76 CHAIN

PART NUMBER TC611-07
ACCESSORIES

SPROCKETS FOR CHAINS - OVERVIEW

ABSTRACT
Regina sprockets for Matveyor® RR 611 Series are available for all chain widths, whether or not the chain has tracking guide.

Regina sprockets for Matveyor® 611 Series are diversely available depending on whether the chain has tracking guide or not. In particular:

<table>
<thead>
<tr>
<th>NUMBER OF TEETH</th>
<th>TYPE OF SPROCKETS</th>
<th>MANUFACTURING</th>
<th>CHAIN TYPE COMBINATION</th>
<th>MATERIALS</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td></td>
<td>MANUFACTURING</td>
<td>CHAINS WITHOUT</td>
<td>CHAINS WITH TRACKING GUIDES</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td>TRACKING GUIDE</td>
<td>SPROCKET</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td></td>
<td>SCREW &amp; NUTS</td>
</tr>
<tr>
<td>8T</td>
<td>Drive / Idler</td>
<td>Machined + Solid</td>
<td>All widths</td>
<td>51mm; 76mm</td>
</tr>
<tr>
<td>14T</td>
<td>Drive / Idler</td>
<td>Machined + Solid</td>
<td>All widths</td>
<td>51mm; 76mm</td>
</tr>
<tr>
<td>19T</td>
<td>Drive / Idler</td>
<td>Machined + Solid</td>
<td>All widths</td>
<td>51mm; 76mm</td>
</tr>
<tr>
<td>24T</td>
<td>Drive / Idler</td>
<td>Machined + Solid</td>
<td>All widths</td>
<td>29mm; 34mm; 37mm</td>
</tr>
<tr>
<td>28T</td>
<td>Drive / Idler</td>
<td>Machined + Solid</td>
<td>All widths</td>
<td>51mm; 76mm</td>
</tr>
<tr>
<td>28T</td>
<td>Drive / Idler</td>
<td>Moulded + Split</td>
<td>All widths</td>
<td>All widths (two different sprockets)</td>
</tr>
<tr>
<td>32T</td>
<td>Drive / Idler</td>
<td>Machined + Split</td>
<td>All widths</td>
<td>51mm; 76mm</td>
</tr>
<tr>
<td>36T</td>
<td>Drive / Idler</td>
<td>Moulded + Split</td>
<td>All widths</td>
<td>51mm; 76mm</td>
</tr>
<tr>
<td>38T</td>
<td>Drive / Idler</td>
<td>Moulded + Split</td>
<td>All widths</td>
<td>51mm; 76mm</td>
</tr>
</tbody>
</table>

The FULL PRODUCT RANGE OVERVIEW of Regina sprockets for Matveyor® 611 and RR 611 Series is displayed in the forthcoming pages, according to the following logic:

- Pages 11 and 12: sprockets for 611 Series, chains width of 29 mm, 34 mm, 37 mm with tracking guide
- Pages 13, 14, 15, and 16:
  - sprockets for 611 Series, all chains width without tracking guide
  - sprockets for 611 Series, chains width of 51 mm and 76 mm with tracking guide
  - sprockets for RR 611 Series, all chains widths
**Matveyor** ½” Pitch Conveyor Chains for Product Dynamic Division in Packaging Machines - 611 & RR 611 Series

ACCESSORIES

SPROCKETS FOR CHAINS
FULL PRODUCT RANGE OVERVIEW

## MATERIALS

<table>
<thead>
<tr>
<th>Material</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>Sprocket</td>
<td>PGF Reinforced Polyamide</td>
</tr>
<tr>
<td>Screws*</td>
<td>SS Stainless Steel</td>
</tr>
<tr>
<td>Nuts*</td>
<td>ZN Zinc Plated Steel</td>
</tr>
</tbody>
</table>

* For split sprockets only.

## MOULDED SOLID DRIVE AND IDLER SPROCKETS

<table>
<thead>
<tr>
<th>N. TEETH</th>
<th>PITCH DIAMETER OD</th>
<th>OUTSIDE DIAMETER OD</th>
<th>WEAR STRIPS POSITIONING A</th>
<th>BORE SIZE*</th>
<th>PART NUMBER</th>
<th>WEIGHT</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>mm</td>
<td>inch</td>
<td>mm</td>
<td>mm</td>
<td>SQUARE BORE SQ DRIVE/IDLER</td>
<td>ROUND BORE RB DRIVE IDLER</td>
</tr>
<tr>
<td>16</td>
<td>65,10</td>
<td>2.563</td>
<td>66,30</td>
<td>2.610</td>
<td>1.110</td>
<td>20 MPBT6111620 MPBF6111620</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td>MPBQ6111625 MPBF6111625</td>
<td>0,04</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td>MPBT6111630 MPBF6111630</td>
<td>0,04</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td>1 MPBT61116254 MPBF61116254</td>
<td>0,04</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td>1 ¼ MPBT61116317 MPBF61116317</td>
<td>0,03</td>
</tr>
</tbody>
</table>

## MOULDED SPLIT DRIVE AND IDLER SPROCKETS

<table>
<thead>
<tr>
<th>N. TEETH</th>
<th>PITCH DIAMETER OD</th>
<th>OUTSIDE DIAMETER OD</th>
<th>WEAR STRIPS POSITIONING A</th>
<th>BORE SIZE*</th>
<th>PART NUMBER</th>
<th>WEIGHT</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>mm</td>
<td>inch</td>
<td>mm</td>
<td>mm</td>
<td>SQUARE BORE SQ DRIVE/IDLER</td>
<td>ROUND BORE RB DRIVE IDLER</td>
</tr>
<tr>
<td>28</td>
<td>113,43</td>
<td>4.466</td>
<td>114,70</td>
<td>4.516</td>
<td>2.063</td>
<td>25 MPBST6112825 MPBSF6112825</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td>MPBST6112830 MPBSF6112830</td>
<td>0,15</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td>MPBST6112835 MPBSF6112835</td>
<td>0,14</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td>MPBQ6112840 MPBF6112840</td>
<td>0,13</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td>1 MPBST61128254 MPBSF61128254</td>
<td>0,15</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td>1 ¼ MPBST61128317 MPBSF61128317</td>
<td>0,14</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td>1 ½ MPBQ61128381 MPB61128381</td>
<td>0,14</td>
</tr>
</tbody>
</table>

*In case of round bore diameter is indicated. In case of square bore, side of the square is indicated.
** Imperial round bore drive sprockets are supplied with setscrew. Metric round bore drive sprockets are supplied without setscrew.

Moulded sprockets for:
- 611 Series with tracking guide (29 mm, 34 mm, 37 mm widths only)
ACCESSORIES
SPROCKETS FOR CHAINS
FULL PRODUCT RANGE OVERVIEW

Machined solid sprockets for:
- 611 Series with tracking guide (29 mm, 34 mm, 37 mm widths only)

MATERIALS

Sprocket Polyamide

MACHINED SOLID DRIVE AND IDLER SPROCKETS

<table>
<thead>
<tr>
<th>N. TEETH</th>
<th>PITCH DIAMETER OD</th>
<th>OUTSIDE DIAMETER OD</th>
<th>WEAR STRIPS POSITIONING A</th>
<th>BORE SIZE*</th>
<th>PART NUMBER</th>
<th>WEIGHT</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>mm</td>
<td>inch</td>
<td>mm</td>
<td>inch</td>
<td>mm</td>
<td>inch**</td>
</tr>
<tr>
<td>24</td>
<td>97,30</td>
<td>3.831</td>
<td>99,50</td>
<td>3.917</td>
<td>44,30</td>
<td>1.744</td>
</tr>
<tr>
<td></td>
<td>97,30</td>
<td>3.831</td>
<td>99,50</td>
<td>3.917</td>
<td>44,30</td>
<td>1.744</td>
</tr>
<tr>
<td></td>
<td>97,30</td>
<td>3.831</td>
<td>99,50</td>
<td>3.917</td>
<td>44,30</td>
<td>1.744</td>
</tr>
<tr>
<td></td>
<td>97,30</td>
<td>3.831</td>
<td>99,50</td>
<td>3.917</td>
<td>44,30</td>
<td>1.744</td>
</tr>
<tr>
<td>1</td>
<td>105</td>
<td>4.134</td>
<td>106,60</td>
<td>4.216</td>
<td>44,30</td>
<td>1.744</td>
</tr>
<tr>
<td>1 ¼</td>
<td>113,80</td>
<td>4.488</td>
<td>115,30</td>
<td>4.531</td>
<td>44,30</td>
<td>1.744</td>
</tr>
<tr>
<td>1 ½</td>
<td>122,20</td>
<td>4.807</td>
<td>123,70</td>
<td>4.854</td>
<td>44,30</td>
<td>1.744</td>
</tr>
</tbody>
</table>

*In case of round bore diameter is indicated. In case of square bore, side of the square is indicated.
** Imperial round bore drive sprockets are supplied with setscrew. Metric round bore drive sprockets are supplied without setscrew.
ACCESSORIES
SPROCKETS FOR CHAINS
FULL PRODUCT RANGE OVERVIEW

Moulded solid sprockets for:
- 611 Series without tracking guide (all widths)
- 611 Series with tracking guide (51 mm, 76 mm widths only)
- RR 611 Series (all widths)

MATERIALS
Sprocket: Reinforced Polyamide

MOULDED SOLID DRIVE AND IDLER SPROCKETS

<table>
<thead>
<tr>
<th>N. TEETH</th>
<th>PITCH DIAMETER PD</th>
<th>OUTSIDE DIAMETER PD</th>
<th>WEAR STRIPS POSITIONING A</th>
<th>BORE SIZE*</th>
<th>PART NUMBER</th>
<th>WEIGHT</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>mm</td>
<td>inch</td>
<td>mm</td>
<td>inch</td>
<td>mm</td>
<td>inch</td>
</tr>
<tr>
<td>16</td>
<td>65,10</td>
<td>2.563</td>
<td>66,30</td>
<td>2.610</td>
<td>28,20</td>
<td>1.110</td>
</tr>
<tr>
<td></td>
<td>25</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>30</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>1</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>1 ¼</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>28</td>
<td>113,43</td>
<td>4.466</td>
<td>114,70</td>
<td>4.516</td>
<td>52,40</td>
<td>2.063</td>
</tr>
<tr>
<td></td>
<td>30</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>35</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>40</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>60</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>1</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>1 ¼</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>1 ½</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

*In case of round bore diameter is indicated. For square bore, side of the square is indicated.
### ACCESSORIES

**SPROCKETS FOR CHAINS**

**FULL PRODUCT RANGE OVERVIEW**

Machined solid sprockets for:
- 611 Series without tracking guide (all widths)
- 611 Series with tracking guide (51 mm, 76 mm widths only)
- RR 611 Series (all widths)

#### MATERIALS

| Sprocket | PA Polyamide |

#### MACHINED SOLID DRIVE AND IDLER SPROCKETS

<table>
<thead>
<tr>
<th>N. TEETH</th>
<th>PITCH DIAMETER PD</th>
<th>OUTSIDE DIAMETER OD</th>
<th>WEAR STRIPS POSITIONING A</th>
<th>BORE SIZE*</th>
<th>SQUARE BORE SQ</th>
<th>ROUND BORE RB</th>
<th>PART NUMBER</th>
<th>WEIGHT</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>mm inch</td>
<td>mm inch</td>
<td>mm inch</td>
<td>mm inch</td>
<td>mm inch**</td>
<td>DRIVE/IDLER</td>
<td>DRIVE</td>
<td>IDLER</td>
</tr>
<tr>
<td>8</td>
<td>33,19</td>
<td>1.307</td>
<td>34,20</td>
<td>1.346</td>
<td>12,25</td>
<td>0.482</td>
<td>MPBAT6000820</td>
<td>MPBAF6000820</td>
</tr>
<tr>
<td>14</td>
<td>57,07</td>
<td>2.247</td>
<td>59,00</td>
<td>2.323</td>
<td>24,18</td>
<td>0.952</td>
<td>MPBAQ6001425</td>
<td>MPBAT6001425</td>
</tr>
<tr>
<td>19</td>
<td>77,16</td>
<td>3.038</td>
<td>78,80</td>
<td>3.102</td>
<td>34,20</td>
<td>1.346</td>
<td>MPBAQ6001940</td>
<td>MPBAF6001940</td>
</tr>
</tbody>
</table>

*In case of round bore diameter is indicated. In case of square bore, side of the square is indicated.

** Imperial round bore drive sprockets are supplied with setcrew. Metric round bore drive sprockets are supplied without setcrew.
ACCESSORIES

SPROCKETS FOR CHAINS
FULL PRODUCT RANGE OVERVIEW

Moulded split sprockets for:
- 611 Series without tracking guide (all widths)
- 611 Series with tracking guide (51 mm, 76 mm widths only)
- RR 611 Series (all widths)

** MATERIALS **

<table>
<thead>
<tr>
<th>Sprocket</th>
<th>PGF</th>
<th>Reinforced Polyamide</th>
</tr>
</thead>
<tbody>
<tr>
<td>Screws</td>
<td>SS</td>
<td>Stainless steel</td>
</tr>
<tr>
<td>Nuts</td>
<td>ZN</td>
<td>Zinc Plated Steel</td>
</tr>
</tbody>
</table>

MOULDED SPLIT DRIVE AND IDLER SPROCKETS

<table>
<thead>
<tr>
<th>N. TEETH</th>
<th>PITCH DI AMETER PD</th>
<th>OUTSIDE DI AMETER OD</th>
<th>WEAR STRIPS POSITIONING A</th>
<th>BORE SIZE</th>
<th>PART NUMBER</th>
<th>SQUARE BORE SQ</th>
<th>ROUND BORE RB</th>
<th>WEIGHT</th>
</tr>
</thead>
<tbody>
<tr>
<td>28</td>
<td>113.43</td>
<td>114.69</td>
<td>4.515</td>
<td>61.10</td>
<td>2.406</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>30</td>
<td>145.70</td>
<td>148.00</td>
<td>5.827</td>
<td>77.20</td>
<td>3.039</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>36</td>
<td>153.80</td>
<td>156.00</td>
<td>6.142</td>
<td>81.20</td>
<td>3.197</td>
<td></td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

NOTE: for 28T sprocket the hub width is 26 mm (1.024”)

Moulded split sprockets for:
- 611 Series without tracking guide (all widths)
- 611 Series with tracking guide (51 mm, 76 mm widths only)
- RR 611 Series (all widths)

In case of round bore diameter is indicated. In case of square bore, side of the square is indicated.

*Imperial round bore drive sprockets are supplied with setscrew. Metric round bore drive sprockets are supplied without setscrew.
## ACCESSORIES

### SPROCKETS FOR CHAINS

FULL PRODUCT RANGE OVERVIEW

Machined split sprockets for:
- 611 Series without tracking guides (all widths)
- 611 Series with tracking guide (51 mm, 76 mm widths only)
- RR 611 Series (all widths)

### MATERIALS

<table>
<thead>
<tr>
<th>Part</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>Sprocket</td>
<td>Polyamide</td>
</tr>
<tr>
<td>Screws</td>
<td>Stainless Steel</td>
</tr>
<tr>
<td>Nuts</td>
<td>Brass</td>
</tr>
</tbody>
</table>

### MACHINED SPLIT DRIVE AND IDLER SPROCKETS

<table>
<thead>
<tr>
<th>N. TEETH</th>
<th>PITCH DIAMETER PD</th>
<th>OUTSIDE DIAMETER OD</th>
<th>WEAR STRIPS POSITIONING A</th>
<th>BORE SIZE*</th>
<th>SQUARE BORE SQ</th>
<th>ROUND BORE RB</th>
<th>PART NUMBER</th>
<th>WEIGHT</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>mm inch</td>
<td>mm inch</td>
<td>mm inch</td>
<td>mm inch</td>
<td>SQUARE BORE SQ</td>
<td>ROUND BORE RB</td>
<td>MPBAST6003225</td>
<td>MPBASF6003225</td>
</tr>
<tr>
<td>32</td>
<td>129,57 5.101</td>
<td>131,00 5.157</td>
<td>69,10 2.720</td>
<td>25</td>
<td></td>
<td></td>
<td>MPBAST6003225</td>
<td>MPBASF6003225</td>
</tr>
<tr>
<td>30</td>
<td></td>
<td></td>
<td></td>
<td>30</td>
<td></td>
<td></td>
<td>MPBAST6003230</td>
<td>MPBASF6003230</td>
</tr>
<tr>
<td>35</td>
<td></td>
<td></td>
<td></td>
<td>35</td>
<td></td>
<td></td>
<td>MPBAST6003235</td>
<td>MPBASF6003235</td>
</tr>
<tr>
<td>40</td>
<td></td>
<td></td>
<td></td>
<td>40</td>
<td>MPBASQ6003240</td>
<td>MPBAST6003240</td>
<td>MPBASF6003240</td>
<td>0,38</td>
</tr>
<tr>
<td>45</td>
<td></td>
<td></td>
<td></td>
<td>45</td>
<td>MPBASQ6003245</td>
<td>MPBAST6003245</td>
<td>MPBASF6003245</td>
<td>0,36</td>
</tr>
<tr>
<td>50</td>
<td></td>
<td></td>
<td></td>
<td>50</td>
<td>MPBASQ6003250</td>
<td>MPBAST6003250</td>
<td>MPBASF6003250</td>
<td>0,35</td>
</tr>
<tr>
<td>1</td>
<td>129,57 5.101</td>
<td>131,00 5.157</td>
<td>69,10 2.720</td>
<td>1</td>
<td>MPBAST60032254</td>
<td>MPBASF60032254</td>
<td>0,41</td>
<td>0.89</td>
</tr>
<tr>
<td>1 1/8</td>
<td></td>
<td></td>
<td></td>
<td>1 1/8</td>
<td>MPBAST60032301</td>
<td>MPBASF60032301</td>
<td>0,40</td>
<td>0.88</td>
</tr>
<tr>
<td>1 1/4</td>
<td></td>
<td></td>
<td></td>
<td>1 1/4</td>
<td>MPBAST60032317</td>
<td>MPBASF60032317</td>
<td>0,39</td>
<td>0.87</td>
</tr>
<tr>
<td>1 3/4</td>
<td></td>
<td></td>
<td></td>
<td>1 3/4</td>
<td>MPBAST60032365</td>
<td>MPBASF60032365</td>
<td>0,38</td>
<td>0.84</td>
</tr>
<tr>
<td>1 1/2</td>
<td></td>
<td></td>
<td></td>
<td>1 1/2</td>
<td>MPBASQ60032381</td>
<td>MPBAST60032381</td>
<td>MPBASF60032381</td>
<td>0,38</td>
</tr>
</tbody>
</table>

*In case of round bore diameter is indicated. In case of square bore, side of the square is indicated.

** Imperial round bore drive sprockets are supplied with setscrew. Metric round bore drive sprockets are supplied without setscrew.
DRIVE CONFIGURATION

The drawings shown in Exhibit 1 and 2 and the recommendations below suggest a proper drive set-up to guarantee:

- a compact conveyor structure in the return section AND
- maximum product stability during head transfer

**EXHIBIT 1 - 611 SERIES SET-UP**

**EXHIBIT 2 - RR 611 SERIES SET-UP**

Chain and nose bar wear may cause product instability, therefore it is recommended to use dynamic head rollers with a minimum diameter D of:

<table>
<thead>
<tr>
<th>Series</th>
<th>D - MINIMUM HEAD ROLLER DIAMETER</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>CHAINS WITHOUT TRACKING GUIDE</td>
</tr>
<tr>
<td></td>
<td>mm</td>
</tr>
<tr>
<td>611, RR 611</td>
<td>19</td>
</tr>
</tbody>
</table>

When using chains with tracking guide (611 or RR 611 Series), the head rollers need to be properly machined down to avoid interference with the guide.

- A back bending roller minimum diameter of:
  - 40 mm (1.57") for 611 Series
  - 70 mm (2.76") for RR 611 Series
  is necessary to minimize back-flexing. This results in a decrease of joints wear and in an increase of chain life.

- The compact conveyor structure in the return section does not allow for a proper catenary sag. Use the back bending roller as tensioner with the possibility to move in slots present in the conveyor frame to adjust the tension on the chain.

- Recommended drive wrap angle is 140° - 150°, to guarantee correct sprocket engagement.
ENGINEERING MANUAL

COMBS POSITIONING FOR RR 611 SERIES

HEAD ROLLERS CONFIGURATION

Exhibit 3 and 4 display the correct positioning of combs using dynamic head rollers configuration.

EXHIBIT 3 - RR 611 SERIES WITHOUT TRACKING GUIDE

EXHIBIT 4 - RR 611 SERIES WITH TRACKING GUIDE

8T SPROCKET CONFIGURATION

Exhibit 5 displays the correct positioning of combs using 8T sprockets installed on conveyor ends.
ENGINEERING MANUAL

ASSEMBLY

Step 1 - Bring one chain section close to the other with the proper hinges orientation.

Step 2 - Hammer the pin inside the hinges using a drift punch to link the two parts.

DISASSEMBLY

Step 1 - Identify the correct side for disassembly by the pin end with the smallest diameter as shown in the picture.

Step 2 - Hammer the pin out of the chain using a drift punch to separate the two parts of the chain.

NOTE: ALL THE STEPS ABOVE ARE VALID BOTH FOR 611 AND RR 611 SERIES.