

## Drag and Flight Conveyors

Drag conveyors are used where multiple loading or discharge points are required and a totally enclosed conveyor is needed for dust containment, capable of handling fine materials ranging from dust to 8 inch (200 mm) lumps, where capacity requirements are high, 200 - 400 TPH. Drag conveyors are used when the material is somewhat fluid, such as TSP (fertilizer), raw metal, and trash content.

3. Chain conveyor or apron chain conveyor calculation system. The load tensions are calculated as indicated below:

$$T = F_1 + F_2 + F_3 + F_4$$

$$F_1 = \frac{W_1 + W_2 + W_3 + W_4 + W_5}{2}$$

$$F_2 = \frac{W_5 + T + W_6}{2}$$

$$F_3 = \frac{W_6 + W_7 + W_8 + W_9 + W_{10} + W_{11} + W_{12}}{2}$$

Where:

T = Total chain force or total work chain tension - (kgf) (kN)

F<sub>1</sub> = Upper chain tension - (kgf) (kN)

F<sub>2</sub> = Down chain tension - (kgf) (kN)

F<sub>3</sub> = Lift chain tension - (kgf) (kN)

W<sub>1</sub> = Conveyor total load - (kg) (kN)

W<sub>2</sub> = Conveyor material weight - (kg) (kN)

W<sub>3</sub> = Total conveyor skirt length (including inclined/declined) - (m) (ft)

W<sub>4</sub> = Conveyor horizontal skirt length - (m) (ft)

W<sub>5</sub> = Conveyor slope (inclined) / declined extension skirt length - (m) (ft)

W<sub>6</sub> = Total chain weight (see manufacturer's tables according to chain type)

W<sub>7</sub> = Driving pulley (kg) - (kN)

W<sub>8</sub> = Upper chain friction factor - 0.25 - 0.35

W<sub>9</sub> = Down chain friction factor - 0.25 - 0.35

W<sub>10</sub> = Lift chain friction factor - 0.25 - 0.35

W<sub>11</sub> = Chain conveyor speed - (m/s) - (ft/min)

W<sub>12</sub> = Driving sprocket diameter - (mm) - (in)

W = Bulk density of conveyed material - (kg/m<sup>3</sup>) - (lb/ft<sup>3</sup>)

4. To calculate the driving power (CV or HP), use the following formulae:

Metric: 
$$P = \frac{T \times V}{1000}$$

British: 
$$P = \frac{T \times V}{33000}$$

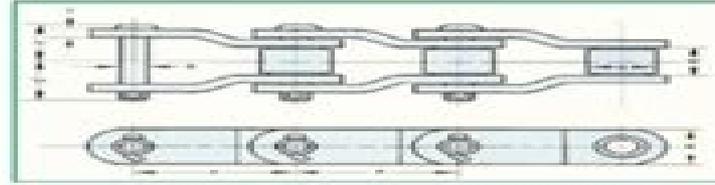
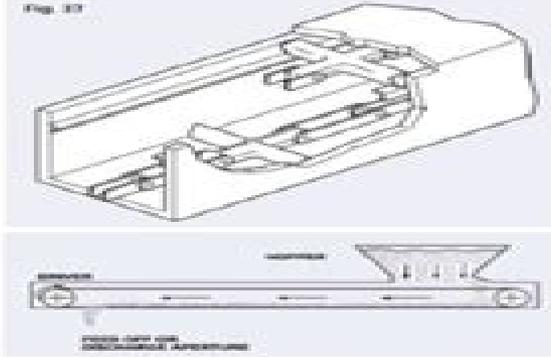
Where:

P = Driving power (kW) - (HP)

T = Total chain force or total work chain tension - (kgf) (kN)

V = Chain conveyor speed - (m/s) - (ft/min)

Fig. 37



## CHAIN CONVEYORS OR APRON CONVEYORS SUBSYSTEMS

Chain conveyors or apron conveyors are commonly used in mining and mining industries to transport heavy materials. The manufacturing industry also use widely chain conveyors for carry coal, pellets, sand, gravel and general industrial materials. These conveyors can be single or double chain strand or Caterpillar type chains. Single chain conveyors are generally easy to install, and have very minimum maintenance for users.

Many industry sectors use chain conveyor technology in their production lines. The automotive industry commonly uses chain conveyor systems to carry car parts through paint plants. Chain conveyors also have widespread use in the white and brown goods, metal finishing and distribution industries.

Chain conveyors are also used in the printing and coating industry, cosmetics, chemical treatment of metals, feed and discharge systems of boilers. In automatic printing systems the products are attached to an apron feed chain conveyor, keeping products off of the floor allows for higher productivity levels.

# Chain Calculation Manual For Chain Conveyors

**Philip Mitchel**



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**Materials Handling Handbook** Raymond A. Kulweic,1991-01-16 Sponsored jointly by the American Society of Mechanical Engineers and International Material Management Society this single source reference is designed to meet today s need for updated technical information on planning installing and operating materials handling systems It not only classifies and describes the standard types of materials handling equipment but also analyzes the engineering specifications and compares the operating capabilities of each type Over one hundred professionals in various areas of materials handling present efficient methods procedures and systems that have significantly reduced both manufacturing and distribution costs

*Springer Handbook of Mechanical Engineering* Karl-Heinrich Grote,Hamid Hefazi,2021-04-10 This resource covers all areas of interest for the practicing engineer as well as for the student at various levels and educational institutions It features the work of authors from all over the world who have contributed their expertise and support the globally working engineer in finding a solution for today s mechanical engineering problems Each subject is discussed in detail and supported by numerous figures and tables

*The Complete Guide to Chain* ,1997

**Tool and Manufacturing Engineers Handbook: Material and Part Handling in Manufacturing** Philip Mitchel,1983 Get the expert advise you need to shrink handling costs reduce downtime and improve efficiency in plant operations You ll use this comprehensive handbook during post design process selection and planning for establishing quality controls tests and measurements to streamline production and for managerial decision making on capital investments and new automated systems

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**Catalogue** International Organization for Standardization,1997      **ISO Catalogue** International Organization for Standardization,1997      **Handbook of Materials Handling** Transportforskningskommissionen (Sweden),1985

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