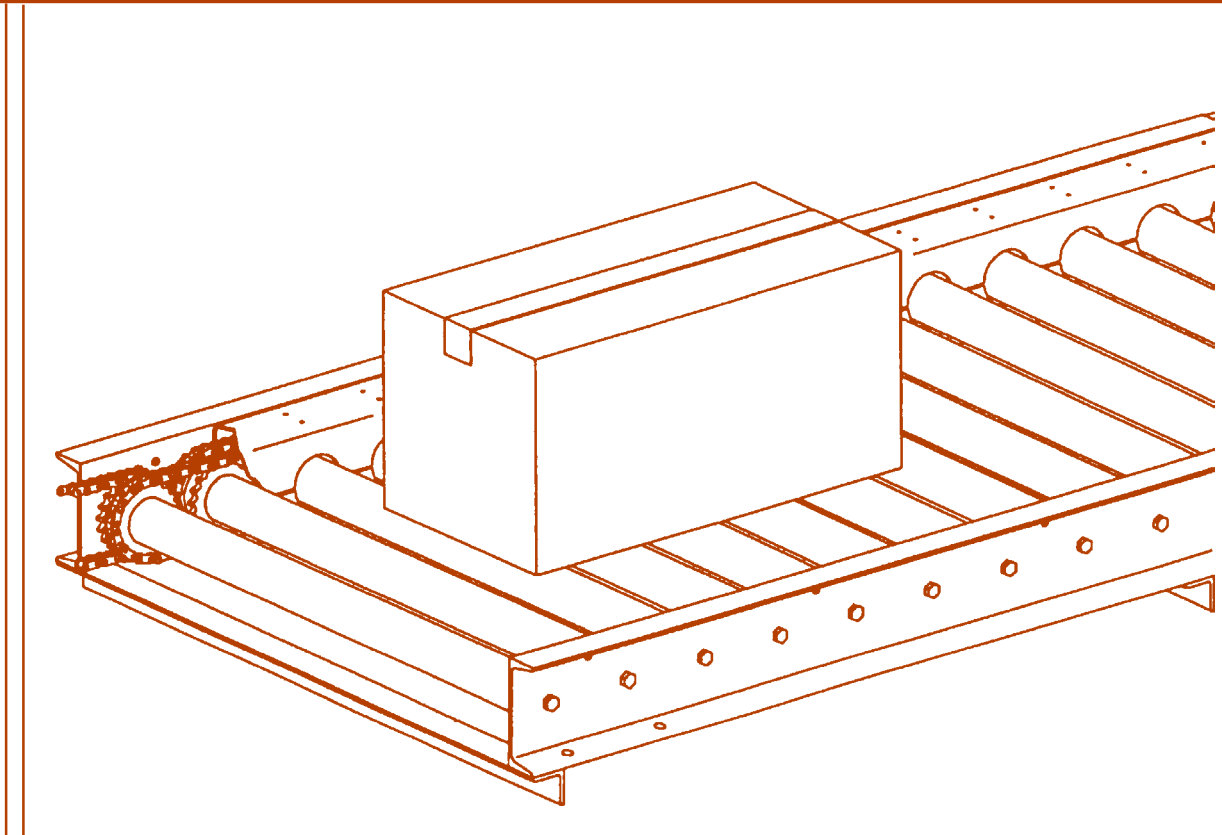


CEMA STANDARD NO. 404-2003



ANSI / CEMA 404-2003 (R2009)
Reaffirmation of ANSI / CEMA 404-2003
(Approved January 22, 2009)

CHAIN DRIVEN LIVE ROLLER CONVEYORS



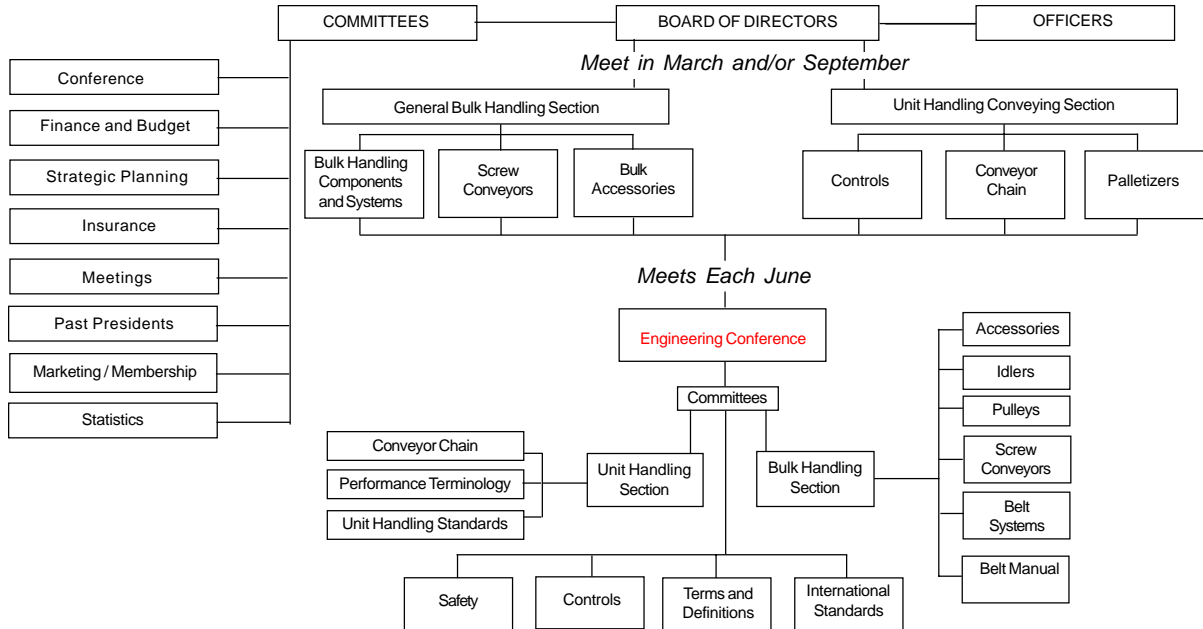
Unit Handling Conveyors



**Conveyor Equipment
Manufacturers Association**

ISBN 978-1-891171-30-7

CEMA ORGANIZATIONAL CHART



For Information on Company Membership
visit the CEMA Web Site at
<http://www.cemanet.org>

SAFETY NOTICE

The Conveyor Equipment Manufacturers Association has developed Industry Standard Safety Labels for use on the conveying equipment of its member companies.

The purpose of the labels is to identify common and uncommon hazards, conditions, and unsafe practices which can injure, or cause the death of, the unwary or inattentive person who is working at or around conveying equipment.

The labels are available for sale to member companies and non-member companies.

A full description of the labels, their purpose, and guidelines on where to place the labels on typical equipment, has been published in CEMA's *Safety Label Brochure* No. 201. The Brochure is available for purchase by members and non-members of the Association. Safety Labels and Safety Label Placement Guidelines, originally published in the Brochure, are also available free on the CEMA Web Site at http://www.cemanet.org/CEMA_Safety_Pg.htm

PLEASE NOTE: Should any of the safety labels supplied by the equipment manufacturer become unreadable for any reason, the equipment USER is then responsible for replacement and location of these safety labels.

Replacement labels and placement guidelines can be obtained by contacting your equipment supplier or CEMA.

DISCLAIMER

The information provided in this document is advisory only. These recommendations are provided by CEMA in the interest of promoting safety in the work place. These recommendations are general in nature and are not intended as a substitute for a thorough safety program. Users should seek the advise, supervision or consultation of qualified engineers or other safety professionals.

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FOREWORD

Chain driven live roller conveyors are used for the controlled movement of a great variety of regular or irregular shaped commodities, from light and fragile to heavy and rugged unit loads.

The path is usually level, but it can be slightly inclined or declined, limited by the coefficient of friction between the rollers and the load. Chain driven live roller conveyors are used for transportation, as a pacesetter for assembly operation, and as a timing medium for integrated handling systems.

The purpose of this standard is to establish recommended minimum standards for use in the design and application of chain driven live roller conveyors.

For additional information relating to definitions and selection of common components, see latest edition of the following publications: CEMA Standard No. 401, Roller Conveyors-Non Powered; CEMA Standard No. 402, Belt Conveyors; CEMA Standard No. 403, Belt Driven Live Roller Conveyors; and CEMA Standard No. 102, Conveyor Terms and Definitions.

The illustrations throughout this book are schematic in nature and represent the general nature of a particular device. The illustrations are not intended to represent the recommended safety configurations since guarding has been omitted to permit clarity in showing the operational characteristics of the device. Refer to the current editions of ANSI/ASME B20.1, Safety Standard for Conveyors and Related Equipment; ANSI/ASME B15.1, Safety Standard for Mechanical Power Transmission Apparatus; and ANSI Z244.1, American National Safety Standards for Lockout/Tagout of Energy Sources - Minimum Safety Requirements; Title 29, Code of Federal Regulations (29 C.F.R.) Part 1910.147, The control of hazardous energy (lockout/tagout); Title 29, Code of Federal Regulations (29 C.F.R.) Part 1910 Subpart O, Machinery and Machine Guarding.

TABLE OF CONTENTS

	<i>Section</i>	<i>Page</i>
DEFINITIONS	1	1
Chain Driven Live Roller		
Continuous Chain Type		
Roll-to-Roll Type		
Mechanical Elements of Chain Driven Live Roller		
APPLICATION DATA	2	2
General Application Engineering Data		
Roll-to-Roll Construction		
Continuous Chain Construction		
Live Shaft Construction		
Chain Driven Live Roller Curves		
Transfers		
Accumulating Chain Driven Live Roller		
Diagrams:		
Roll-to-Roll Construction		
Continuous Chain Construction		
Transfer Selection Data		
TECHNICAL DATA	3	9
Chain Pull and Horsepower Calculations		
Table I Combined Friction Factor		
Table II Factor For Determining Value "Q"		
Table III Minimum Sprocket Teeth per Roller Diameter		
Table IV Minimum Roller Centers		

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**Note - CEMA Has Reaffirmed the 2003 Edition.
This 2009 Edition is Identical to the 2003 Edition**

SUMMARY OF CHANGES IN 2003 EDITION

A summary of the major changes in this edition:

All drawings have been cleaned up and enhanced for clarity where necessary.

Foreword:

Updated to include Safety Label Requirements Notice.

Section 1: Definitions

Terms and Definitions have been expanded, regrouped for ease of understanding, and revised to conform with those in ANSI/CEMA Standard No. 102, *Conveyor Terms and Definitions*.

Section 2: Application

Figures have been redrawn and, in some cases, regrouped for clarity.

Section 3: Technical Data

No changes

**CEMA Standard No. 404-2009 (PDF)
Reviewed by
Unit Handling Section
of the
CEMA Engineering Conference**