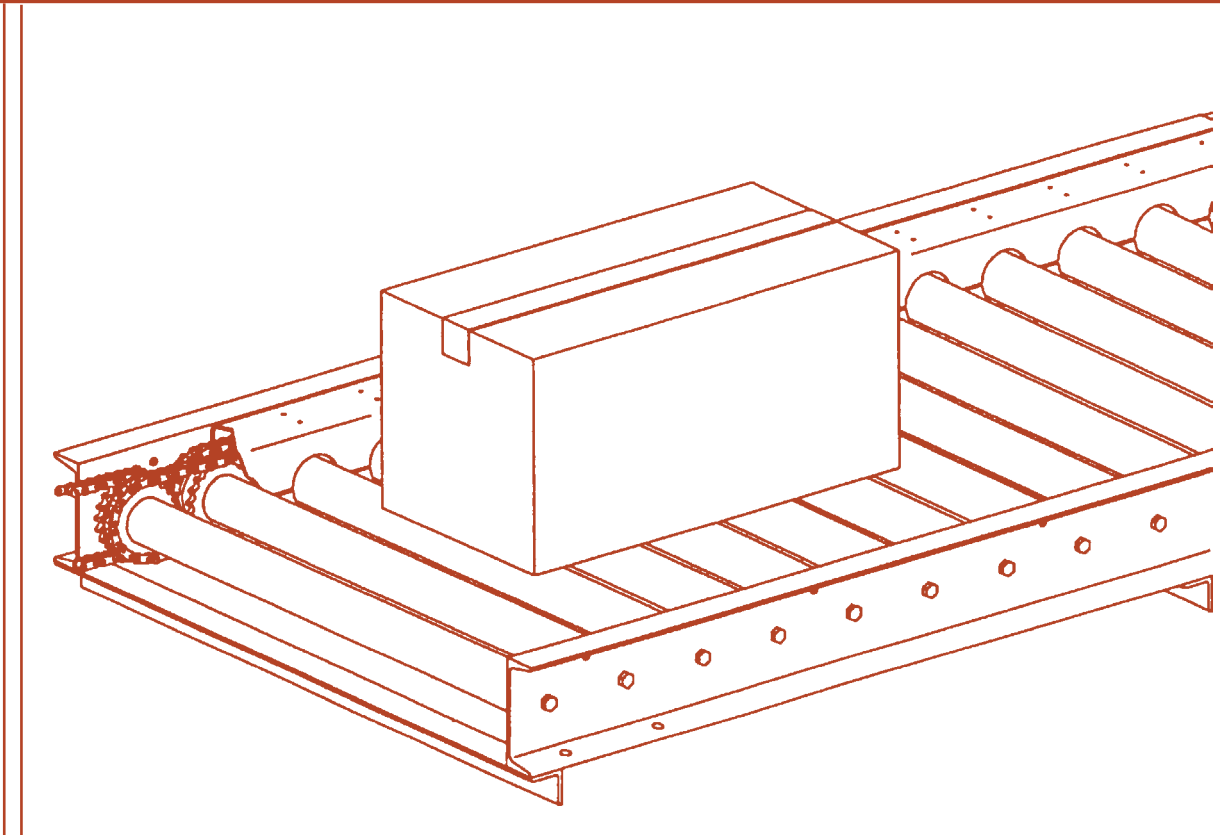


# CEMA STANDARD NO. 404-2003



ANSI / CEMA 404-2003 (R2015)  
Reaffirmation of ANSI / CEMA 404-2003  
( Approved January, 2015)

## CHAIN DRIVEN LIVE ROLLER CONVEYORS



### Unit Handling Conveyors



Conveyor Equipment  
Manufacturers Association

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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: ANSI/CEMA Standard No. 401, Roller Conveyors-Non Powered; ANSI/CEMA Standard No. 402, Belt Conveyors; ANSI/CEMA Standard No. 403, Belt Driven Live Roller Conveyors; and ANSI/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 Lock-out/Tag-out of Energy Sources - Minimum Safety Requirements; Title 29, Code of Federal Regulations (29 C.F.R.) Part 1910.147, the control of hazardous energy (lock-out/tag-out); Title 29, Code of Federal Regulations (29 C.F.R.) Part 1910 Subpart O, Machinery and Machine Guarding. Consult ASME or ANSI for the latest editions.

In 2003 Edition, include Safety Label Requirements Notice here, 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. On section 2, Figures have been redrawn and, in some cases, regrouped for clarity.

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