

## Rexnord® TableTop® and MatTop® Chains



## Rexnord Roller Upgrade System

REXNORD® FLATTOP



## **Rexnord Industries, LLC**

For more than one hundred years, Rexnord has provided superior power transmission, bearing, aerospace and specialty components to industry across the globe. We pride ourselves in commitment and dedication to the customer – from development to manufacturing, from installation to service.

This commitment and dedication are the centerpieces as Rexnord Industries begins our next century of growth. We are taking on new challenges and opportunities with a fresh look on the future.

**Precision. Power. Performance.<sup>SM</sup>**

It's more than a new slogan, it's a promise – the Rexnord promise.

## **FlatTop Global's Vision**

To be the best in the world at continuously improving customers' productivity through superior material handling solutions.

## **Rexnord Industries, LLC Mission**

To be a leading marketer and world class manufacturer of precision motion technology products & systems and provide superior growth and command sustainable competitive advantage.

## CONTENTS

4	INTRODUCTION
5	SAFETY CONSIDERATIONS
6	COMPONENT REFERENCE PICTURES
10	INSTALLATION
27	MAINTENANCE / TROUBLESHOOTING

# INTRODUCTION

This Rexnord® Roller Upgrade System will bring two important benefits:

- It will convey products much more smoothly and with less damage.
- It will be much easier to maintain than the current powered rollers or belts.

During the installation, you will re-establish a smooth, level conveying surface that may have been lost due to worn rollers, belts or bearings. The original conveying height, defined as the height of the top of rollers or belt, will also be reset to its original location. The result is that your products and packages will be conveyed smoothly and efficiently, reducing product damage.

What's more, this system will save you time and headaches by eliminating the problems associated with powered roller and belt conveyors, such as belt slippage, tracking problems, wandering or fraying, o-ring replacement, and take-ups and their associated maintenance. The low-friction modular chain will provide smooth, quiet and safe high speed case conveying with minimal downtime.

This installation procedure is broken up into three steps:

1. Removing the old rollers and belts
2. Installing the shaft support modules and support brackets
3. Installing wearstrips, chain and drive

## SAFETY CONSIDERATIONS

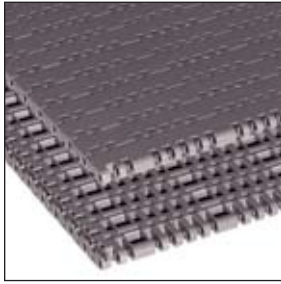
**PRODUCT SAFETY:** Products designed and manufactured by Rexnord are capable of being used in a safe manner; but Rexnord cannot warrant their safety under all circumstances.

**PURCHASER MUST INSTALL AND USE THE PRODUCTS IN SAFE AND LAWFUL MANNER IN COMPLIANCE WITH APPLICABLE HEALTH AND SAFETY REGULATIONS AND LAWS AND GENERAL STANDARDS OF REASONABLE CARE; AND IF PURCHASER FAILS TO DO SO, PURCHASER SHALL INDEMNIFY REXNORD FROM ANY LOSS, COST OR EXPENSE RESULTING DIRECTLY OR INDIRECTLY FROM SUCH FAILURE.**

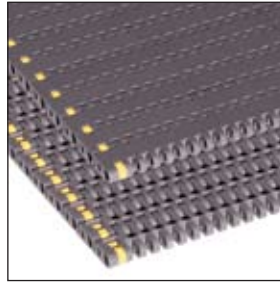
**SAFETY DEVICES:** Products are provided with only safety devices identified herein. **IT IS THE RESPONSIBILITY OF PURCHASER TO FURNISH APPROPRIATE GUARDS FOR MACHINERY PARTS** in compliance with **MSHA** or **OSHA** Standards, as well as any other safety devices desired by Purchaser and/or required by law; and **IF PURCHASER FAILS TO DO SO, PURCHASER SHALL INDEMNIFY REXNORD FROM ANY LOSS, COST OR EXPENSE RESULTING DIRECTLY OR INDIRECTLY FROM SUCH FAILURE.**

## COMPONENT REFERENCE PICTURES

**Straight running chains for general transport or light accumulation.**

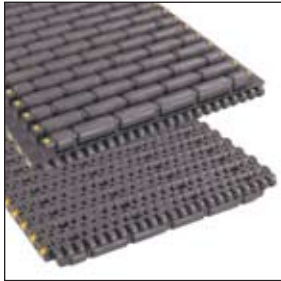


Rexnord® HP7705  
MatTop® Chain



Rexnord HP8505  
MatTop Chain

**Straight running chain for accumulation.**



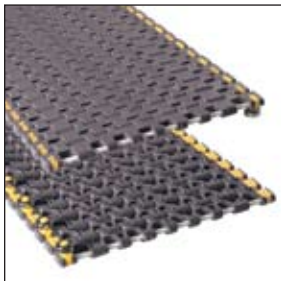
Rexnord HPLBP7703  
MatTop Chain

**Straight running chains for inclines and declines.**

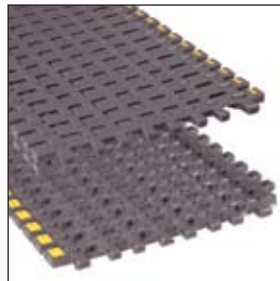


Rexnord 7705  
RubberTop™  
MatTop Chain

**Side-flexing chains for general transport or light accumulation.**



Rexnord HP7956B  
MatTop Chain



Rexnord® HP7956GT  
MatTop® Chain



Rexnord HP882TAB  
TableTop Chain

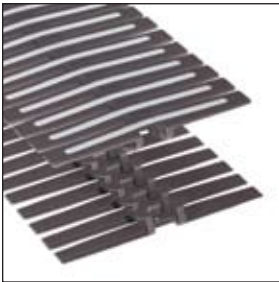
## COMPONENT REFERENCE PICTURES

### Rexnord® Sideflexing TableTop® chain for accumulation



Rexnord® LFLBP883TAB  
TableTop® Chain

### Rexnord Sideflexing TableTop chain for inclines and declines



Rexnord HPM882TAB  
TableTop Chain

### Rexnord Sprocket

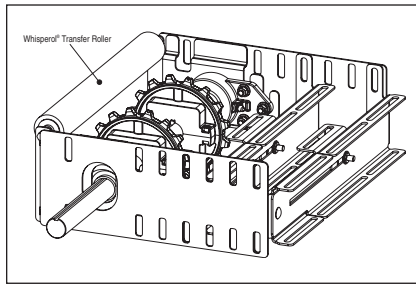


### Rexnord Support Brackets

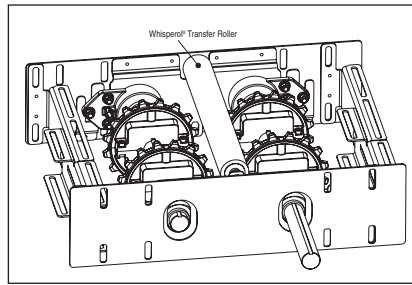


# COMPONENT REFERENCE PICTURES

## Shaft Support Modules



End shaft Support Module with Transfer Rollers - Drive or Idler



End shaft Support Module with Transfer Rollers - Tandem

## Extruded Wearstrip and Chain Guide Components



Edge Guide  
For use with:

- 7705
- 8505
- LBP7703
- TCF7705
- HTF7705



Center Wearstrip  
For use with:

- 7705
- 8505
- LBP7703
- TCF7705
- HTF7705



Return Guide  
For use with:

- 7705
- 8505
- LBP7703
- TCF7705
- HTF7705
- 7956GT
- 7956B



Curved Guide/Wearstrip  
For use with:

- 7956GT
- 7956B



Straight Chain Guide  
For use with:

- 7956GT
- 7956B



Chain Guide Connector



# COMPONENT REFERENCE PICTURES

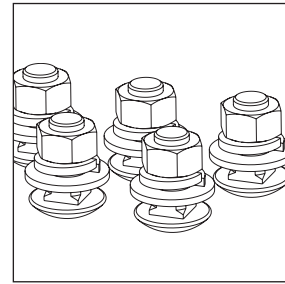
## Extruded Wearstrip and Chain Guide Components



Rexnord MatTop Return Shoe Assembly



Rexnord TableTop Return Shoe



Hardware

## Machined Corner Tracks



882 Straight Track

For use with:

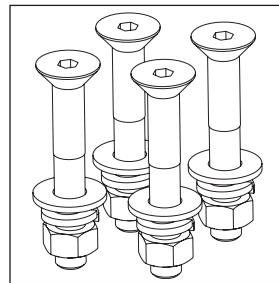
- 882TAB
- HPM882TAB
- LBP883TAB



882 Corner Track

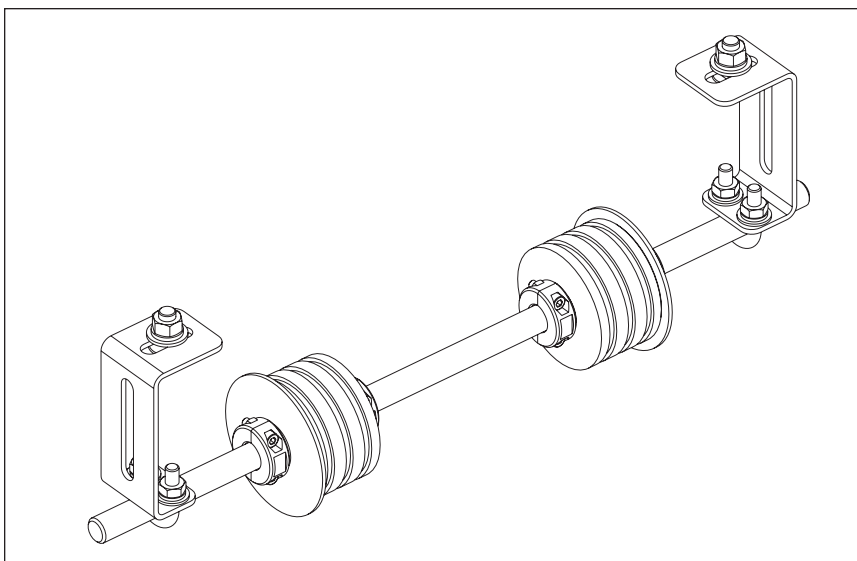
For use with:

- 882TAB
- HPM882TAB
- LBP883TAB



Corner Track Hardware

## Return Roller Assembly



Optional with:

- 7705
- 8505
- TCF7705
- HTF7705

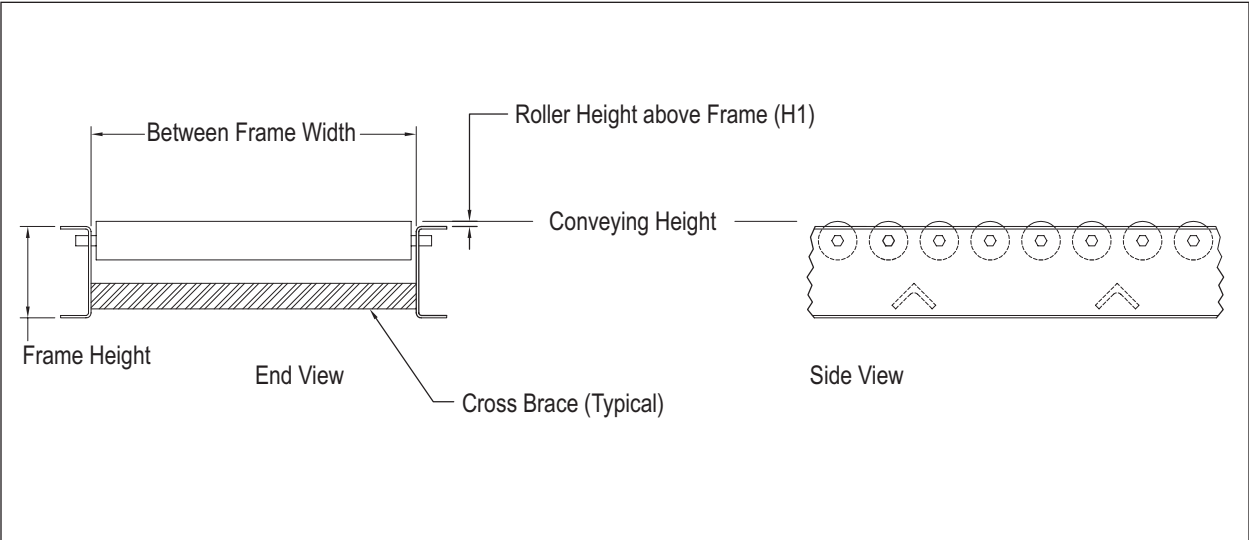
# INSTALLATION

## 1. Remove old rollers and belts

### 1.1 Measure and document the existing conveying height

- Measure the distance from the top of the rollers to the top of the conveyor frame. Typically, the conveying height is ¼ inch above the top of the frame, but it can be farther above or below the top of the frame. Record this dimension.

Roller Height above frame, H1: \_\_\_\_\_



**Tip:** If the conveying height varies, take an average.

- H is the distance from the top of the support bracket to the top of the chain. H2 is the distance from the top of the frame to the top of the support brackets.
- Subtract H1 from H to determine H2. Record this dimension in the table.

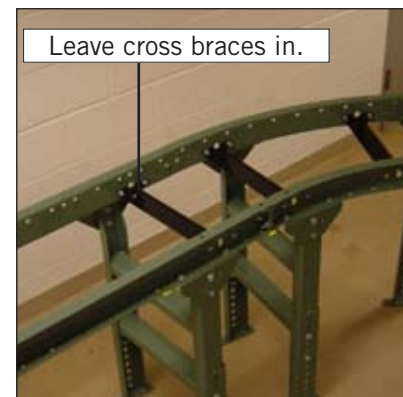
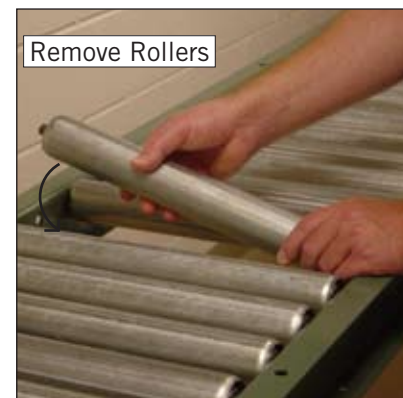
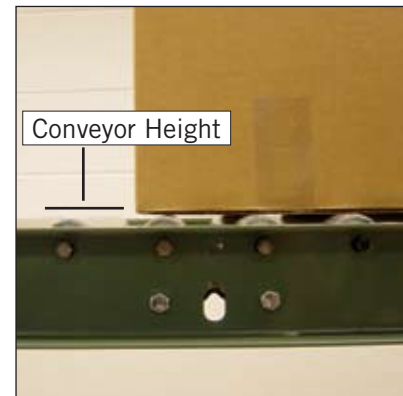
Chain	H (inches)	H2 = H - H1 (inches)
7705	1.075	
TCF7705, HTF7705	1.263	
LBP7703	1.775	
8505	0.919	
7956B, 7956GT	1.302	
882	1.565	
HPM882	1.664	
LBP883	2.125	

# INSTALLATION

## 1.2 Remove old rollers, belts, drive belts, drive drums, idler drums and drives

**Tip:** Do not remove any of the conveyor frame cross braces

- If separate guide rails are currently in place for guiding the product, it must not be necessary to remove them.
- All that should remain at this time are the two side frames, cross braces, and guide rails (if being used).
- If desired, clean or vacuum the conveyor at this time.



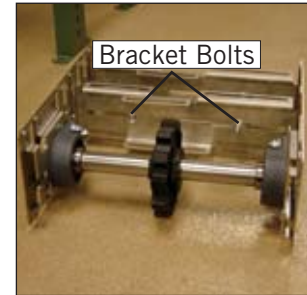
# INSTALLATION

## 2. Install shaft support modules and support brackets

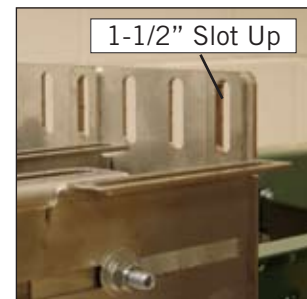
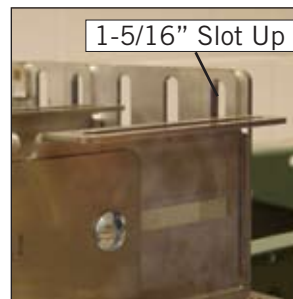
### 2.1 Install the idler shaft support module.

- Starting at the infeed end of the first conveyor farthest upstream, install the idler shaft support module. The shaft support module comes preassembled with the shaft, sprockets and bearings and should already be adjusted to the nominal between-frame width of your conveyor.

**Tip:** You may loosen the bracket bolts and bearing set screws, if necessary to adjust the width of the support module to your exact frame width.



- The shaft support modules are designed to mount with either the short slot up or the long slot up, depending on which chain is being used. Be sure to mount the module with the proper side up. See table and photos.



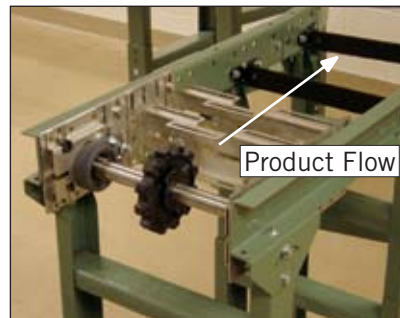
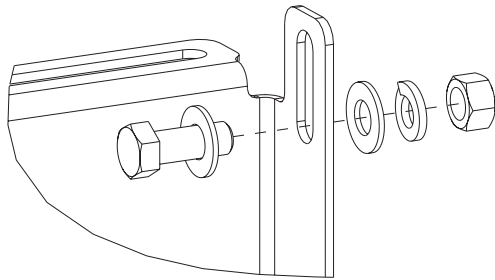
Rexnord TableTop & MatTop Chain	1-5/16" Slot Up	1-1/2" Slot Up
7705, TCF7705, HTF7705	X	
LBP7703		X
8505	X	
7956B, 7956GT	X	
882, HPM882		X
LBP883		X



- Place the end of the idler shaft support module flush with the end of the conveyor.

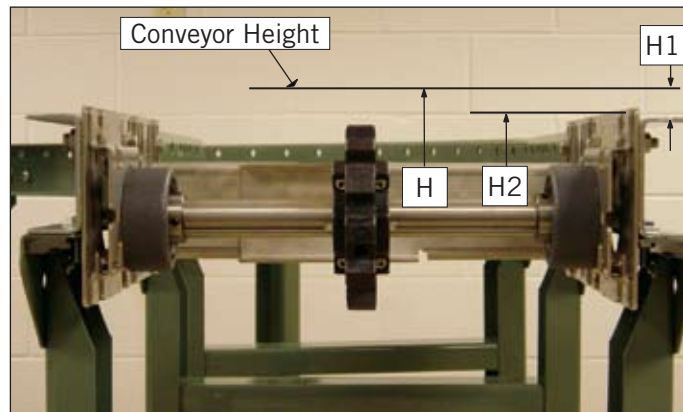
# INSTALLATION

- Mounting bolts (included) are only required in the upper set of slots. Insert bolts, washers and nuts and tighten bolts just enough to hold module in place, but do not tighten at this time. The bolts go through the existing hex shaped roller-mounting holes.



Loosely bolted idler shaft support module

- The vertical position of the shaft support module should be adjusted to maintain the original conveying height.
- H is the distance from the top of the support bracket to the top of the chain (see table below).
- Subtract H1 (determined in step 1.1) from H to determine H2. H2 is the distance from the top of the frame to the top of the support brackets.
- Use this dimension to adjust the height of the shaft support module, and tighten the bolts.

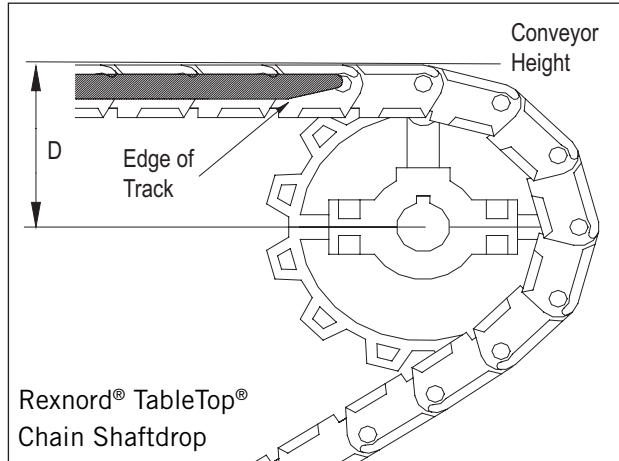
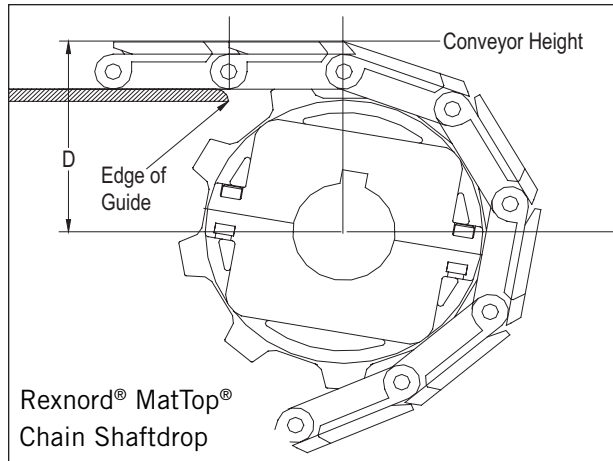


**Tip:** A combination square is helpful for setting the height (see photo below).



# INSTALLATION

As an additional reference, the distance from the centerline of the shaft to the top of the chain (or conveying height) is shown in the drawings and table below. This dimension is referred to as the “D” dimension.

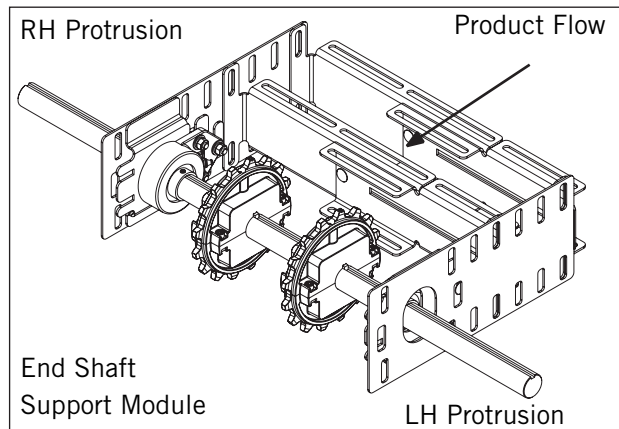
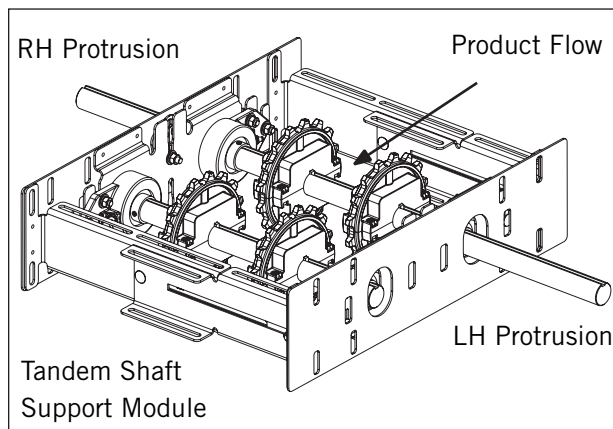


Shaft Drop Dimensions			
Rexnord Chain	Sprocket used		D (inches)
	No. of teeth	Pitch Diameter (in.)	
7705	18	5.759	3.129
TCF7705, HTF7705	18	5.759	3.317
LBP7703	16	5.126	3.603
8505	25	6.040	3.192
7956B, 7956GT	16	6.407	3.454
882	12	5.796	3.273
HPM882	12	5.796	3.372
LBP883	11	5.325	3.600

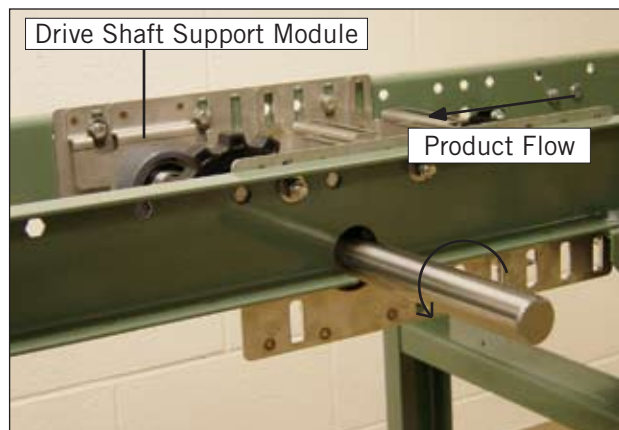
# INSTALLATION

## 2.2 Install the drive shaft support module or tandem shaft support module.

- Move downstream to the location where the first conveyor will end, or where the first drive will be situated, to install the drive shaft support module or tandem shaft support module.
- Drive shaft support modules use only a drive shaft.
- Tandem shaft support modules use a drive shaft and an idler shaft in the same assembly for simplifying installation on multiple drive conveyor lines.
- On either unit, the drive shaft will protrude out the right side, or the left side, depending on the specification on your order (see orientation drawings below for how to distinguish between LH and RH).



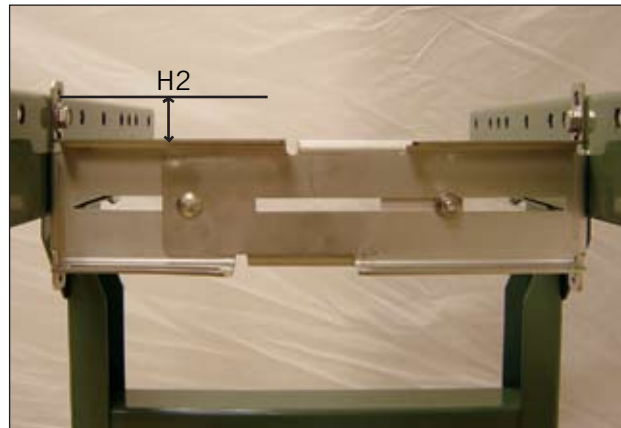
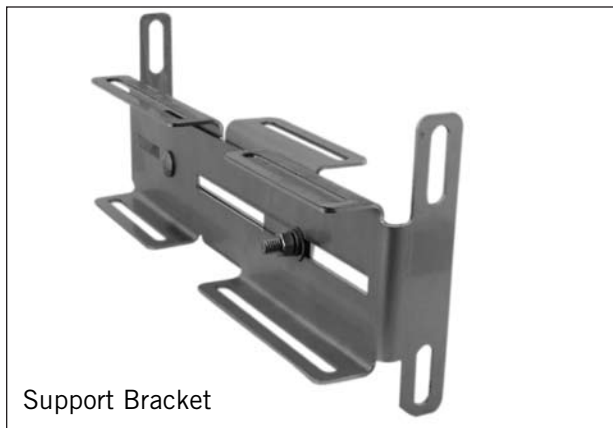
- The drive and tandem shaft support modules come preassembled with the shaft(s), sprockets and bearings and should already be adjusted to the nominal between frame width of your conveyor. Mount with proper side up using the same orientation as the idler shaft support module in step 2.1. (p. 12)
- The drive shaft support modules and tandem shaft support modules are installed in the same manner as the idler shaft support modules in step 2.1, with the exception that a clearance hole or slot will have to be cut into the conveyor frame for the drive shaft to protrude through.
- Cut the slot in order to best preserve structural integrity. Reinforcement may have to be added.



# INSTALLATION

## 2.3 Install the Support Brackets

- The support brackets are the foundation structure for the wearstrips, chain and product. They are spaced every two feet, but this can be adjusted as necessary to avoid existing conveyor frame cross braces or other structures.
- Like the shaft support modules, the support brackets are designed to mount either with the short slot up, or the long slot up depending on which chain is being used. Mount them with the same side up as the shaft support modules. See page 12.
- Mounting bolts are only required in the upper set of slots. Insert bolts, washers and nuts, and tighten bolts just enough to hold bracket in place. The bolts go through the existing hex shaped roller mounting holes.



- The vertical position of the support brackets should be adjusted so that you maintain your original conveying height. Use the same H2 dimension determined in step 2.1 to set the height of the support brackets. See page 13.
- After bolting the brackets in place, tighten the carriage bolts that connect the halves together. Ensure that the top of the bracket is horizontal.



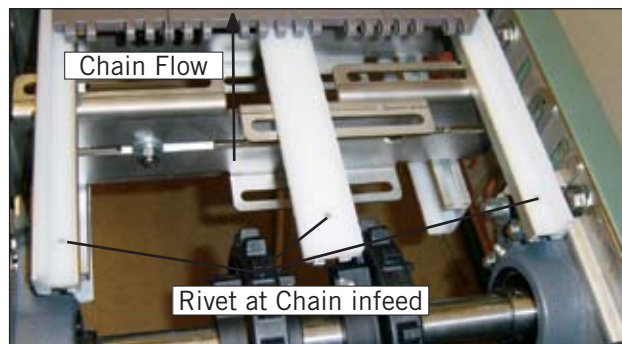
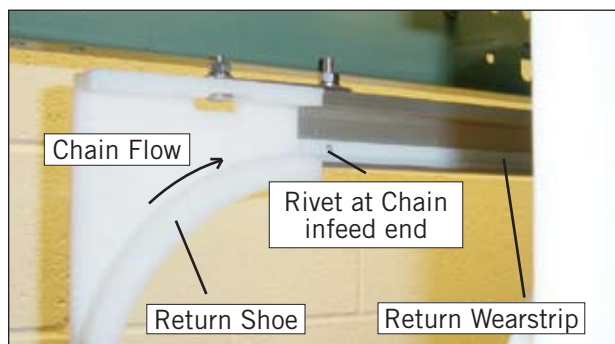
# INSTALLATION

## 3. Install wearstrips and chain

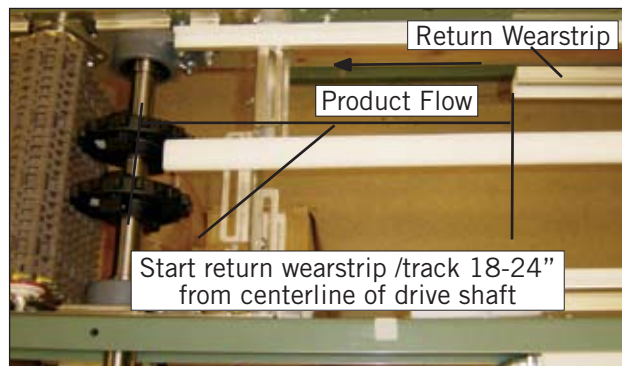
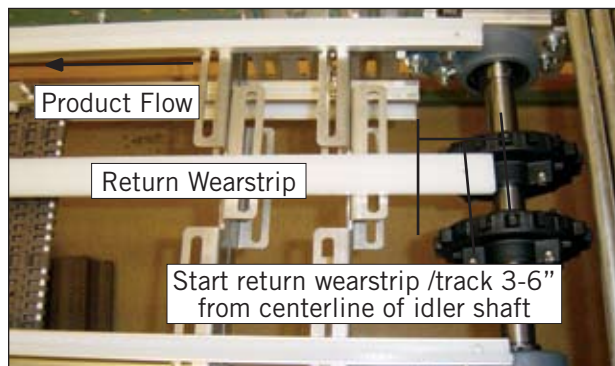
### 3.1. Return Guides and Shoes, Return Tracks and Shoes, or return rollers

#### 3.1.A. Return guides and shoes for Rexnord® MatTop® chains

- Rexnord MatTop chains (7956, 7700, 8505) use aluminum guides with UHMWPE wearstrips.
- All wearstrips come riveted at one end only. The rivets should be placed at the upstream end with regards to chain flow. This allows for thermal expansion or contraction of the UHMWPE.
- Starting at the drive end of your first conveyor, Orient the wearstrips with riveted end towards the chain infeed (drive) end (see photos).
- The wearstrips are installed with standard 5/16-18 carriage bolts, flat washers, lock washers and nuts which are included with the system (hardware pack no. 614-599-1).



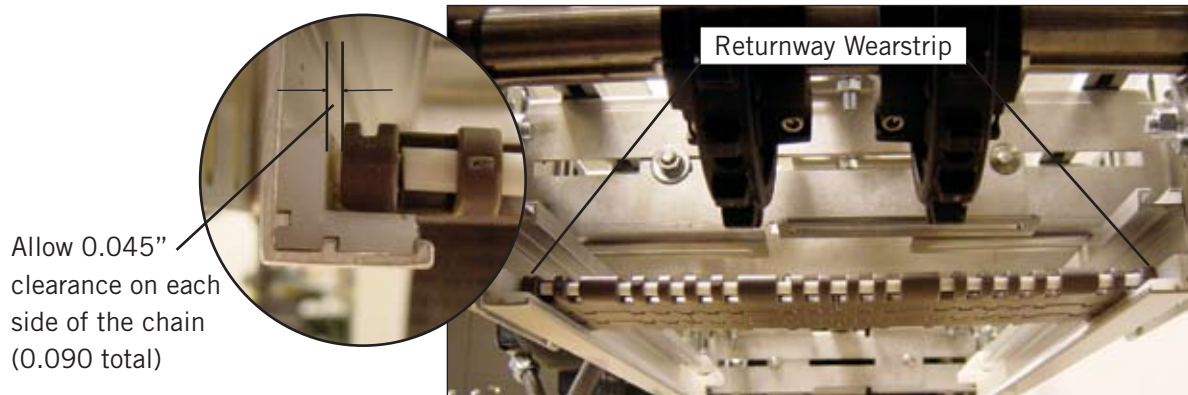
- Only two return guides are required to support the chain - one on each side (see photo below).
- Insert the carriage bolts into the slots on the guides and bolt them loosely onto the undersides of the support brackets.
- All wearstrips must be installed the correct distance from the idler and drive shafts. Return guides should start 18" to 24" from the shaft on the drive end, and end 3" to 6" from the shaft on the idler end.



- Place short section of chain onto the sprockets to line up the return guides with the sprockets.
- Determine that the guides are parallel to the conveyor frame, and that there is the proper clearance between for the chain all the way down. It is helpful to use a short section of chain (about 1 foot long) and slide it through the chain guides as you move down the conveyor to ensure free movement of the chain. See photos below for recommended clearance.

## INSTALLATION

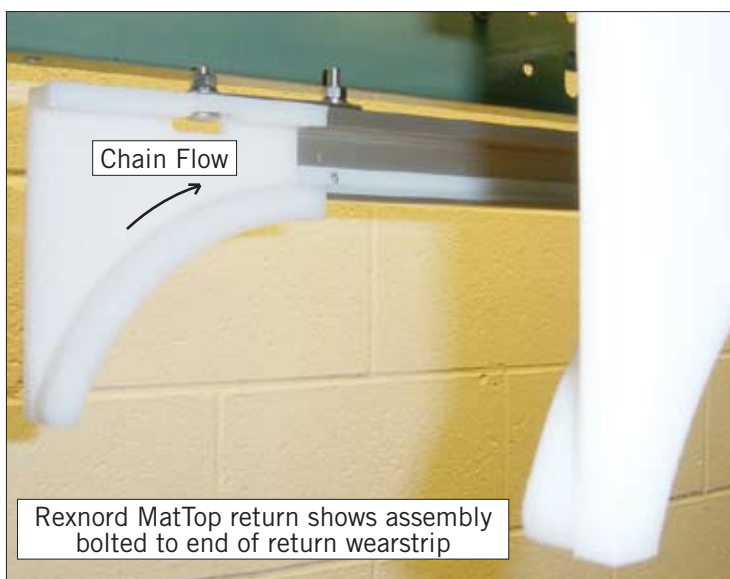
- Cut guides to length if necessary, and bolt down. When cutting the wearstrips, cut off the end without the rivet and use the piece with the rivet. You may add a rivet to any cut sections of wearstrip that do not have a rivet. Place the rivet about one inch from the infeed end of the wearstrip.



- Use chain guide connectors (see page 8) to connect the chain guides end to end and ensure their alignment.
- Using a utility knife, chamfer the ends of the wearstrips at the idler end and drive end where the return shoes will be mounted. It is not necessary to chamfer wearstrips that join end to end.
- Return guides for curves are shipped pre-bent and are installed in the same manner as the straight wearstrips. There is an inner corner (smaller radius) and an outer corner (larger radius).
- Ensure that the Rexnord 7956 chain guide, on the inner radius, is installed in a smooth curve.

### Install return shoes.

- Slide the UHMWPE shoes onto ends of the return guides, with carriage bolts going into slots. Ensure that the shoes are seated and the the chain has the proper clearance. Tighten the bolts.

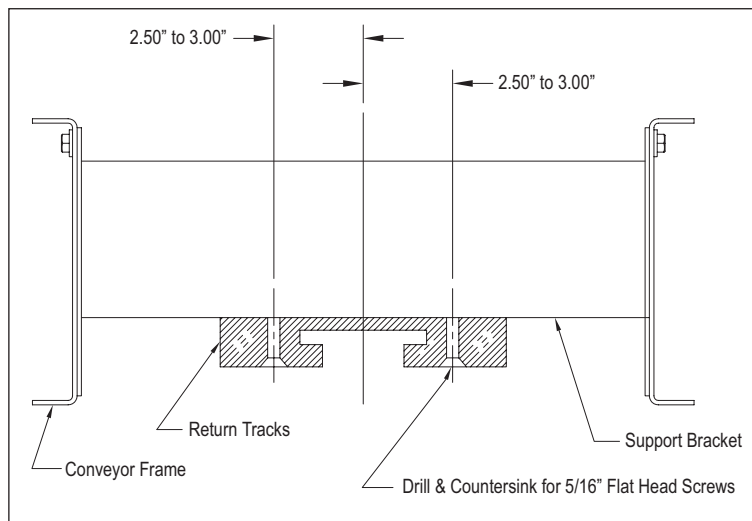
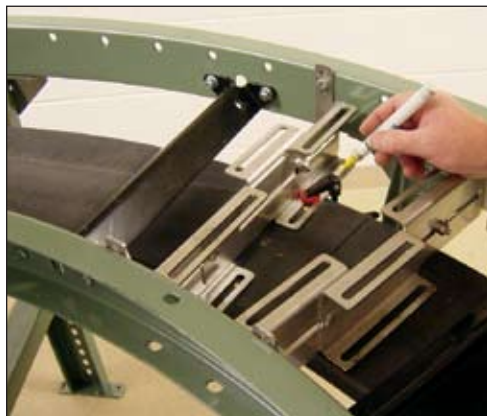


# INSTALLATION

## 3.1.B. Return tracks and shoes for Rexnord® TableTop® chains

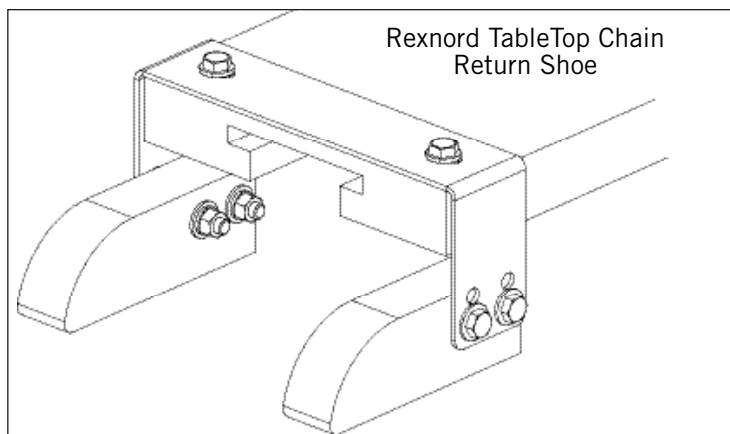
- Rexnord TableTop chains (882, HPM882 and LBP883) use solid, machined, UHMWPE tracks for the returnways (straights and corners). UHMWPE tracks are white. Black Nylatron® tracks may be used on the carry side.
- Begin with the corner tracks, then cut the straight tracks to fit.
- All tracks must be installed the correct distance from the idler and drive shafts. Return tracks should extend to 3" to 6" away from the shaft on the idler end, and 18" to 24" from the shaft on the drive end.
- Center the track between the conveyor frame.
- The tracks are installed with standard 5/16-18 x 2" flathead bolts, flat washers, lock washers and nuts which are included with your system (hardware pack no. 614-600-1). The tracks must be drilled and countersunk for the flathead bolts (see photos below).
- Two bolts are required at each support bracket.

**Tip:** Temporarily Clamp the tracks in place and mark where to drill the holes.



Mounting of Rexnord TableTop Chain Return Tracks

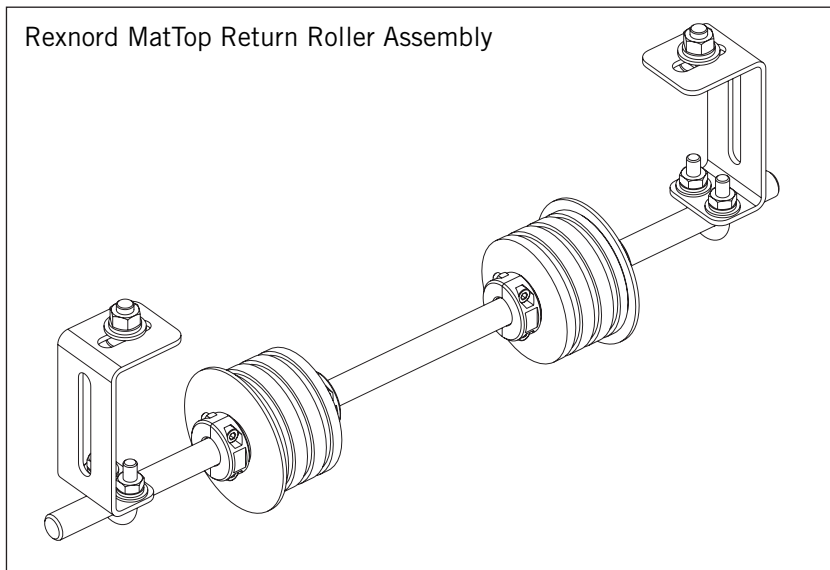
- TableTop return shoe bolts to top of return track, adjacent to the drive end.
- Center the bracket over the return track, with the edge of the bracket aligned with the end of the track.
- Drill two 9/32" holes and use the self-tapping screws provided.



# INSTALLATION

## 3.1.C Return Rollers

- As an alternative method for returning the Rexnord® MatTop® chains, return roller assemblies may be used in lieu of the return wearstrips. The return roller assembly can be bolted to the bottom of the support brackets, or to the inside walls of the conveyor.
- The return roller assemblies are typically spaced every 4 feet
- Be sure the rollers and shaft are centered between the conveyor frame.

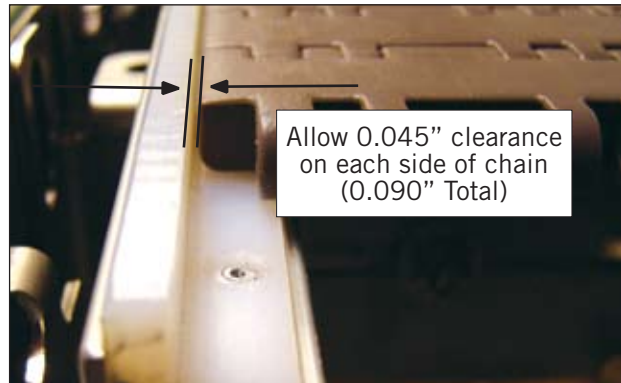
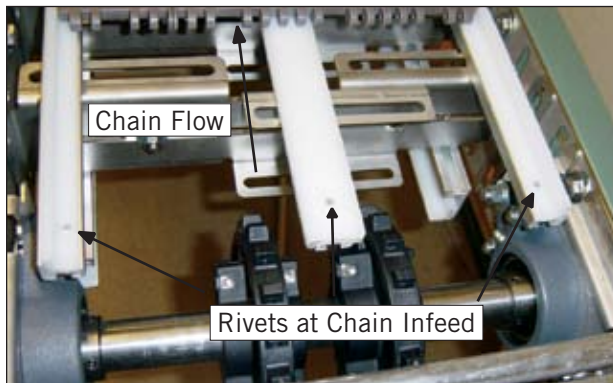


# INSTALLATION

## 3.2 Carry-side Chain Guides and Tracks

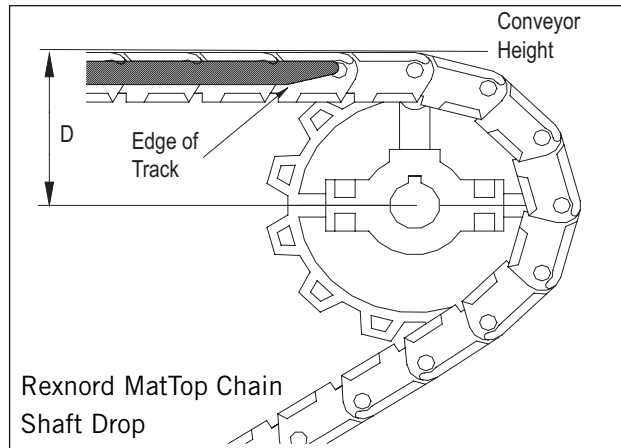
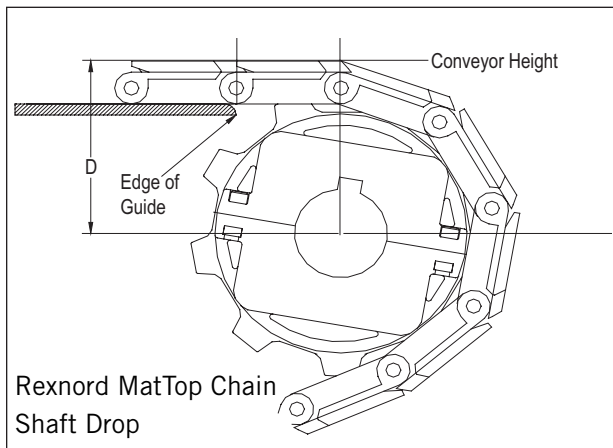
### 3.2.A. Carryway chain guides for Rexnord® MatTop® chains (7956, 7700, 8505)

- Rexnord MatTop chains (7956, 7700, 8505) use aluminum guides with UHMWPE wearstrips. All wear strips come riveted at one end only to allow for thermal expansion or contraction of the UHMWPE.
- Starting at the idler end of your first conveyor, orient the wearstrips with rivet at the chain infeed end (see photos below).



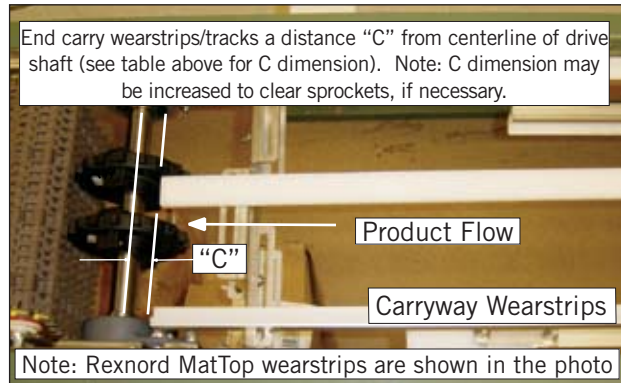
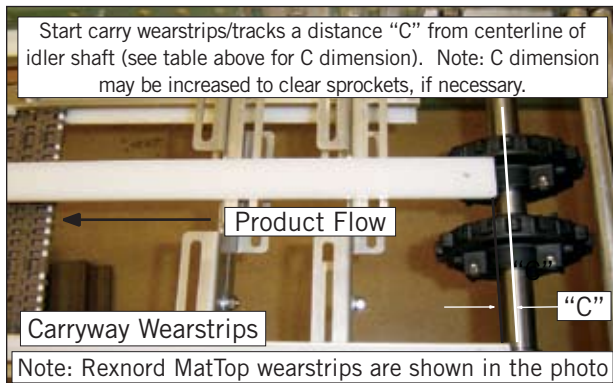
- The chain guides and wearstrips are installed with standard 5/16-18 x 3/4" carriage bolts, flat washers, lock washers and nuts which are included with your system (hardware pack no. 614-599-1).
- Insert the carriage bolts into the slots on the guides and bolt them loosely onto the support brackets.
- All carryway wearstrips/guides should be installed so that the distance from the end of the wearstrips/tracks to the centerline of the drive shafts and idler shafts is equal to one pitch of chain. This dimension is referred to as the "C" dimension. See table and drawings below.

Rexnord Chain	C (chain pitch)
7705, TCF7705, HTF7705, LBP7703	1"
8505	3/4"
7956B, 7956GT	1-1/4"
882, HPM882, LBP883	1-1/2"

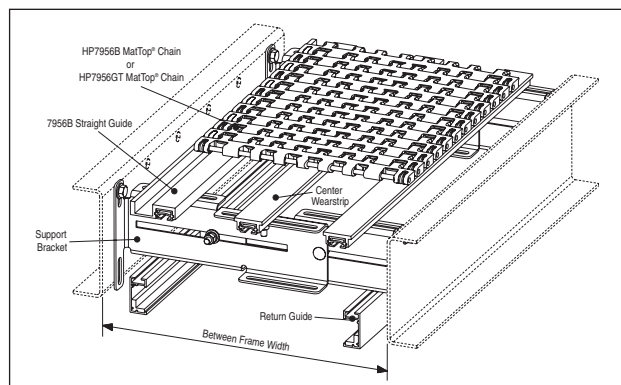
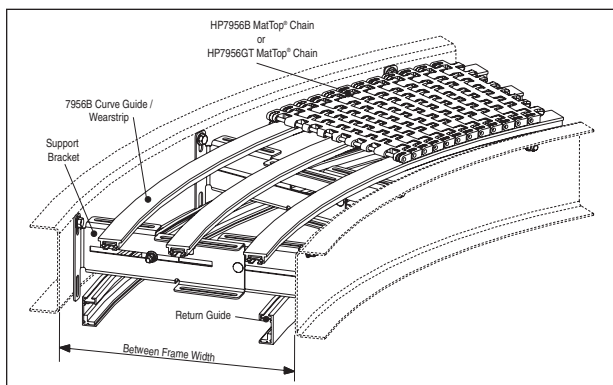


# INSTALLATION

- Place a short section of chain onto the sprockets to line up the return guides with the sprockets.
- Determine that the guides are parallel to the conveyor frame, and that there is the proper clearance for the chain all the way down. It is helpful to use a short section of chain (about 1 foot long) and slide it through the chain guides as you move down the conveyor to ensure free movement of the chain. 3/32" clearance overall is recommended (see photos).
- Cut guides to length if necessary, and bolt down. When cutting the wearstrips, cut off the end without the rivet and use the end with the rivet. You may add a rivet to any cut section of wearstrip that does not have a rivet. Place rivet about one inch from the infeed end of the wearstrip.

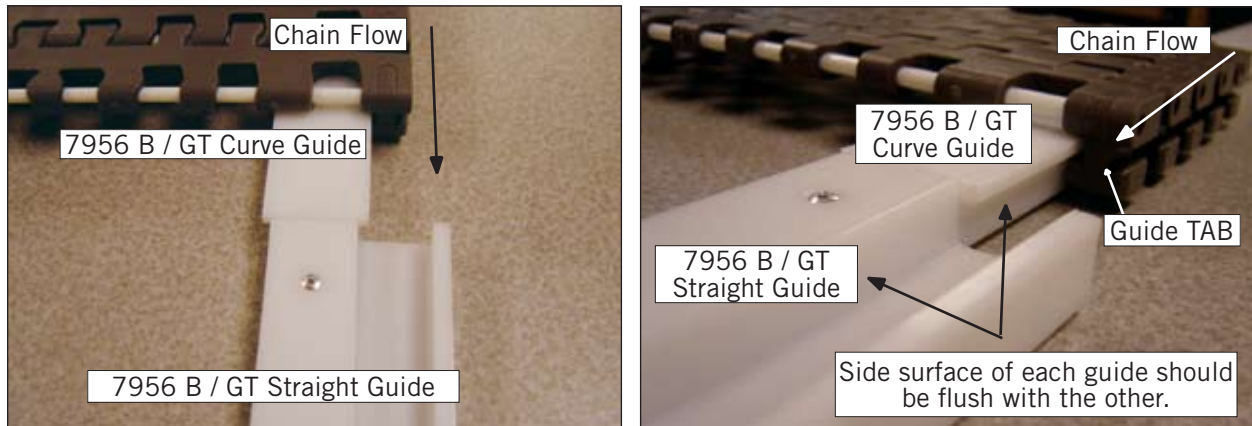


- Use chain guide connectors (see page 8) to connect the chain guides end to end and ensure their alignment.
- Using a utility knife, chamfer the ends of the wearstrips at the idler and drive ends. It is not necessary to chamfer wearstrips that join end to end.
- Corner wearstrips are shipped pre-curved and are installed in the same manner as the straight wearstrips.
- Rexnord sideflexing MatTop chains 7956B and 7956GT utilize a bearing (for 7956B) or a guide TAB (for 7956GT) to retain the chain in the corner. The bearing or guide tab is on the outer radius of the chain only, turning in one direction only (see drawing below). In cases where the chain turns in both directions, the bearings or guide tabs will be provided on both sides of the chain. The 7956B and 7956GT can be picked up out of the corner for cleaning and/or maintenance, by sliding it outwards and lifting up.
- Ensure that the chain guide on the outer radius is installed in a smooth curve.
- On 7956 conveyors that have sections of more than approximately 5 feet of straight before the corner, the 7956 straight chain guide is used to provide side-to-side tracking of the chain (see drawing below). The straight guide is only needed on one side of the chain – the side with the bearings or guide tabs.



# INSTALLATION

- On Rexnord 7956 MatTop chain conveyors that have straight guides, it is important that the curve guide and the straight guide are lined up properly to ensure smooth transition of the chain between the corners and the straights (see photos below). Use the chain guide connector (part no. 614-565-1) to align the guides.



- For Rexnord® MatTop® chains, see the tables below for number of support wearstrips required on the carryway side.

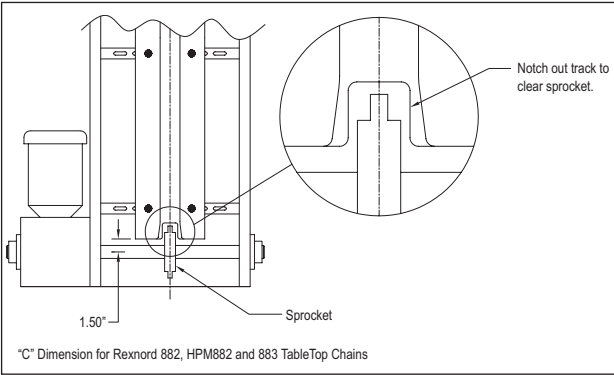
Rexnord 8500 and 7700 series MatTop chains	
Chain width (inches)	Center wearstrips required
6 to 14.9	1
15 to 17.9	2
18 to 23.9	3
24 to 29.9	4
30 to 35.9	5
36 to 42	6

Rexnord 7956 series MatTop chains	
Chain width (inches)	Total number of wearstrips/guides required
6	2
12	3
15	3
18	4
24	5
30	5

# INSTALLATION

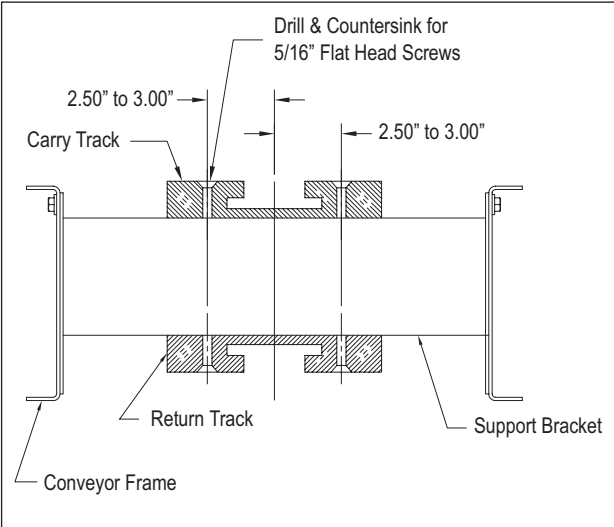
## 3.2.B. Carryway Tracks for Rexnord® TableTop® Chains (882, HPM882, LBP883)

- Rexnord® TableTop® chains (882, HPM882 and LBP883) use solid, machined, UHMWPE tracks for the carryway in the straights, and either UHMWPE or Nylatron® in the corners. UHMWPE corner tracks will be white, while Nylatron will be black.
- Begin with the corner tracks, then cut the straight tracks to fit.
- All tracks must be installed the correct distance from the idler and drive shafts. Carry tracks should extend to 1.50" away from the shaft on the idler end and on the drive end.
- Center the track between the conveyor frame rails.
- Using a deburring tool or utility knife, chamfer the ends of each track, including the corner tracks.
- The tracks must be notched out at the idler and drive ends to clear the sprocket and maintain the 1.50 inch C dimension.



- The tracks are installed with standard 5/16-18 x 2" flathead bolts, flat washers, lock washers and nuts which are included with your system (hardware pack no. 614-600-1). The tracks must be drilled and countersunk for the flathead bolts.
- Two bolts are required at each support bracket.

**Tip:** Clamp the tracks in place and premark where to drill the holes (see drawing below).





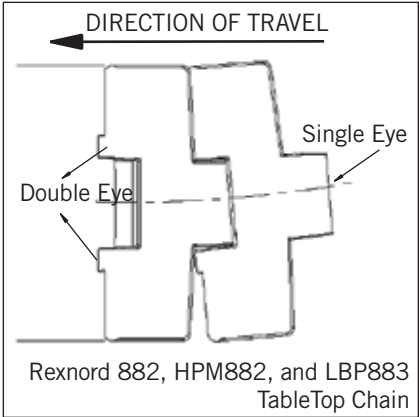
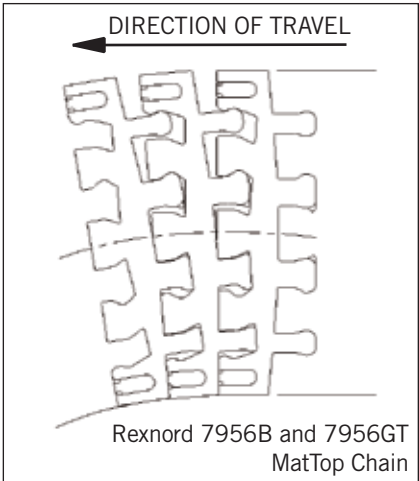
# INSTALLATION

## 3.3. Install the Chain

- The chain is typically shipped in ten-foot sections, but may be less for wide Rexnord® MatTop® chains.
- Before installing the chain, drag a short section of chain (about 1 foot long) through the entire carry and return way to double check that there are no tight spots or areas where adjoining wearstrips are not flush with each other, that the chain could catch on. Make any adjustments as required.
- Verify proper direction of chain travel before installing the chain (see table below).

Rexnord Chains	Direction of travel
7705	Either direction
TCF7705, HTF7705	Either direction
LBP7703	Either direction
8505	Either direction
7956B	Most eyes forward, with bearings to outside of turn (see drawing below)
7956GT	Most eyes forward, with GT TABs to outside of turn (see drawing below, or arrow on chain)
882	Double eye forward (see drawing below, or arrow on chain)
HPM882	Double eye forward (see drawing below, or arrow on chain)
LBP883	Double eye forward (see drawing below, or arrow on chain)

- For Rexnord TableTop or MatTop chains where the direction of travel can be either way, it is recommended that the chain be installed in the same direction on every conveyor.
- Install the chain sections into the conveyor, connecting each section as you go.
- Connect the ends of the chain together in the drive area.
- Add or remove links as necessary, in order to establish the proper catenary sag (see bottom of page 26).



# INSTALLATION

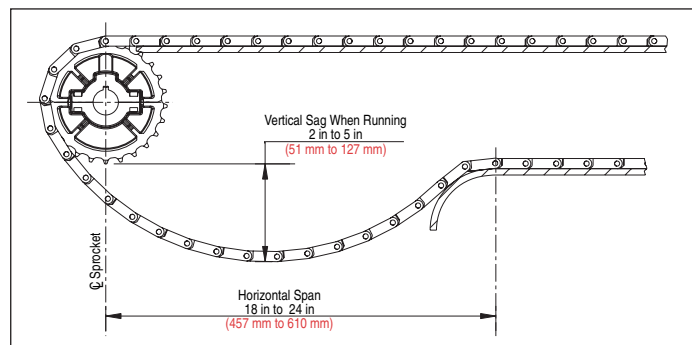
## Install reducer and motor.

**WARNING:** It is always recommended to follow manufacturers specifications and instruction when installing their products.

- If using a hollow output shaft reducer (recommended for the easiest installation, otherwise proceed to standard output shaft reducer below):
  - With the motor and reducer still on the floor or bench, mount the motor to the reducer (please follow the manufacturers recommending assembly procedure in the motor and reducer instructions)
  - Carefully slide the motor/reducer onto the drive shaft (please follow the manufacturers recommending assembly procedure in the reducer and coupling instructions)
  - Firmly secure the reducer to the conveyor frame using a torque arm or mounting bracket
- If using a standard output shaft reducer:
  - With the motor and reducer still on the floor or bench, mount the motor to the reducer (please follow the manufacturers recommending assembly procedure in the motor and reducer instructions)
  - Determine the best mounting method for the reducer to the frame.
    - Allow for adequate clearance for motor the drive chain, sprockets and guards.
    - Fabricate the necessary mounting platform or bracket(s) and secure the reducer to the conveyor frame.
    - Firmly secure the reducer/motor to the mounting bracket, or platform.
    - Install the sprockets and drive chain.
    - Fabricate and install guards.
- Run conduit and wiring to the motor.
- Jog the motor to verify proper drive shaft rotation.
- Test run each conveyor, first without product, then with product.
- After running the conveyor for several hours, adjust the catenary sag by adding or removing chain links as necessary.



Torque Arm



# MAINTENANCE

## 4. Maintenance

Congratulations, you are now ready to start enjoying the many benefits of your new Rexnord® Roller Upgrade System! If you have any questions, you may contact Rexnord Application Engineering:

Rexnord Application Engineering Phone: (262) 376-4800 Fax: (262) 376-4750

Rexnord Application Engineering E-mail: flattop.tech.support@rexnord.com

### 4.1. Periodic Checks

Your new Rexnord Roller Upgrade System requires very little attention. The table below provides suggested service checks and the interval at which they should be checked. Chain and sprockets should be replaced if one or more of the following occurs:

Suggested Service Checks			
Service check	Interval between checks		
	Monthly	Semi-annually	Annually
Clean conveyor of debris if necessary	X		
Check catenary sag, adjust as necessary (see p.24)	X		
Check chain for unusual grooves or wear		X	
Measure chain elongation (3% is max.)			X
Check for wear to link or top plate			X
Check for wear to thrust surface (sideflexing chains only)			X
Disconnect chain and check sprockets for wear			X

- Chain jumps sprocket teeth
- Sprocket teeth become worn away, causing chain to skip
- Sprocket teeth become hooked or chain hangs up on sprockets
- Link thickness wear causes product handling or transfer problems or thickness drops below limits listed in table below
- Link surface becomes uneven from wear (see Troubleshooting Guide)

Wearstrips and tracks should be replaced when worn, or if debris becomes embedded

To check chain elongation, measure a number of links of chain according to the table below, when the chain is taut. It is recommended to replace the chain and sprockets when chain elongation reaches 3%.

Rexnord Chain	No. of links	Length, new	Length at replacement
LBP7703, 7705, HTF7705, TCF7705	60	60"	61-7/8"
7956B, 7956GT	48	60"	61-7/8"
8505	80	60-1/2"	62-3/8"
882, HPM882, LBP883	40	60"	61-7/8"

Rexnord Chain	Thickness, new	Thickness, at replacement *	Thrust surface wear
LBP7703, 7705, HTF7705, TCF7705	0.50"	0.44"	n/a
7956B, 7956GT	0.50"	0.44"	Replace when GT attachment is worn though
8505	0.34"	0.31"	n/a
882*, HPM882*, LBP883*	0.19"	0.10"	Replace when pin ends are flush with chain thrust surface

\* Thickness of Rexnord 882 and 883 TableTop chains refer to top plate only. Thickness of other chains refers to the entire base link.

# TROUBLESHOOTING GUIDE

Symptom	Cause	Correction
Chain is jumping the sprockets	Chain stretched past 3%	Replace chain & sprockets
	Sprockets worn	
	Improper shaft position (wrong C or D dimension)	Adjust properly (see pp. 12, 19)
	Too much chain sag causing insufficient chain wrap	Adjust the catenary sag (see p.24)
Uneven wear pattern on the bottom of the chain	Wearstrips on the carryway side are not flush or level	Make the carryway wearstrips level and flush
	An obstruction in the carryway is cutting or scraping the chain	Locate the origin of the cutting and remove the obstruction
Uneven wear pattern on the top of the chain	Return roller(s) stuck	Locate stuck roller(s) and fix or replace
	An obstruction in the return guide or return shoe is cutting or scraping the chain	Locate the origin of the cutting and remove the obstruction
Chain pulsation	Very minor pulsations are normal	Do nothing
	Build-up of foreign material or a sticky residue on the wearstrips	Lift the chain from the track and clean wearstrips and chain if necessary
	Idler sprocket(s) seized up due to bad bearing or other	Replace bad bearing and make sure idler sprockets spin freely
	Inadequate guide clearance	Check guide clearance and adjust (see p.16)
	Return roller(s) stuck	Locate stuck roller(s) and fix or replace
	Improper catenary	Adjust the catenary sag (see p.24)

**NOTES**

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# NOTES

**NOTES**

# World Class Customer Service

For more than 100 years, the dedicated people of Rexnord have delivered excellence in quality and service to our customers around the globe. Rexnord is a trusted name when it comes to providing skillfully engineered products that improve productivity and efficiency for industrial applications worldwide. We are committed to exceeding customer expectations in every area of our business: product design, application engineering, operations, and customer service.

Because of our customer focus, we are able to thoroughly understand the needs of your business and have the resources available to work closely with you to reduce maintenance costs, eliminate redundant inventories and prevent equipment down time.

Rexnord represents the most comprehensive portfolio of power transmission and conveying components in the world with the brands you know and trust.

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