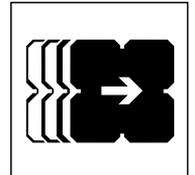


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Material and information flow technology

Maintenance of TS 2 Flat Top Chains

S2010-04 EN

After long-term testing and additional field tests on servicing flat top chains, we have determined that lubricating the flat top chains with Structovis BHD is not ideal.

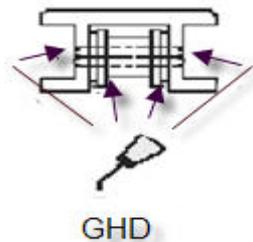
Reason: Increased abrasion and relative stiffness of the chain.

Therefore, we have removed the spray lubricant from the program and it should **not** be used any more.

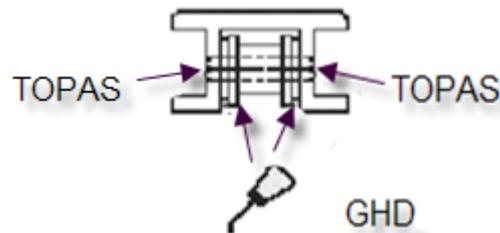
Beginning immediately, only Structovis GHD is to be used for standard flat top chains.

For ESD version flat top chains, we recommend lubricating with Topas NCA 52 on the lateral running surfaces.

Standard flat top chain (black)



ESD flat top chain (gray)



The **S2007-07** Service Information has been modified. This Service Information contains further details and is enclosed with this SIS.

Please observe this information in all future maintenance work.

Please pass this important information on to your maintenance personnel, as well as to your customers.

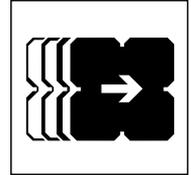
Enclosure: SIS S2007-07, modified

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Material and information flow technology

Information about Maintenance Intervals for Flat Top Chains

S2007-07 EN

Please note that chains from the **TS 2plus** and **TS 4plus** transfer systems should be lubricated and re-tensioned after a running time of **1000 hours** according to our assembly and operating instructions.

This applies for all units, in which accumulation roller chains and flat top chains are used as conveyor media.

Based on our field experience, we could determine that non-compliance with the maintenance intervals resulted in stiffer chains and stretched links. The first sign that the lubrication level is too low is stick-slip effect on the chain.

In the case of flat top chains, it appeared as overlapping of the chain clips in the return section of the drive unit, as you can see from the illustration. The clips are snapped off as a result.



We were also able to determine that the guide profiles were pulled into the return unit and the guide units in the curves were subject to very high abrasion.

Occasionally, this even led to motor failure due to excessive current consumption as a result of the overload caused by a lack of lubricant.

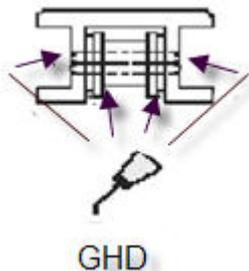
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In coordination with our chain vendor and the lubricant manufacturer, combined with our experience in the field, we have concluded the following:

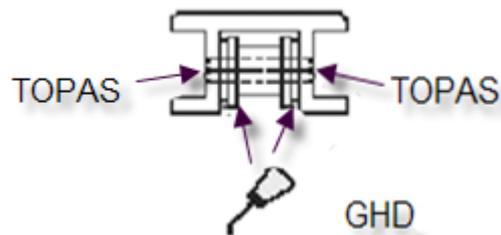
All flat top chains are delivered with an initial lubrication level. The chains must be lubricated again after no later than **1000 hours** of operation.

The flat top chain side plates are not lubricated prior to delivery. Initial lubrication of the lateral flat top chain side plates is imperative when using the chains in curves. The side plates must also be relubricated every **1000 hours**.

Standard flat top chain (black)



ESD flat top chain (gray)



Lubrication method: Lubricate the chain using a brush or a metered hand oiler. This is recommended in the area of the chain return in the drive unit.

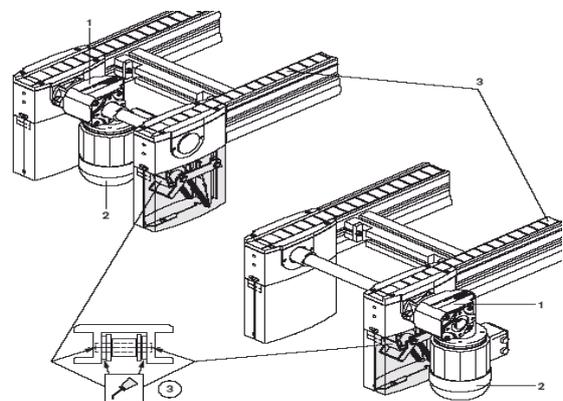
A few excerpts from the assembly instructions are provided here for clarification about the lubrication position and about re-tensioning the chain.

Excerpts from the assembly instructions

Flat top chains

The chains have been oiled on delivery. Afterwards, they should be lubricated every **1000** operating hours with approx. 2-3 g oil/m of chain.

Before lubricating, remove any unnecessary grease, dirt, or other contaminants from the surface and also check for wear and stretching.



Remove chain links once the chain tensioner end position has been reached - AS 2/C-400, AS 2/C-700 (Fig. 3)

This has happened when:

- The "X" tension lever is in the lowest position.
- An installed "Y" proximity switch EN 60947-5-2-I2A12 (fastened with a SH 2/UV switch

bracket, order no.: 3 842 168 600) has been activated by the "X" tension lever, switching off the controller.

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Remove chain links once the chain tensioner end position has been reached - AS 2/C-100, AS 2/C-250, BS 4/R

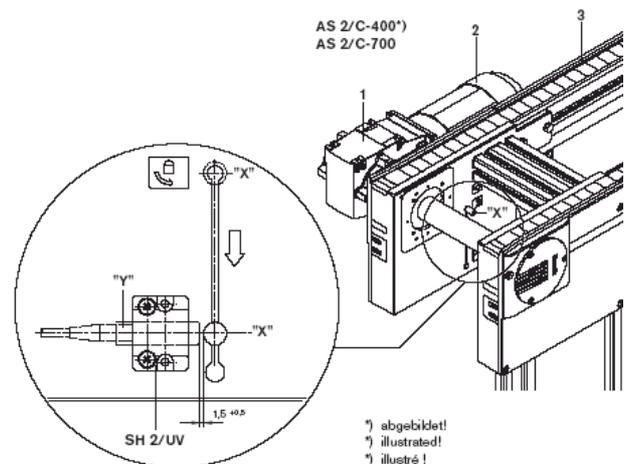
This has happened when:

- Tab "1" is visible in the monitoring bore area.
- An installed "X" proximity switch has been activated by tab "2", switching off the controller.

Note:

The EN 60947-5-2-I2A12 proximity switch and SH 2/UV switch bracket, order no.: 3 842 168 600 are not a part of the scope of the delivery and must be ordered separately.

The drive wheels and chain should always be replaced once the chain has stretched by more than 3% of its original length.



Lubricants:

Structovis GHD, for steel parts and flat top chain parts (standard)

Part no. 0 842 904 229,

Use 0.5 l for a chain length of 50 m per maintenance cycle

Advantages of Structovis GHD:

Good abrasion protection	→	Increases the service life of your chain and thereby reduces the costs of purchasing replacement parts
Shear thinning lubricant	→	Good creep characteristics (shear thinning is the characteristic of a fluid that shows low viscosity at high shear forces)
Good corrosion protection	→	Optimal maintenance intervals
Hydro-capillary effect	→	Flows under water

Structovis GHD, for standard chains and steel parts of the ESD chain

DCL SIS (Sales Information Service)

ISOFLEX TOPAS NCA52, only for ESD flat top chain parts (gray)

Part no. 3 842 542 314,

Use 400 grams for a chain length of approx. 200 m per maintenance cycle

Advantages of Topas NCA52, high performance grease

Good abrasion protection	→	Increases the service life of your chain and thereby reduces the costs of purchasing replacement parts
Good adhesion	→	Suitable for high surface pressure, also in combination with plastics Good surface adhesion Very good material penetration between friction partners
Temperature resistant	→	Up to +150°C

Please pass this important information on to your maintenance personnel, as well as to your customers.