



Tubular Drag Conveyors

Cableflow® cable or Dynaflow® chain driven for dry bulk solids and ingredients across all industries

Tubular Drag Conveyors

What are they?

They are mechanically driven conveyors that 'drag' material along the inside of a tube. They are designed to transfer finely and not so finely divided, flowable bulk materials from in-feed points to discharge points through a totally enclosed conduit. They are positive displacement devices using close-running discs connected by a cable or metal links. They have been used successfully throughout a range of industries for over fifty years.

How do they work?

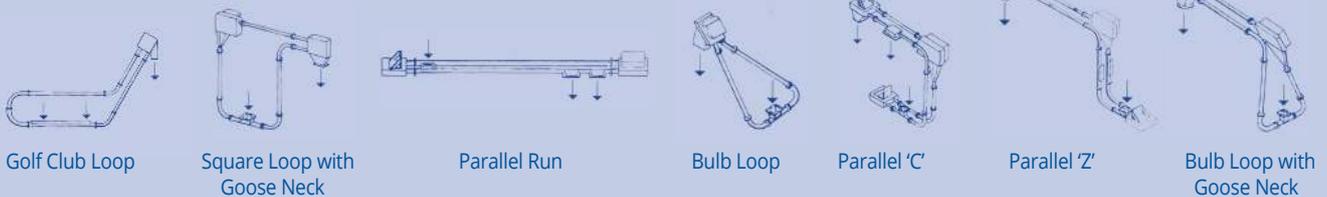
A cable or chain with discs spaced along its length and its ends connected to each other to form an endless loop is pulled by a motor driven sprocket within an enclosed tube. Changes in direction are facilitated by bends in the tubing or by corner housings for tighter radii. Discharge of the product is through 'outlet boxes'. Cable or chain and casing are routed back to in-feed point in an endless loop.

Installation

By nature, the tubular conveyor absorbs all the reactions to its own conveying forces internally. The forces are transferred by compression of the flanged casing sections. As a result, the only external supports required are those necessary to support the weight of the conveyor and load of product being conveyed. If desired, Spiroflow engineers can recommend support locations. Services of an installation are also available on a fee basis.



Typical Circuits



Materials of Construction

Generally, the construction materials of a tubular conveyor are determined by the product to be handled. Materials that are corrosive or contaminable would normally dictate stainless steel construction on metallic material contact surfaces. In applications where there is no concern over corrosion or contamination, carbon steel construction is a far more economical alternative. The most common materials of construction, in order of increasing costs, are carbon steel, 304 stainless steel and 316 stainless steel. External components not in contact with the product would be carbon steel unless specifically requested in some other materials. Construction from other materials quoted upon request.

What are their benefits?

- Totally enclosed, dust-free, contamination-free handling
- Only mechanical conveyor that can operate in 3 planes which permits complex circuits eliminating transfer points using only a single drive
- Minimum horsepower and energy consumption
- Can be Meter or Flood Fed
- Handles hot, cold, wet, dry, hygroscopic or temperature sensitive materials
- May be fed at multiple points in a circuit
- Minimum noise level
- May discharge at multiple points in a circuit (no air locks)
- No need for filters or cyclone to separate air and material as discharge gravity takes care of this for FREE
- Gentle conveying action - minimized product attrition
- Will not separate blends
- Round construction minimizes material residence and build-up
- May operate under pressure differential or inert purge

Chains, Cables & Flights for every application

At the heart of every tubular conveyor is the conveyor cable and disc or chain and disc assembly which is the single most critical component in the system.

Spiroflow offers a wide range of construction materials and assemblies to meet the demands of the various products to be conveyed. Selection of the cable and disc or chain and disc assembly to be used on any particular application is based on the total developed length of the conveyor circuit, the number of casing bends, material loading, the total mechanical load (chain pull), the number of planes through which the cable or chain must pass and the characteristics of the product being conveyed. Spiroflow offers two cables and two chains that effectively satisfy all applications. They are all well tried, tested and proven designs.

Cables & Discs

Our cable and disc assemblies are a development of those used in our tried and tested range of aero mechanical conveyors. The cables are sized to be strong enough for the load imposed upon the discs. The discs are molded onto metal ferules that are rigidly crimped along the length of the cable. Cables can be of carbon or stainless steel according to the application.

Sealed Pin Chain

Elastomer washers are compressed around the pins and between the links to seal abrasive and corrosive materials from the pin bearing surfaces, thereby extending chain life. Seals are most commonly made of neoprene, E.P.D.M. or polyurethane. Other seal materials are available upon request.

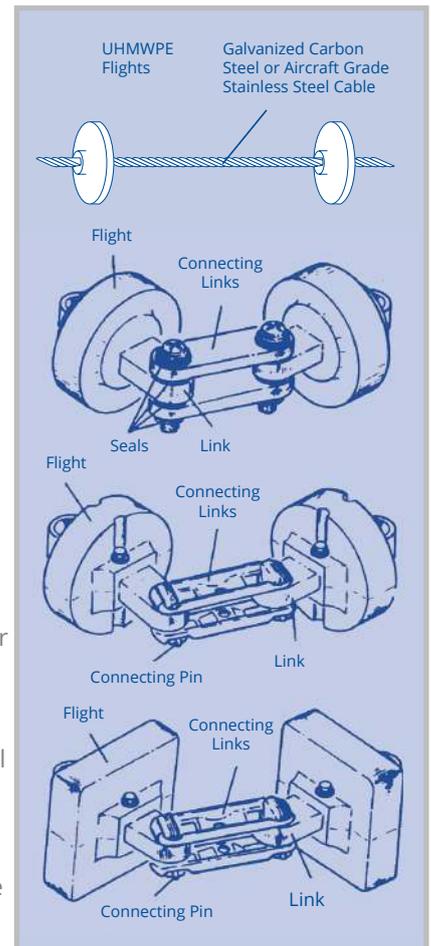
Forged Steel Chain

This chain style utilizes commercially available drop forged rivetless chain with open pin construction. Chain of this design is extremely durable and less costly than the sealed pin variety.

Chains for Square Tubes

From time to time, the demands of a particular application will call for a tubular conveyor with a square or rectangular cross-section. Spiroflow offers a range of chain assemblies that effectively meet these requirements.

A preliminary evaluation gives the false impression that our chain and disc assemblies will operate in only one plane. This is not true as they are designed to rotate out of plane up to 90° over a given distance. This means that “universal joints,” with their inherent drawbacks and added expense, are not required. Our chains are constructed in such a way that elements or sections can be replaced when necessary. And, of course, our cable and disc assemblies will readily flex any which way! Their construction also enables sections to be replaced as required.



Flight Selection

Conveyor flight selection is another critical point. The proper flight material must be chosen to withstand possible chemical attack, abrasion, temperature, etc. Spiroflow offers an effective range of standard flights, meeting the needs of virtually all applications, as follows:

Ultra High Molecular Weight

Polyethylene (UHMWPE) is generally the most popular and best all around flight material, due to its extremely high abrasion resistance, very low coefficient of friction, high impact strength and resulting long service. The material is available in an FDA approved grade; it is chemically inert and

water absorption is essentially nil. Service temperature is up to 175° F (80° C).

Cast Iron is the second most popular flight material due to its low cost & reasonable service life. In many applications, corrosion, abrasion, chemical resistance and product contamination are not a factor. In these instances cast iron may be a prudent choice of materials. In some applications, carbon/mild steel may be substituted to provide the same type of service. Cast iron & mild steel flights have a service range up to 482°F (250°C).

Other Materials:

While nylon and polyurethane flights do not offer all the beneficial properties of UHMWPE there is a range of applications where these materials are best suited.

Specials:

Conveyor flights can be moulded, machined, fabricated or flame cut from a wide range of materials as required by a specific application. A Spiroflow engineer would be happy to discuss your needs and help select the flight material best suited.

Cableflow Tubular Cable Drag Conveyors

Cableflow Tubular Cable Drag Conveyors are in fact a development of our tried and tested Aero Mechanical Conveyors operating with reduced clearances and at reduced running speeds.

Cableflow conveyors are designed for gentle material handling and for installations requiring conveying in multiple planes. They provide complete material batch transfer of bulk products from single or multiple in-feed points to single or multiple discharge points with little or no damage.

Because they are a derivation of our Aero Mechanical Conveyors, they enjoy the option to have our DART (Dynamic Automatic Rope Tensioner) rope tensioning system for maximum cable life and minimum maintenance. This is a key advantage over competitors' cable driven conveyors. Cable discs are manufactured from Ultra High Molecular Weight Polyethylene and are suitable for duties up to 176° F (80° C).



What can they convey?

- Acordis Cellulosic Fiber
- Almonds
- Aluminum Oxide
- Atrazine
- Barium Metaborate Monohydrate
- Burned Oats
- Carbon Black
- Coffee Beans / Ground & Whole
- Corn Starch
- Cotton Seed Coated with Starch
- Cuprous Chloride
- Detergent, powder
- Diatomaceous Earth
- Dried Feed Grade Egg Product
- Flour
- Ground Paper Product
- Lime
- Lime Kiln Dust
- Limestone Pellets
- Lysine Chunks
- Monosodium Glutamate
- Mustard Seed
- Natural Organic Fertiliser
- Oats
- Paper Sludge
- Paraffin
- Peanut Splits
- Powder/Shavings/Slivers
- Polyester Fiber
- PVC Pelletized Mix
- Rubber
- Silica Sand
- Rice
- Rubber (includes Fluff)
- Tungsten Powder
- Tea
- Urea
- Vegetable Scraps
- Virgin PVC
- Walnuts
- Waste Cotton
- Waxed Prills
- Wheat Mids
- Wood Chips
- Zinc Oxide
- Zinc Stearate



Dynaflow Tubular Chain Drag Conveyors

The Dynaflow Tubular Chain Drag Conveyor is also a mechanical tubular drag conveyor operating within the confines of a pipe.

In this conveyor, the discs that move material along the pipe are connected by articulated metal links (chains) meaning that they are well suited to the most arduous of applications. The discs can be made from a variety of materials including steel and cast iron. This enables them to operate at temperatures up to 482° F (250° C).

What can they convey?

- Activated Carbon
- Adipic Acid
- Alum
- Ammonium Nitrate
- Antimony Oxide
- Artificial Sweetener
- Aspirin Powder
- Asbestos
- Baghouse Dust
- Baking Powder
- Black Oxide
- Benzoic Acid
- Bentonite Clay
- Bisphenol
- Bone Meal
- Calcium Carbonate
- Calcium Hypochlorite
- Carbon Black
- Carbon Chips
- Caustic Soda
- Cellulose
- Cement Powder
- Ceramic Clay
- Cereal Fines
- Chlorendic Anhydride
- Coal Fines
- Coffee Beans
- Coffee Chaff
- Copper Powder
- Copper Chromate
- Copper Sulphate
- Corn Meal
- Crushed Pineapple
- Diatomaceous Earth
- Digested Wood Knots
- Epsom Salts
- Ferrous Sulfate
- Fertiliser Powder
- Filter Cake Flock
- Fumaric Acid
- Grain
- Graphite
- Green Salts
- Grinding Sludge
- Ground Coffee
- Ground Graham
- Herbicide
- Hydrated Lime
- Insecticide Powder
- Instant Coffee
- Irganox
- Iron Oxide
- Iron Sulfate
- Isophthalic Acid
- Kaolin Clay
- Lead Oxide
- Lime
- Magnesium Fluoride
- Magnesium Chips
- Magnetic Oxide
- Manganese Oxide
- Malt
- Mercuric Oxide
- Metal Chips
- Metallurgical Coke
- Mica
- Mill Scale
- Molybdenum
- Monosodium phosphate
- Mustard
- Mylar Flake
- Paint Flake
- Paint Sludge
- Paper Pulp
- Paraformaldehyde Flake
- Paunch Manure
- Penicillin Powder
- Pentaerythritol
- Pesticide
- Petroleum Coke
- Phenolic Resin
- Phthalic Acid
- Phthalic Anhydride
- Phosphate Sludge
- Phosphorus Pentasulfide
- Phosphate Ore
- Plastics Sludge
- Powdered Metal
- Powdered Sugar
- Powdered Grass Killer
- PVC Powder
- Raven Black
- Red Lead
- Resin
- Rice
- Rice Hulls
- Sawdust
- Sewage Grit
- Sewage Sludge
- Shelled Peanuts
- Soda Ash
- Sodium bicarbonate
- Sodium Tripolyphosphate
- Sodium Phosphate
- Sodium Hydroxide
- Sodium Bisulphate
- Spent Grain
- Spent Hops
- Spices
- Starch
- Stearic Acid
- Sulphur
- Talc
- Tea
- Terephthalic Acid
- Titanium Dioxide
- Titanox
- Tile clay
- Uranium Oxide
- Uranium Salts
- Uranium Tetrafluoride
- Urea
- Vinsol Resin



Conveyor Selection

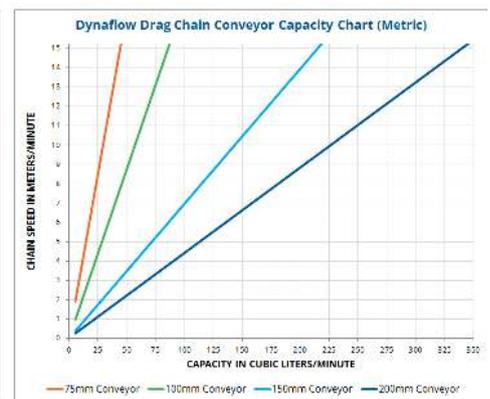
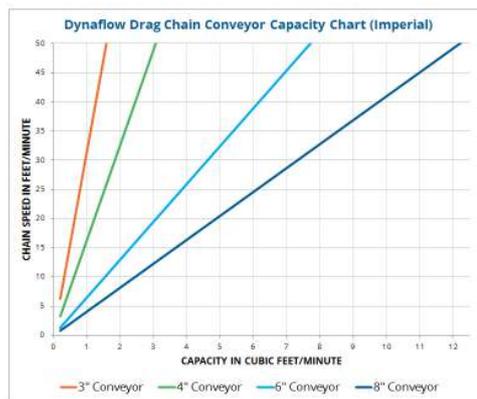
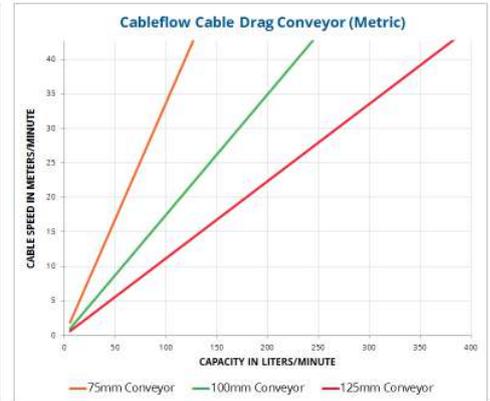
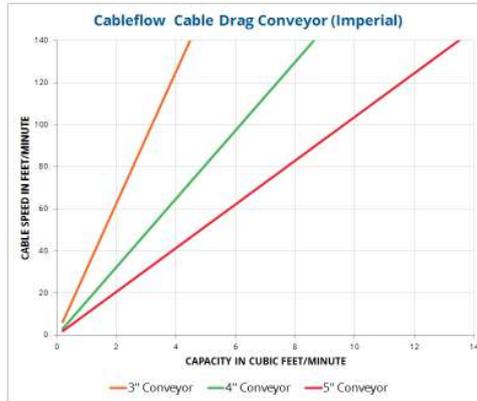
Conveyor Size and Cable/Chain Speed

The capacity chart below will allow you to estimate the size of conveyor and the chain speed needed based on the throughput requirements in litres per minute. The horizontal lines represent the velocity at which your product will pass through the conveyor. The vertical lines indicate the volumetric throughput rate in litres per minute. The diagonal lines are the sizes of the conveyors available.

How to Use the Capacity Charts

1. Based on your material's bulk density, calculate the required conveying rate in cubic feet or litres per minute. Locate the amount required on the horizontal scale.
2. Move up the vertical line and note where it intersects with one or more diagonal lines. Each intersection point indicates a possible conveyor size.
3. From each intersection point, move left horizontally all the way to the vertical scale, indicating the conveyor cable/chain speed.

There are many factors that enter into the tubular conveyor selection process. Beyond the mechanical selection described above, consideration must be given to the physical characteristics of the material to be conveyed and the equipment duty cycle.



Tubular Conveyor Selection Guidelines

1. Cableflow cable drag conveyors can run up to is 140 ft/min (43m/min) and Dynaflow chain drag conveyors can run up to 50 ft/min (15m/min) depending, of course, on the application.
2. It is generally advisable to apply a larger conveyor at a slower cable/chain speed if your material possess sluggish flow characteristics, is sticky, abrasive or if the equipment operational duty cycle is extensive.
3. Smaller conveyor sizes and faster cable/chain speeds are usually selected when the material is free flowing and non-abrasive and/or the equipment duty cycle is low.
4. Future capacity requirements should be considered. It may be prudent to install a larger conveyor now, at a lower cable/chain speed, then increase the cable/chain speed later to accommodate a higher capacity. This can be done with a simple change of pulleys and v-belts.
5. Surges and uneven feed conditions should be considered. Surge hoppers may provide for more constant feeding and may allow use of a smaller conveyor. Tubular Drag Conveyors can be operated partially charged or, with no material being fed into them, to ensure they are empty.
6. Many forms of sludge do not flow well into or out of tubular conveyors. In applications involving sludge, it is generally advisable to oversize the conveyor by a factor of four or more and to never run the chain at a speed above 20 ft/min (6m/min). It is also important to determine the characteristics of the sludge when it dries on the conveyor wall and chain linkage. If it becomes too hard to be easily removed, another type of conveyor may be better suited.

Final equipment selection should be made by a Spiroflow engineer, who will consider the above as well as other factors and make a recommendation on a conveyor that will provide reliable service.

The System Components

Drive Assemblies

Conveyor drive assemblies are available for 90° or 180° locations. They are always located at a high point in the conveyor circuit, after product discharge or can be used as a discharge point. Drive components are selected as required by the conveyor circuit and are mounted on a drive plate which serves as a take-up unit. All drives are complete with overload protection and drive guards. Constant or variable speed units available. All drives are designed for full load start up.



Chain Vibrator

Where a conveyed product resists complete discharge, a special chain vibrator can be incorporated. The vibrator mechanism penetrates the conveyor housing to make direct contact with the chain.



Inspection Openings

Inspection and access openings are located along straight casing sections.



Idler Sprocket Turns

Sprocket turns are placed in a circuit in place of a bend to reduce frictional drag. They are available in any angle from 90° to 180°. They are most commonly placed in the return circuit.



Conveying product through an idler box is not recommended, although idler turns are often used as a product discharge point in a system.



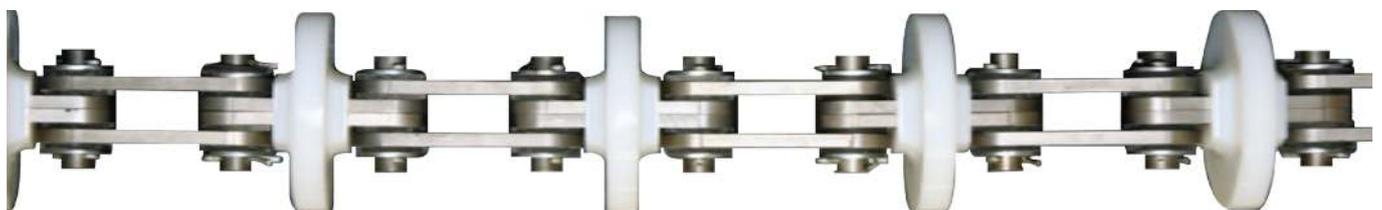
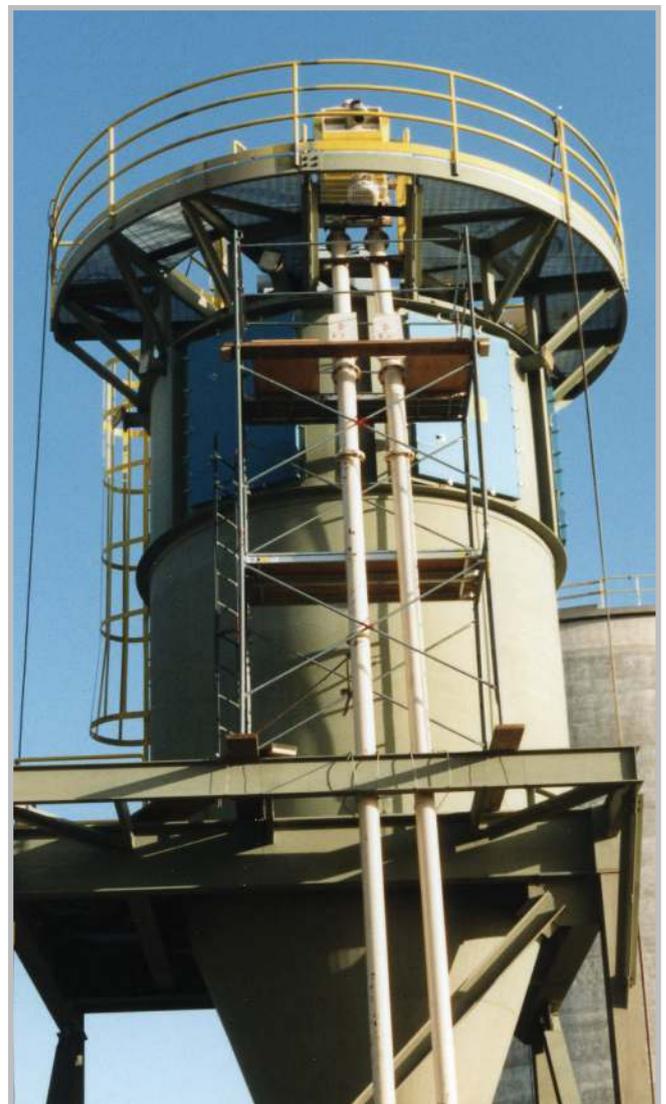
Inlet & Discharge Hoppers

Hoppers are located where required along the straight sections of the conveyor circuit. The actual length and height of the hopper are determined by the flow characteristics of the conveyed product and the dimensions of interfacing equipment. It is quite common to provide a large surge hopper at the inlet for bag dump operations.



Discharge Gates

Manual or air-operated discharge gates allow the operator to choose which of a multiple of discharge points is to be used at a specific time. Commercially available knife or butterfly style valves, located below a standard discharge hopper, are also available.



Powder Handling Systems



Design

We have an experienced team of mechanical and electrical engineers with a vast collective knowledge of solids handling, geared to handle your project quickly and efficiently, whether you need a single conveyor or a complete powder handling system.



Manufacturing

We actively encourage customers to visit our modern manufacturing facilities in the US or UK at any time. Here, we are able to process orders efficiently and to our high standards. Our systems and procedures have ISO9001:2000 accreditation.

Testing

Engineers at our fully equipped test facilities in the US & UK are at your disposal to assess performance of our machinery on your particular material. On-site trials can also be arranged if preferred.

After sales

At Spiroflow, we firmly believe that after sales service forms an integral part of the product. Over 70% of our business comes from existing customers, whom we work with as partners from the moment of placing an order and throughout the equipment's operational life.

Other equipment in the Spiroflow Range:

- Flexible Screw Conveyors
- Aero Mechanical Conveyors
- Pneumatic & Vacuum Conveyors
- Bulk Bag Fillers
- Bulk Bag Dischargers
- Bag, Drum & IBC Emptiers
- Ingredients Handling Systems
- Batch & Continuous Weighing Systems
- Silo & Hopper Discharge Aids
- Continuous Mixing Systems



Flexible Screw Conveyors



Aero Mechanical Conveyors



Vacuum Conveyors



Bulk Bag Fillers



Bulk Bag Dischargers

Contact us today to discuss your applications



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