

Drag and Flight Conveyors Design Calculation

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Drag and Flight Conveyors

Drag conveyors are used where multiple loading or discharge points are required and a totally enclosed conveyor is needed for dust containment, capable of handling fine materials ranging from dust to 8 inch (200 mm) lumps, where capacity requirements are high, 200 - 400 TPH. Drag conveyors are used when the material is somewhat fluid, such as TSP (fertilizers), iron fines, and grain cement.

3. Chain conveyor or apron chain conveyor calculation system. The load functions are calculated as indicated below:

$$T = H_1 + H_2 + H_3 + H_4$$

$$P_{ch} = \frac{Q_{ch} \times L_1}{3.6} + Q_{ch} \times L_2 + H_5 + H_6$$

$$H_1 = \frac{Q_{ch} \times L_1 \times H_1}{2}$$

$$H_2 = \frac{Q_{ch} \times L_2 \times H_2}{2}$$

where:

T = Total chain force or total work chain tension - (kgf) (Nf).

P_{ch} = Upper chain tension - (kgf) (Nf).

H₁ = Down chain tension - (kgf) (Nf).

H₂ = Lift chain tension - (kgf) (Nf).

Q_{ch} = Conveyor chain load - (t/h) (kg/h).

L₁ = Conveyor material weight - (kg/m) (kg/h).

L₂ = Total conveyor skirt length (including inclined/declined) - (m) (ft).

L₃ = Conveyor horizontal skirt length - (m) (ft).

L₄ = Conveyor slope (inclined) / declined extension skirt length - (m) (ft).

H₅ = Total chain weight (see manufacturer's tables according to chain type).

H₆ = Driving power (kW) - (HP).

F = Upper chain friction factor = 0.25 ~ 0.35.

F₂ = Down chain friction factor = 0.20 ~ 0.30.

F₃ = Lift chain friction factor = 0.25 ~ 0.35.

v = Chain conveyor speed - (m/h) - (ft/min).

D = Driving sprocket diameter - (mm) - (in).

L = Conveyor skirt length.

H = Bulk density of conveyed material - (kg/m³) - (lb/ft³).

4. To calculate the driving power (CV or HP), use the following formula:

$$H = \frac{T \times v \times 1000}{9.8 \times 60 \times 1000}$$

$$H = \frac{T \times v \times 1000}{9.8 \times 60 \times 1000}$$

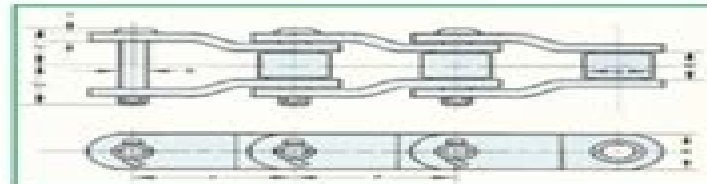
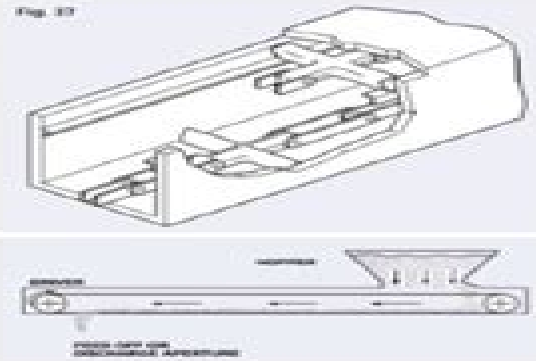
where:

H = Driving power (kW) - (HP).

T = Total chain force or total work chain tension - (kgf) (Nf).

v = Chain conveyor speed - (m/h) - (ft/min).

Fig. 37



CHAIN CONVEYORS OR APRON CONVEYORS SUMMARY:

Chain conveyors or also called apron conveyors are commonly used in mining and moving industries to transport heavy materials. The manufacturing industry also use widely chain conveyor for carry coal lumps, pellets, gang bones and general industrial containers. These conveyors can be single or double chain drive or Caterpillar type chains. Single chain conveyors are generally easy to install and have very minimum maintenance for users.

Many industries sectors use chain conveyor technology in their production lines. The automotive industry commonly uses chain conveyor systems to carry car parts through paint plants. Chain conveyors also have widespread use in the rubber and cement plants, metal finishing and steel-making industries.

Chain conveyors are also used in the printing and coating industry, ceramics, thermal treatment of metals, food and discharge systems of boilers. In automatic printing systems the products are attached to an apron head chain conveyor, keeping products off of the floor allows for higher productivity results.

Chain Calculation Manual For Chain Conveyors

Wenbin Ji



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