

67222

TRANSFER ROLLERS

Material

Steel (AISI 1040 housing and AISI 52100 for balls),
stainless steel (AISI 416 for housing and AISI 420 for balls) and acetal (POM).

Technical Notes

These ball transfer units are made of a solid steel block with a precision machined hemispherical carrying bowl.

Top cover plates are shaped to ensure the perfect conveyance of items which have possible burred or bent edges. This design also prevents possible damage to the carrying ball.

Provided with a hole in the base of the bearing cup to dispose of particles of dirt and swarf (this may also be used for re-lubrication purposes).

Manufactured without a flange on the housing, therefore the whole load is being supported only by the bottom face of the unit.

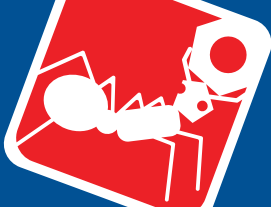
Tips

These rollers can only be used in the horizontal or „ball up“ direction.

Order No.	d ₁	d ₂	h ₁	h ₂	h ₃	Housing	Ball	Load kg max.
67222.W0081	8	18	12.0	10.0	2.0	Steel	Steel	13
67222.W0084	8	18	12.0	10.0	2.0	Steel	Stainless	10
67222.W0082	8	18	12.0	10.0	2.0	Stainless	Stainless	8.4
67222.W0124	12	20	16.5	13.5	3.0	Steel	Stainless	20
67222.W0154	15	24	20.0	15.0	5.0	Steel	Stainless	50
67222.W0224	22	36	30.5	27.9	4.5	Steel	Stainless	180
67222.W0304	30	45	36.8	30.3	6.5	Steel	Stainless	350
67222.W0454	45	62	53.5	45.0	8.5	Steel	Stainless	600
67222.W0604	60	100	77.5	61	16.5	Steel	Stainless	1100
67222.W0121	12	20	16.5	13.5	3.0	Steel	Steel	25
67222.W0125	12	20	16.5	13.5	3.0	Steel	Acetal	5
67222.W0122	12	20	16.5	13.5	3.0	Stainless	Stainless	14
67222.W0151	15	24	20.0	15.0	5.0	Steel	Steel	60
67222.W0155	15	24	20.0	15.0	5.0	Steel	Acetal	10
67222.W0152	15	24	20.0	15.0	5.0	Stainless	Stainless	40
67222.W0221	22	36	30.5	27.9	4.5	Steel	Steel	180
67222.W0225	22	36	30.5	27.9	4.5	Steel	Acetal	20
67222.W0222	22	36	30.5	27.9	2.6	Stainless	Stainless	125
67222.W0301	30	45	36.8	30.3	6.5	Steel	Steel	350
67222.W0305	30	45	36.8	30.3	6.5	Steel	Acetal	25
67222.W0302	30	45	36.8	30.3	6.5	Stainless	Stainless	245
67222.W0451	45	62	53.5	45.0	8.5	Steel	Steel	600
67222.W0455	45	62	53.5	45.0	8.5	Steel	Acetal	25
67222.W0452	45	62	53.5	45.0	8.5	Stainless	Stainless	420
67222.W0601	60	100	77.5	61	16.5	Steel	Steel	1500



Order No.	d ₁	d ₂	h ₁	h ₂	h ₃	Housing	Ball	Load kg max.
67222.W0605	60	100	77.5	61	16.5	Steel	Acetal	35
67222.W0602	60	100	77.5	61	16.5	Stainless	Stainless	1000



Product selection

Housing	Ball	Load Factor	
Steel	Steel	1,0	Housing: AISI 1040 steel, machined, toughened & zinc plated. Ball: AISI 52100 chrome steel
Steel	Stainless	0,7	Housing: AISI 1040 steel, machined, toughened & zinc plated. Ball: AISI 420 stainless steel
Stainless	Stainless	0,7	Housing: AISI 416 stainless steel. Ball: AISI 420 stainless steel
Steel	Acetal		Housing: AISI 1040 steel, machined, toughened & zinc plated. Ball: POM acetal
Aluminium	Stainless		Housing: aluminium. Ball: AISI 420 stainless steel
Acetal	Acetal		Housing: POM acetal. Ball: POM acetal
Acetal	Stainless		Housing: POM acetal. Ball: AISI 420 stainless steel

Available materials

Part No.	Ball Size	Minimum Bore ø	Maximum Bore ø
67202.W9015	15	24,8	25,0
67202.W9022	22	37,0	37,2
67202.W9030	30	46,3	46,7

Fixing clip selection

Clip requires a minimum plate thickness of 3mm to grip securely

Ball Type	Max Load (Kg)	Friction (% of load)	Speed (m/s)	Shock Loads	Arduous Conditions	Orientation	Instant Change
Medium Duty	20-3500	2%	1,5	✓✓✓	✓✓		✓✓✓
Light Duty	7-250	3%	1,0	✓	✓✓		✓✓✓

How to select the correct unit



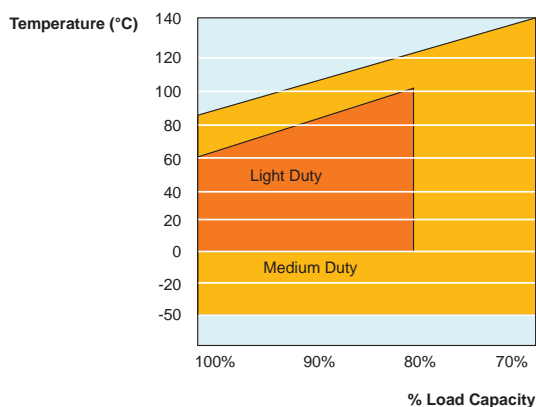
Variables to consider

Shock Loads:
Specify High Capacity series & spring loaded units

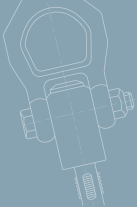
Track Hardness/Conveyed Item Material:
Standard material ball units have Rockwell 'C' hardness of 60 minimum

Delicate Surfaces:
Ball Units - Acetal (POM) & Phenolic Resin

Operating Environment:
Wet, dirty, outdoor, radioactive

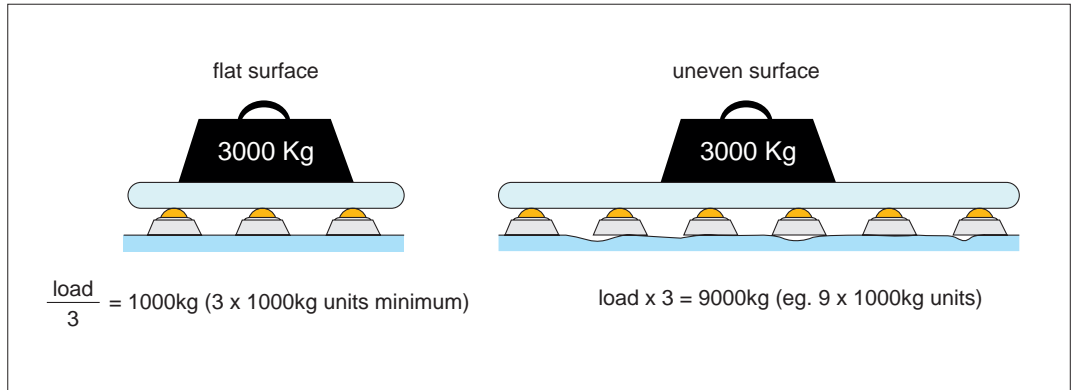


Operation temperature



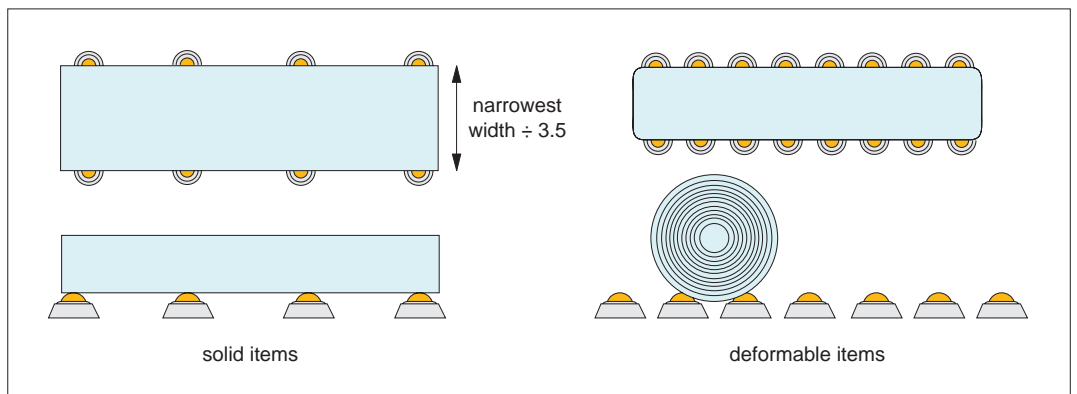
Load and stability

To determine the load of a ball transfer unit, the weight of the article to be conveyed should be divided by 3. If the height tolerance of the load balls is good and the surface of the workpiece to be conveyed is suitable, the calculation can be based on the number of ball transfer units under the load.



Pitching and spacing

How the ball transfer units should be arranged depends on the bottom surface of the load to be transported. For loads with a uniform, even bottom surface, e.g. packing cases, the distance between the ball transfer units is calculated by dividing the smallest dimension by 3,5.



Conveying speed and load capacity

The maximum conveying speed allowed amounts to 2m/s. The load capacities specified apply to any mounting position and are based on 10^6 rotations of the load ball. With the units being used over a longer time at speeds exceeding 1m/s, an increase in temperature as well as a reduction in travel life must be expected depending on the load.

Calculation of travel life

$$L = \frac{C^3}{F} 10^6 \text{ rotations}$$

L = travel life
C = load capacity (N)
F = load (N)

Friction

The diagram shows the friction values as a function of load and speed for ball transfer units. These approximate values apply to all mounting positions with operation on a hardened steel plate.

v = 1m/s

