



Flow-Merge

The Next Generation of Merges

FLOW-TURN's Flow-Merge conveyors utilize a series of strip belts that create a triangular transition arrangement with another conveyor. This allows merge or spur applications at almost any angle and high speeds, complementing FLOW-TURN's power belt curve program.

The strip belts have a high-grip top surface, perfectly suitable for package & parcel and many other applications. A bead is attached to the belt bottom which travels in matching grooves on slider bed, end rolls, and drive pulley. This assures proper belt tracking at all times. The slider bed is made from a low-friction, sound absorbing UHMW material.

Belt strips are precision cut and laced which makes them easily replaceable. End rolls are designed to be exchanged without tools.

Advantages and Benefits of the Flow-Merge Design

- Simple, Low-Maintenance Design
- Usable for Merge and Diverge (Spur) Applications
- Large "Between Frame" (BF) Width Range, from 16" to 60"; other widths available upon request
- Self-Tracking & Quick-Replaceable Strip Belts with Lacing Splices; Strip Width between 3-11/16" and 4"
- High-Grip Belting to maintain proper product position
- Low-Friction, Low-Noise UHMW Slider Bed
- Drives can be shaft-mounted or underslung
- Speeds of up to 600 FPM
- Available in standards angles 20, 22, 30 and 45-degree, other angles are available upon request



45-degree Flow-Merge with RH Flow and Underslung Drive for a Package & Parcel Handling Application

Typical Applications

- Package & Parcel Handling
- Warehousing & Distribution
- Industrial Applications
- Baggage Handling
- Manufacturing & Production

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1050 Commerce Avenue, Union, NJ 07083

Phone: (908) 687 – 3225
Fax: (908) 687 – 1715
Email: sales@flow-turn.com
www.flow-turn.com

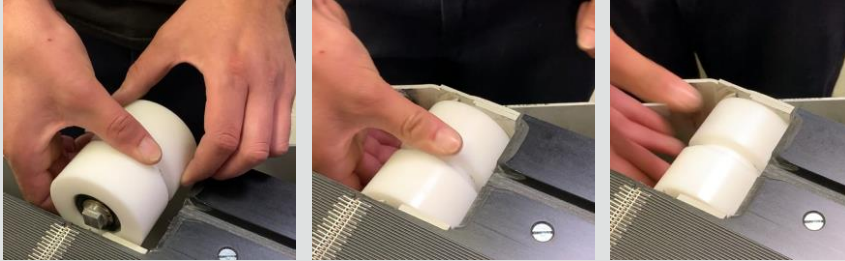
*Custom design is a FLOW-TURN specialty.
We manufacture to rigid specifications and provide answers to unusual requirements.*



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Design Details

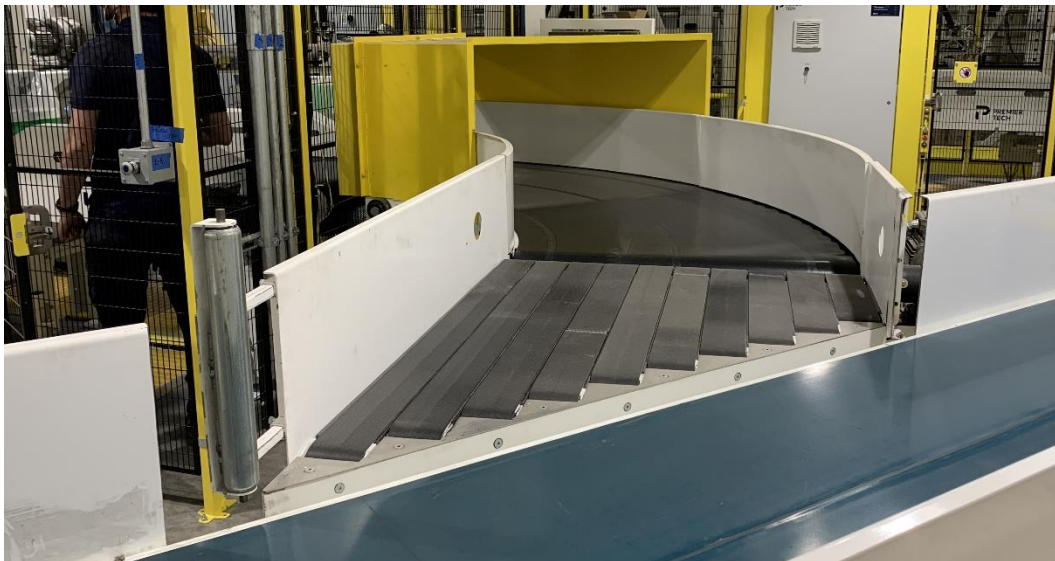
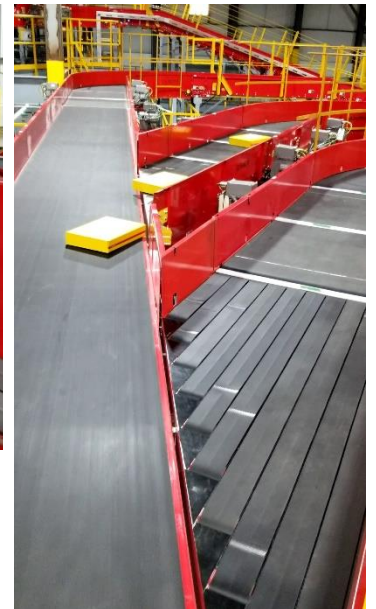
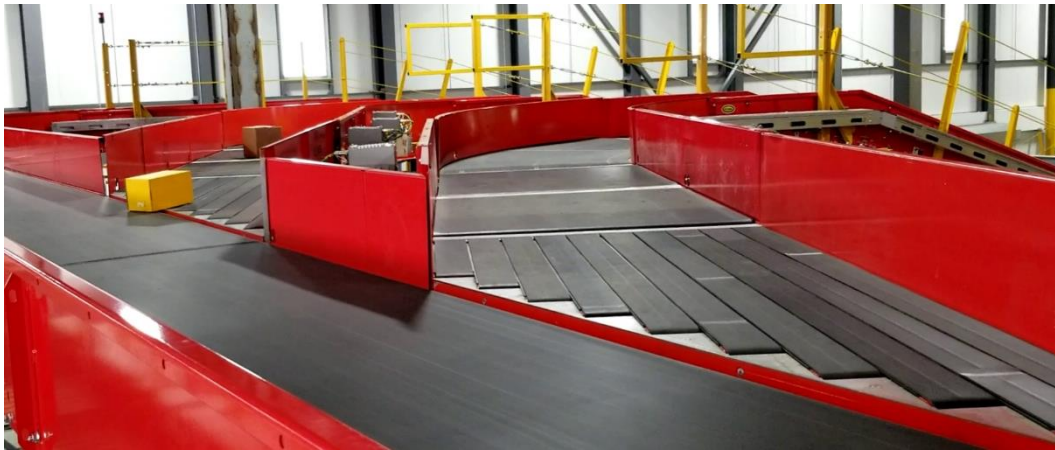


Quick-Replaceable End Rolls Drop into Position



Strip Belt with Bottom Bead and End Roll

Merge Application Examples – Package & Parcel Handling (Top) and Insulation Batts (Bottom)



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MTBH – Material To Be Handled

Flow-Merge strip belt conveyors are designed to transport conveyable unit goods such as bags, boxes, crates, parcels, packages, totes, and trays. They are not suitable for non-conveyable items such as bulk goods, unstable goods (e.g. with round or oval shaped base), loosely wrapped goods, or packaged goods with leaking product, or in environments with excessive dust.

Product Width

As a rule of thumb, the maximum width of the products conveyed should not exceed 80% BF. Recommended minimum product width is 3” but can be smaller depending on speed and application details.

Product Length

For standard merge centerline lengths, the maximum product length should not be larger than 2x maximum product width; if required, the centerline length can be increased.

Product Weight

The live load shall not exceed 25 lb/ft; the total load on a merge shall not exceed 200 lbs.

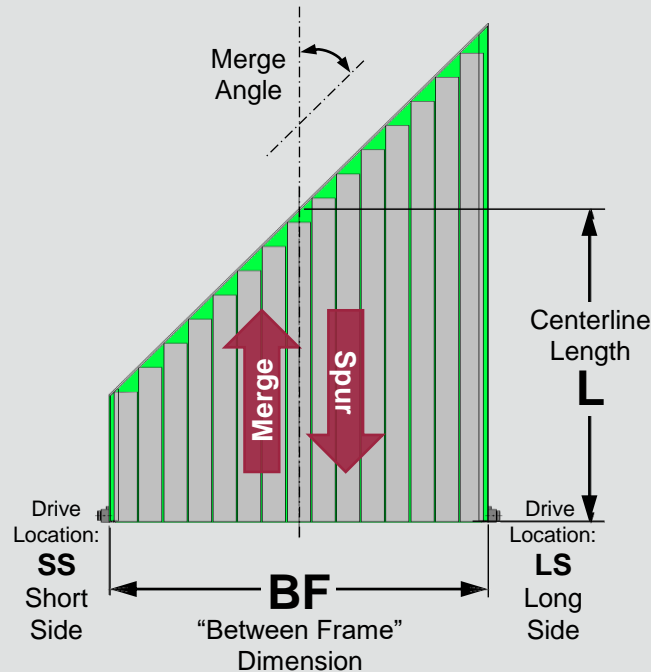
Between Frame BF	Max. Product Dimensions (for standard centerline lengths)	
	Width	Length
16	12.8	25.6
20	16	32
24	19.2	38.4
28	22.4	44.8
30	24	48
32	25.6	51.2
36	28.8	57.6
48	38.4	76.8
60	48	96

Flow-Merge Conveyor Sizing – Width and Length

The table below shows standard centerline lengths for selected BF Between Frame dimensions and standard merge angles. The centerline lengths are calculated for short side lengths of 20” and can be adjusted; please inquire with required centerline lengths for your project.

Centerline Length in in.	Merge Angle				
	20°	22°	30°	45°	
Between Frame BF	16	42	40	34	28
	20	47.5	45	37.5	30
	24	53	50	41	32
	28	58.5	55	44.5	34
	30	61.5	57.5	46	35
	32	64	60	48	36
	36	69.5	65	51.5	38
	48	86	79.5	62	44
	60	102.5	94.5	72	50

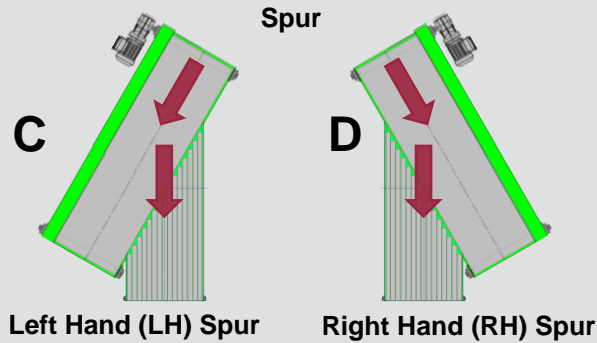
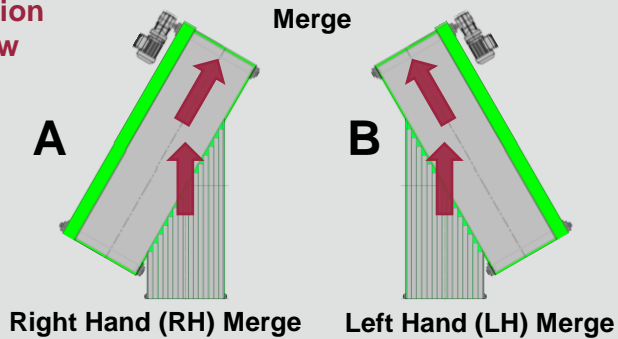
Main Dimensions and Drive Placement



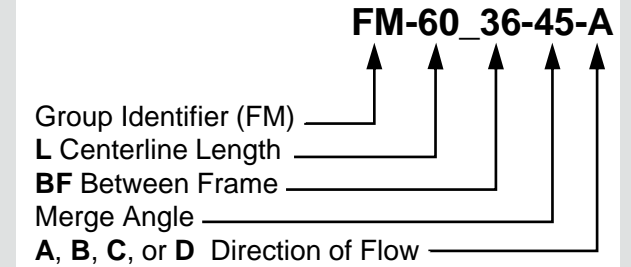
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Direction
of Flow



Flow-Turn Model Code



Drive Mounting Options

Drives can be shaft-mounted horizontally or vertically or installed underslung. Due to limited space on the short side, preferred installation location in many cases is **LS** (Long Side)

45-degree **Flow-Merge** with Direction of Flow “**B**” (Left Hand Merge), merging onto a straight conveyor which is slave-driven from a 45-degree **Square-Turn** belt curve (Inside Side Guards and Drive Cover removed to show design details)

