
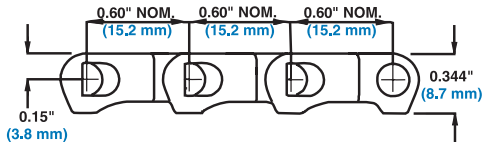



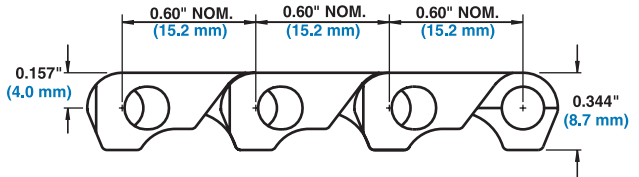
Flush Grid		
	in.	mm
Pitch	0.60	15.2
Minimum Width	See Product Notes	
Width Increments	See Product Notes	
Min. Opening Size (approx.)	0.17 × 0.10	4.3 × 2.5
Max. Opening Size (approx.)	0.31 × 0.10	7.9 × 2.5
Open Area	28%	
Hinge Style	Open	
Drive Method	Hinge-driven	
Product Notes		
<ul style="list-style-type: none"> <li>• Always check with Customer Service for precise belt width measurement and stock status before designing a conveyor or ordering a belt.</li> <li>• Lightweight with smooth surface grid.</li> <li>• Mini-pitch reduces chordal action and transfer dead plate gap.</li> <li>• Custom-built in widths from 3 in. (76 mm) and up, in 0.5 in. (12.7 mm) increments. FR-TPES and EC Acetal are built in widths from 5 in. (127 mm) and up, in 0.5 in. (12.7 mm) increments.</li> <li>• Can be used over 0.875 in. (22.2 mm) diameter nosebar for tight transfers.</li> <li>• For information regarding sprocket placement, refer to the Center Sprocket Offset chart on page 304.</li> </ul>		
Additional Information		
<ul style="list-style-type: none"> <li>• See "Belt selection process" (page 5)</li> <li>• See "Standard belt materials" (page 18)</li> <li>• See "Special application belt materials" (page 18)</li> <li>• See "Friction factors" (page 31)</li> </ul>		

Belt Data															
Belt Material	Standard Rod Material Ø 0.18 in. (4.6 mm)	BS Belt Strength		Temperature Range (continuous)		W Belt Weight		Agency Acceptability: 1=White, 2=Blue, 3=Natural, 4=Grey							
		lb/ft	kg/m	°F	°C	lb/ft <sup>2</sup>	kg/m <sup>2</sup>	FDA (USA)	USDA-FSIS - Meat & Poultry	USDA Dairy <sup>a</sup>	CFA <sup>b</sup>	A <sup>c</sup>	Z <sup>d</sup>	J <sup>e</sup>	EU MC <sup>f</sup>
Polypropylene	Polypropylene	700	1040	34 to 220	1 to 104	0.81	3.95	•	•	1	•	•	•	3	•
Polyethylene	Polyethylene	450	670	-50 to 150	-46 to 66	0.87	4.25	•	•	3	•			3	•
Acetal	Polypropylene	1300	1940	34 to 200	1 to 93	1.19	5.80	•	•	1	•			3	•
EC Acetal	Polypropylene	800	1190	34 to 200	1 to 93	1.19	5.80								
FR-TPES	Polypropylene	750	1120	40 to 150	4 to 66	1.30	6.34								
Non FDA HR Nylon	Non FDA HR Nylon	1100	1640	-50 to 310	-46 to 154	1.20	5.80								
FDA HR Nylon <sup>g</sup>	Nylon	1100	1640	-50 to 240	-46 to 116	1.07	5.22	•							•
UV Resistant Polypropylene	UV Resistant Polypropylene	700	1040	34 to 220	1 to 104	0.81	3.98								
Acetal <sup>h</sup>	Polyethylene	1200	1790	-50 to 70	-46 to 21	1.19	5.80	•	•	1	•			3	•

a. USDA Dairy acceptance require the use of a clean-in-place-system.  
 b. Canada Food Inspection Agency  
 c. Australian Quarantine Inspection Service  
 d. MAF-New Zealand Ministry of Agriculture and Forestry. MAF acceptance requires the use of a clean-in-place system.  
 e. Japan Ministry of Health, Labour, and Welfare  
 f. European Migration Certificate providing approval for food contact according to EU Directive 2002/72/EC and all its amendments to date.  
 g. This product may not be used for food contact articles that will come in contact with food containing alcohol.  
 h. Polyethylene rods can be used in cold applications when impacts or sudden starts/stops occur. Please note lower rating.

<b>Flat Top</b>		
	in.	mm
Pitch	0.60	15.2
Minimum Width	3	76
Width Increments	1.00	25.4
Opening Size (approximate)	-	-
Open Area	0%	
Hinge Style	Open	
Drive Method	Hinge-driven	
<b>Product Notes</b>		
<ul style="list-style-type: none"> <li>• <b>Always check with Customer Service for precise belt width measurement and stock status before designing a conveyor or ordering a belt.</b></li> <li>• Lightweight with smooth, closed surface grid.</li> <li>• Mini-pitch reduces chordal action and transfer dead plate gap.</li> <li>• Can be used over 0.875 in. (22.2 mm) diameter nosebar for tight transfers.</li> <li>• For information regarding sprocket placement, refer to the Center Sprocket Offset chart on page 304.</li> </ul>		
<b>Additional Information</b>		
<ul style="list-style-type: none"> <li>• See “Belt selection process” (page 5)</li> <li>• See “Standard belt materials” (page 18)</li> <li>• See “Special application belt materials” (page 18)</li> <li>• See “Friction factors” (page 31)</li> </ul>		

<b>Belt Data</b>															
Belt Material	Standard Rod Material Ø 0.18 in. (4.6 mm)	<b>BS</b> Belt Strength		Temperature Range (continuous)		<b>W</b> Belt Weight		Agency Acceptability: 1=White, 2=Blue, 3=Natural, 4=Grey							
		lb/ft	kg/m	°F	°C	lb/ft <sup>2</sup>	kg/m <sup>2</sup>	FDA (USA)	USDA-FSIS - Meat & Poultry	USDA Dairy <sup>a</sup>	CFA <sup>b</sup>	A <sup>c</sup>	Z <sup>d</sup>	J <sup>e</sup>	EU MC <sup>f</sup>
Polypropylene	Polypropylene	500 <sup>g</sup>	744 <sup>g</sup>	34 to 220	1 to 104	0.90	4.40	•	•	1	•	•	•	3	•
Polyethylene	Polyethylene	300 <sup>g</sup>	450 <sup>g</sup>	-50 to 150	-46 to 66	0.96	4.69	•	•	3	•	•	•	3	•
Acetal	Polypropylene	1000	1490	34 to 200	1 to 93	1.30	6.35	•	•	1	•			3	•
Acetal <sup>h</sup>	Polyethylene	900	1340	-50 to 70	-46 to 21	1.30	6.35	•	•	1	•			3	•

a. USDA Dairy acceptance requires the use of a clean-in-place-system.  
 b. Canada Food Inspection Agency  
 c. Australian Quarantine Inspection Service  
 d. MAF-New Zealand Ministry of Agriculture and Forestry. MAF acceptance requires the use of a clean-in-place system.  
 e. Japan Ministry of Health, Labour, and Welfare  
 f. European Migration Certificate providing approval for food contact according to EC Directive 2002/72/EC and all its amendments to date.  
 g. When using steel split sprockets, the belt strength for polypropylene is 400 lb/ft (595 kg/m); polyethylene is 240 lb/ft (360 kg/m)  
 h. Polyethylene rods can be used in cold applications when impacts or sudden starts/stops occur. Please note lower rating.

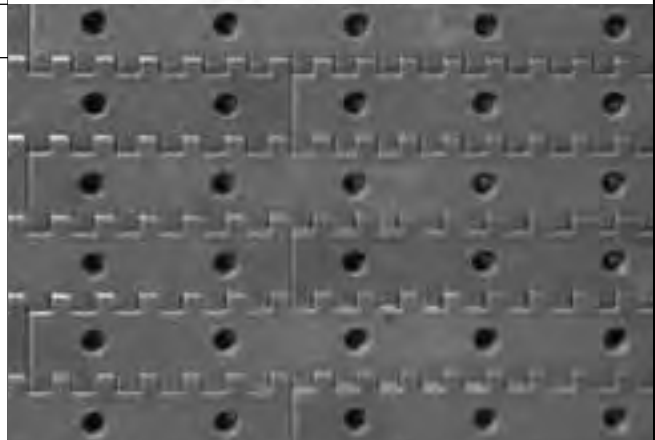
**Perforated Flat Top**

	in.	mm
Pitch	0.60	15.2
Minimum Width	3	76
Width Increments	1.00	25.4
Opening Size (approximate)	-	-
Open Area	3%	
Hinge Style	Open	
Drive Method	Hinge-driven	



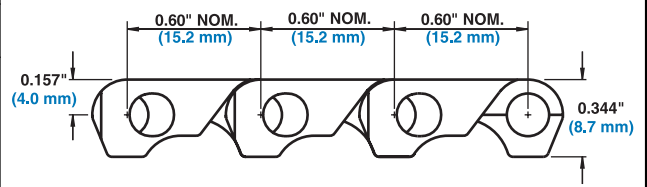
**Product Notes**

- Always check with Customer Service for precise belt width measurement and stock status before designing a conveyor or ordering a belt.
- Available with 5/32 in. (4 mm) round perforations on a nominal 1 in. (25.4 mm) × 0.6 in. (15.2 mm) perforation pattern.
- For use on vacuum applications requiring tight, end-to-end transfers.
- Underside design and small pitch allows the belt to run smoothly around nosebars.
- Can be used over 0.875 in. (22.2 mm) diameter nosebar for tight transfers.
- For information regarding sprocket placement, refer to the Center Sprocket Offset chart on page 304.



**Additional Information**

- See "Belt selection process" (page 5)
- See "Standard belt materials" (page 18)
- See "Special application belt materials" (page 18)
- See "Friction factors" (page 31)

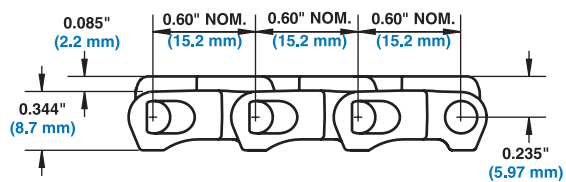
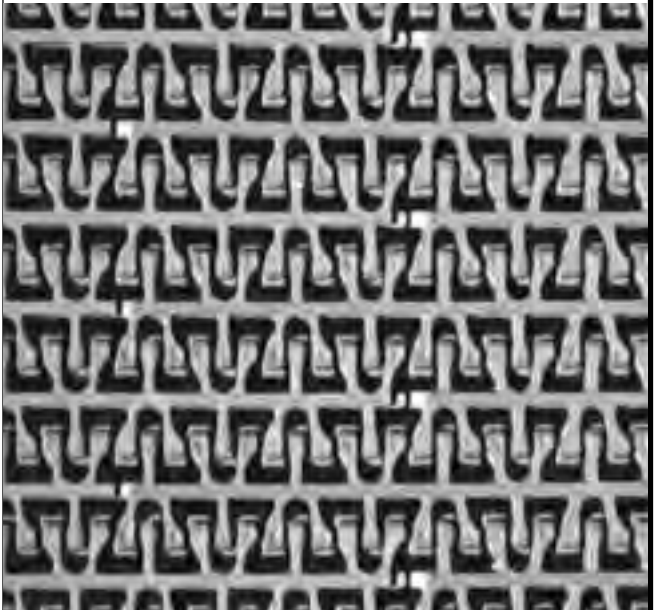
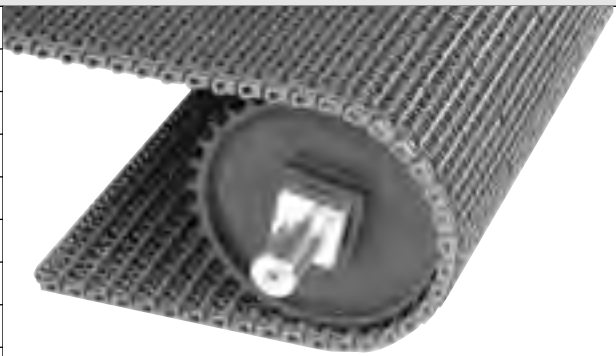


**Belt Data**

Belt Material	Standard Rod Material Ø 0.18 in. (4.6 mm)	BS Belt Strength		Temperature Range (continuous)		W Belt Weight		Agency Acceptability: 1=White, 2=Blue, 3=Natural, 4=Grey						
		lb/ft	kg/m	°F	°C	lb/ft <sup>2</sup>	kg/m <sup>2</sup>	FDA (USA)	USDA-FSIS - Meat & Poultry	USDA Dairy <sup>a</sup>	CFA <sup>b</sup>	A <sup>c</sup>	J <sup>d</sup>	EU MC <sup>e</sup>
Acetal	Polypropylene	1000	1490	34 to 200	1 to 93	1.30	6.35	•	•				3	•
Acetal <sup>f</sup>	Polyethylene	900	1340	-50 to 70	-46 to 21	1.30	6.35	•	•				3	•

a. USDA Dairy acceptance requires the use of a clean-in-place-system.  
 b. Canada Food Inspection Agency  
 c. Australian Quarantine Inspection Service  
 d. Japan Ministry of Health, Labour, and Welfare  
 e. European Migration Certificate providing approval for food contact according to EU Directive 2002/72/EC and all its amendments to date.  
 f. Polyethylene rods can be used in cold applications when impacts or sudden starts/stops occur. Please note lower rating.

<b>Flush Grid Friction Top</b>			
	in.	mm	
Pitch	0.60	15.2	
Minimum Width	3	76	
Width Increments	0.5	12.7	
Opening Size (approximate)	0.17 × 0.10	4.3 × 2.5	
Open Area	28%		
Hinge Style	Open		
Drive Method	Hinge-driven		
<b>Product Notes</b>			
<ul style="list-style-type: none"> <li>• <b>Always check with Customer Service for precise belt width measurement and stock status before designing a conveyor or ordering a belt.</b></li> <li>• Available with grey rubber on a grey polypropylene belt and white rubber on a white polypropylene belt.</li> <li>• White and Black Friction Top materials comply with FDA regulations for use in food processing and packaging applications.</li> <li>• Can be used over 0.875 in. (22.2 mm) diameter nosebar for tight transfers.</li> <li>• For information regarding sprocket placement, refer to the Center Sprocket Offset chart on page 304.</li> <li>• Available materials are Grey PP/Grey Rubber, Grey PP/Black Rubber, and White PP/White Rubber.</li> <li>• Belts have a 0.34 in. (8.6 mm) molded indent.</li> <li>• Grey rubber has a hardness of 64 Shore A. White and Black rubber has a hardness of 55 Shore A.</li> <li>• If a center-drive set up is used, it may be necessary to place collars to laterally retain the belt at the backbend roller before the drive. Abrasion Resistant rods are required.</li> <li>• Temperature, environmental conditions and product characteristics affect the effective maximum degree of incline. Take these items into consideration when designing conveyor systems utilizing these belts.</li> </ul>			
<b>Additional Information</b>			
<ul style="list-style-type: none"> <li>• See “Belt selection process” (page 5)</li> <li>• See “Standard belt materials” (page 18)</li> <li>• See “Special application belt materials” (page 18)</li> <li>• See “Friction factors” (page 31)</li> </ul>			



<b>Belt Data</b>														
Belt Material	Standard Rod Material Ø 0.18 in. (4.6 mm)	<b>BS</b>		Temperature Range (continuous)		<b>W</b>		Agency Acceptability: 1=White, 2=Blue, 3=Natural, 4=Grey, 5=Black						
		lb/ft	kg/m			lb/ft <sup>2</sup>	kg/m <sup>2</sup>	FDA (USA)	USDA Dairy <sup>a</sup>	CFA <sup>b</sup>	A <sup>c</sup>	J <sup>d</sup>	Z <sup>e</sup>	EU MC <sup>f</sup>
Polypropylene	Polypropylene	700	1040	34 to 150	1 to 66	0.81	3.98	1, 5						

a. USDA Dairy acceptance requires the use of a clean-in-place-system.  
 b. Canada Food Inspection Agency  
 c. Australian Quarantine Inspection Service  
 d. Japan Ministry of Health, Labour, and Welfare  
 e. MAF-New Zealand Ministry of Agriculture and Forestry. MAF acceptance requires the use of a clean-in-place system.  
 f. European Migration Certificate providing approval for food contact according to EU Directive 2002/72/EC and all its amendments to date.



**ONEPIECE™ Live Transfer Flush Grid**

	in.	mm
Pitch	0.60	15.2
Minimum Width	6	152
Width Increments	1.00	25.4
Min. Opening Size (approx.)	0.17 × 0.10	4.3 × 2.5
Max. Opening Size (approx.)	0.31 × 0.10	7.9 × 2.5
Open Area	28%	
Hinge Style	Open	
Drive Method	Hinge-driven	

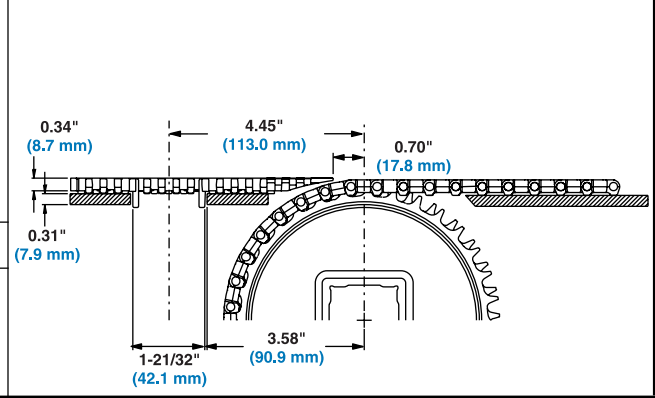


**Product Notes**

- Always check with Customer Service for precise belt width measurement and stock status before designing a conveyor or ordering a belt.
- Lightweight with smooth surface grid.
- Mini-pitch reduces chordal action, resulting in a smoother product transfer.
- Transfer edge is an integral part of this belt.
- Designed for smooth, self-clearing, right angle transfers onto takeaway belts.
- Molded tracking tabs fit into standard 1-3/4 in. (44.5 mm) wearstrip tracks insuring proper belt alignment.
- Built with nylon rods for superior wear resistance.
- Recommended for use with EZ Tracking sprockets.
- You may need to include a fixed frame support member beneath the ONEPIECE™ Live Transfer belt prior to the actual transfer. This will insure that the ONEPIECE™ Live Transfer belt does not snag when it intersects with the takeaway belt. See "Fig. 3-31 PARABOLIC GUIDE RAIL CONTOURS WITH 6.0 in. (152 mm) ONEPIECE™ LIVE TRANSFER BELT" (page 336).
- Also available in 6 in. (152 mm) Mold to Width.
- Use sprockets with a Pitch Diameter of 3.5 in. (89 mm) or larger.
- For custom belt widths please contact Customer Service.

**Additional Information**

- See "Belt selection process" (page 5)
- See "Standard belt materials" (page 18)
- See "Special application belt materials" (page 18)
- See "Friction factors" (page 31)



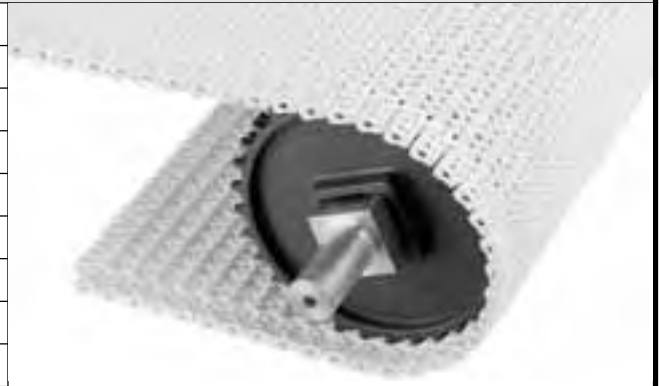
**Belt Data**

Belt Material	Standard Rod Material Ø 0.18 in. (4.6 mm)	BS Belt Strength		Temperature Range (continuous)		W Belt Weight		Agency Acceptability: 1=White, 2=Blue, 3=Natural, 4=Grey			
		lb/ft	kg/m	°F	°C	lb/ft²	kg/m²	FDA (USA)	USDA Dairy <sup>a</sup>	J <sup>b</sup>	EU MC <sup>c</sup>
Acetal	Nylon	1300	1940	34 to 200	1 to 93	1.19	5.80	•		3	•
FR-TPES	Nylon	750	1120	40 to 150	4 to 66	1.30	6.34				
Non FDA HR Nylon	Non FDA HR Nylon	1100	1640	-50 to 310	-46 to 154	1.20	5.80				

a. USDA Dairy acceptance requires the use of a clean-in-place-system.  
 b. Japan Ministry of Health, Labour, and Welfare  
 c. European Migration Certificate providing approval for food contact according to EU Directive 2002/72/EC and all its amendments to date.

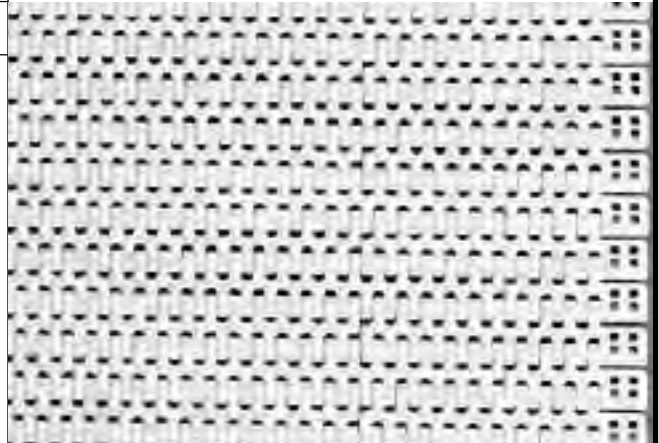
**Flush Grid Nub Top™**

	in.	mm
Pitch	0.60	15.2
Minimum Width	3	76
Width Increments	1.00	25.4
Opening Size (approx.)	0.18 × 0.09	4.4 × 2.3
Open Area	15%	
Product Contact Area	26%	
Hinge Style	Open	
Drive Method	Hinge-driven	



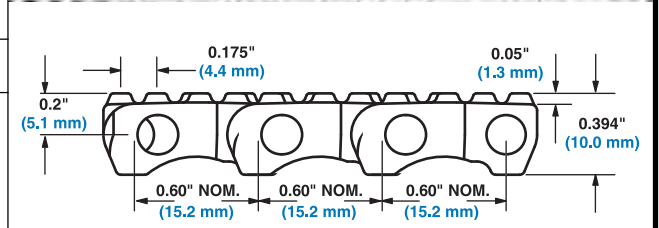
**Product Notes**

- Always check with Customer Service for precise belt width measurement and stock status before designing a conveyor or ordering a belt.
- Standard Nub indent is 1 inch (25.4 mm).
- Headless rod retention system allows re-use of rods.
- Nub pattern reduces contact between belt surface and product.
- Manufactured in Acetal, Polypropylene and Polyethylene (for frozen products).
- Recommended for products large enough to span the distance between the nubs.
- Can be fitted with a 2.0 inch (50.8 mm) Flush Grid Nub Top flight.



**Additional Information**

- See "Belt selection process" (page 5)
- See "Standard belt materials" (page 18)
- See "Special application belt materials" (page 18)
- See "Friction factors" (page 31)



SECTION 2

1100

**Belt Data**

Belt Material	Standard Rod Material Ø 0.18 in. (4.6 mm)	BS Belt Strength <sup>a</sup>		Temperature Range (continuous)		W Belt Weight		Agency Acceptability: 1=White, 2=Blue, 3=Natural, 4=Grey							
		lb/ft	kg/m	°F	°C	lb/ft <sup>2</sup>	kg/m <sup>2</sup>	FDA (USA)	USDA Dairy <sup>b</sup>	CFA <sup>c</sup>	A <sup>d</sup>	J <sup>e</sup>	Z <sup>f</sup>	EU MC <sup>g</sup>	
Polypropylene	Polypropylene	700	1040	34 to 220	1 to 104	0.93	4.55	•					3		•
Acetal	Polypropylene	1300	1940	34 to 220	7 to 93	1.36	6.65	•					3		•
Polyethylene	Polyethylene	450	670	-50 to 150	-46 to 66	1.00	4.90	•					3		•
Acetal	Polyethylene	1200	1790	-50 to 70	-46 to 21	1.36	6.65	•					3		•

a. When using Polyurethane sprockets, the Belt Strength for Polypropylene, Acetal and Nylon is 750 lbs/ft (1120 kg/m), and the temperature range for the sprocket is 0 °F (-18 °C) to 120 °F (49 °C). Contact Customer Service for availability of Polyurethane sprockets.  
 b. USDA Dairy acceptance requires the use of a clean-in-place-system.  
 c. Canada Food Inspection Agency  
 d. Australian Quarantine Inspection Service  
 e. Japan Ministry of Health, Labour, and Welfare  
 f. MAF-New Zealand Ministry of Agriculture and Forestry. MAF acceptance requires the use of a clean-in-place system.  
 g. European Migration Certificate providing approval for food contact according to EU Directive 2002/72/EC and all its amendments to date.

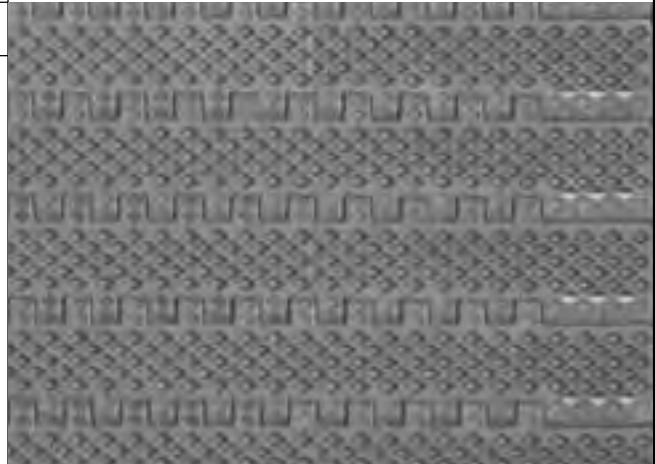
**Embedded Diamond Top**

	in.	mm
Pitch	0.60	15.2
Minimum Width	3	76
Width Increments	1.00	25.4
Opening Size (approx.)	-	-
Open Area	0%	
Hinge Style	Open	
Drive Method	Hinge-driven	



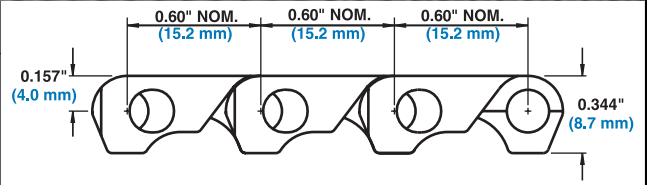
**Product Notes**

- Always check with Customer Service for precise belt width measurement and stock status before designing a conveyor or ordering a belt.
- Lightweight with smooth, closed surface grid.
- Mini-pitch reduces chordal action and transfer dead plate gap.
- Can be used over 0.875 in. (22.2 mm) diameter nosebar for tight transfers.
- For information regarding sprocket placement, refer to the Center Sprocket Offset chart on page 304.



**Additional Information**

- See "Belt selection process" (page 5)
- See "Standard belt materials" (page 18)
- See "Special application belt materials" (page 18)
- See "Friction factors" (page 31)


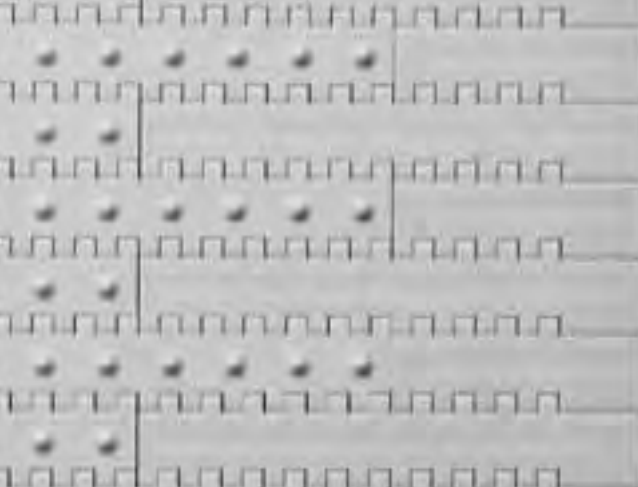


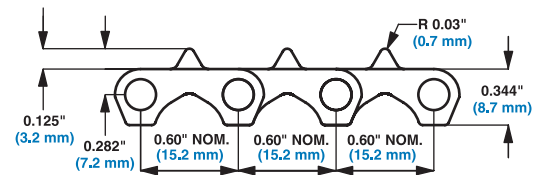
**Belt Data**

Belt Material	Standard Rod Material Ø 0.18 in. (4.6 mm)	<b>BS</b> Belt Strength <sup>a</sup>	Temperature Range (continuous)		<b>W</b> Belt Weight	Agency Acceptability: 1=White, 2=Blue, 3=Natural, 4=Grey									
			lb/ft	kg/m		°F	°C	lb/ft <sup>2</sup>	kg/m <sup>2</sup>	FDA (USA)	USDA-FSIS - Meat & Poultry	USDA Dairy <sup>b</sup>	CFA <sup>c</sup>	A <sup>d</sup>	J <sup>e</sup>
Polyethylene	Polyethylene	300	450	-50 to 150	-46 to 66	0.96	4.69	•	•	3			3		•

a. When using steel sprockets, the belt strength for polyethylene is 240 lb/ft (360 kg/m).  
 b. USDA Dairy acceptance requires the use of a clean-in-place-system.  
 c. Canada Food Inspection Agency  
 d. Australian Quarantine Inspection Service  
 e. Japan Ministry of Health, Labour, and Welfare  
 f. MAF-New Zealand Ministry of Agriculture and Forestry. MAF acceptance requires the use of a clean-in-place system.  
 g. European Migration Certificate providing approval for food contact according to EU Directive 2002/72/EC and all its amendments to date.

<b>Cone Top™</b>		
	in.	mm
Pitch	0.60	15.2
Minimum Width	9	229
Width Increments	1.00	25.4
Opening Size (approx.)	-	-
Open Area	0%	
Hinge Style	Open	
Drive Method	Hinge-driven	
<b>Product Notes</b>		
<ul style="list-style-type: none"> <li>Always check with Customer Service for precise belt width measurement and stock status before designing a conveyor or ordering a belt.</li> <li>Mini-pitch reduces chordal action and transfer dead plate gap.</li> <li>Can be used over 0.875 in. (22.2 mm) diameter nosebar for tight transfers.</li> <li>For information regarding sprocket placement, refer to the Center Sprocket Offset chart on page 304.</li> <li>Minimum indent is 2 in. (50.8 mm).</li> </ul>		
<b>Additional Information</b>		
<ul style="list-style-type: none"> <li>See "Belt selection process" (page 5)</li> <li>See "Standard belt materials" (page 18)</li> <li>See "Special application belt materials" (page 18)</li> <li>See "Friction factors" (page 31)</li> </ul>		



<b>Belt Data</b>															
Belt Material	Standard Rod Material Ø 0.18 in. (4.6 mm)	<b>BS</b> Belt Strength		Temperature Range (continuous)		<b>W</b> Belt Weight		Agency Acceptability: 1=White, 2=Blue, 3=Natural, 4=Grey							
		lb/ft	kg/m	°F	°C	lb/ft <sup>2</sup>	kg/m <sup>2</sup>	FDA (USA)	USDA-FSIS - Meat & Poultry	USDA Dairy <sup>a</sup>	CFA <sup>b</sup>	A <sup>c</sup>	J <sup>d</sup>	Z <sup>e</sup>	EU MC <sup>f</sup>
Acetal	Polypropylene	1000	1490	34 to 200	1 to 93	1.31	6.40	•	•	1			3		•

- a. USDA Dairy acceptance requires the use of a clean-in-place-system.
- b. Canada Food Inspection Agency
- c. Australian Quarantine Inspection Service
- d. Japan Ministry of Health, Labour, and Welfare
- e. MAF-New Zealand Ministry of Agriculture and Forestry. MAF acceptance requires the use of a clean-in-place system.
- f. European Migration Certificate providing approval for food contact according to EU Directive 2002/72/EC and all its amendments to date.



**Flush Grid MTW, 38 and 46 mm Wide**

	in.	mm
Pitch	0.60	15.2
Molded Widths	1.5 & 1.8	38 & 46
Min. Opening Size (approx.)	0.17 × 0.10	4.3 × 2.5
Max. Opening Size (approx.)	0.31 × 0.10	7.9 × 2.5
Open Area	26%	
Hinge Style	Open	
Drive Method	Hinge-driven	



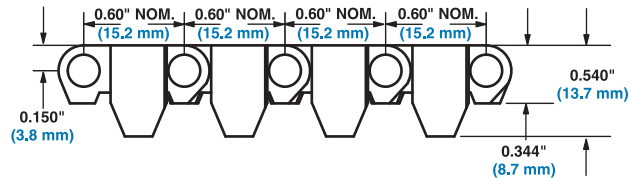
**Product Notes**

- Always check with Customer Service for precise belt width measurement and stock status before designing a conveyor or ordering a belt.
- Boxed in 10 ft. (3.05 m) increments.
- Flush edges with snap-in rod retention.
- Tracking tabs provide lateral tracking.
- All chains come with nylon rodlets standard, providing longer service life.
- Lightweight with smooth surface grid.
- Can be used over 0.875 in. (22.2 mm) diameter nosebar for tight transfers.
- One (1) sprocket maximum per shaft for both widths.
- EZ Track sprockets only.
- The 38 mm belt has a 1.23 in. (31.2 mm) spacing between tabs. The 46 mm belt has a 1.54 in. (39.1 mm) spacing.



**Additional Information**

- See "Belt selection process" (page 5)
- See "Standard belt materials" (page 18)
- See "Special application belt materials" (page 18)
- See "Friction factors" (page 31)



**Belt Data**

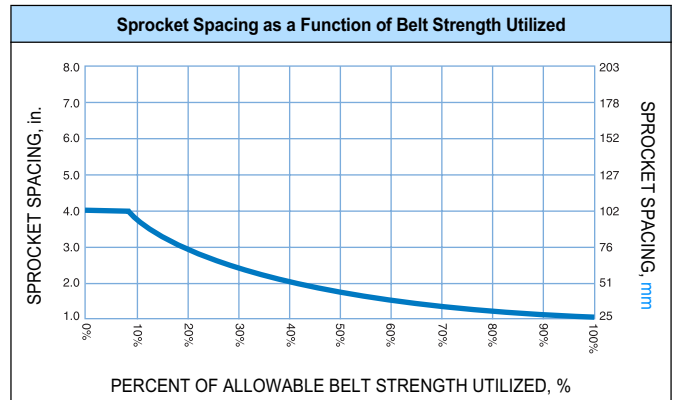
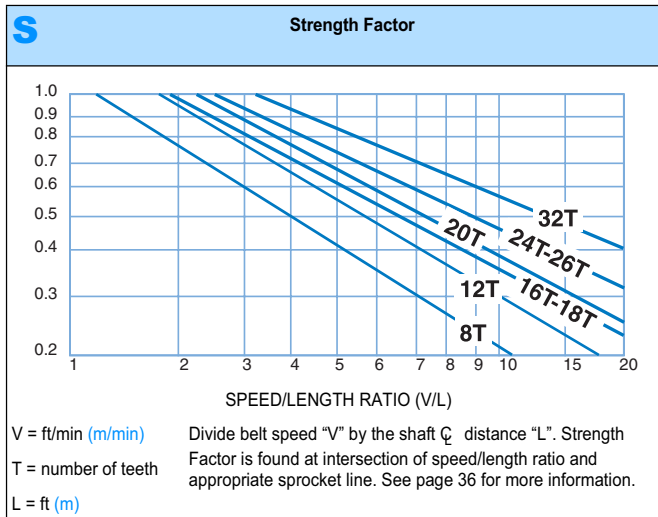
Belt Material	Standard Rod Material Ø 0.18 in. (4.6 mm)	BS Belt Strength <sup>a</sup>		Temperature Range (continuous)		W Belt Weight		Agency Acceptability: 1=White, 2=Blue, 3=Natural, 4=Grey						
		lb	kg	°F	°C	lb/ft	kg/m	FDA (USA)	USDA Dairy <sup>b</sup>	CFA <sup>c</sup>	A <sup>d</sup>	J <sup>e</sup>	Z <sup>f</sup>	EU MC <sup>g</sup>
Acetal (38 mm)	Nylon	130	59	-50 to 200	-46 to 93	0.185	0.275	•					3	•
Acetal (46 mm)	Nylon	150	68	-50 to 200	-46 to 93	0.216	0.321	•					3	•

a. When using steel sprockets, the belt strength for polyethylene is 240 lb/ft (360 kg/m).  
 b. USDA Dairy acceptance require the use of a clean-in-place-system.  
 c. Canada Food Inspection Agency  
 d. Australian Quarantine Inspection Service  
 e. Japan Ministry of Health, Labour, and Welfare  
 f. MAF-New Zealand Ministry of Agriculture and Forestry. MAF acceptance requires the use of a clean-in-place system.  
 g. European Migration Certificate providing approval for food contact according to EU Directive 2002/72/EC and all its amendments to date.

### Sprocket and Support Quantity Reference<sup>a</sup>

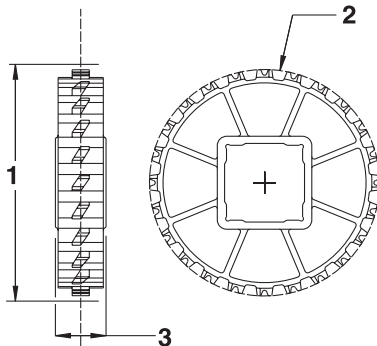
Belt Width Range <sup>b</sup>		Minimum Number of Sprockets Per Shaft <sup>c</sup>	Wearstrips	
in.	mm		Carryway	Returnway
3	76	1	2	2
4	102	1	2	2
6	152	2	2	2
7	178	2	3	2
8	203	2	3	2
10	254	3	3	2
12	305	3	3	2
14	356	5	4	3
15	381	5	4	3
16	406	5	4	3
18	457	5	4	3
20	508	5	5	3
24	610	7	5	3
30	762	9	6	4
32	813	9	7	4
36	914	9	7	4
42	1067	11	8	5
48	1219	13	9	5
54	1372	15	10	6
60	1524	15	11	6
72	1829	19	13	7
84	2134	21	15	8
96	2438	25	17	9
120	3048	31	21	11
144	3658	37	25	13
For Other Widths, Use Odd Number of Sprockets <sup>d</sup> at Maximum 4 in. (102 mm) $\varnothing$ Spacing			Maximum 6 in. (152 mm) $\varnothing$ Spacing	Maximum 12 in. (305 mm) $\varnothing$ Spacing

- a. Because of the single plate steel design, Intralox recommends using twice as many 8 and 12 tooth sprockets as indicated.
- b. If your belt width exceeds a number listed in the table, please refer to the sprocket and support material minimums for the next larger width range listed. Belts are available in 1.00 in. (25.4 mm) increments beginning with minimum width of 3 in. (76 mm). **If the actual width is critical, consult Customer Service.**
- c. These are the minimum number of sprockets. Additional sprockets may be required for heavily loaded applications.
- d. The center sprocket should be locked down. With only two sprockets, fix the sprocket on the drive journal side only. See Retainer Rings/Center Sprocket Offset chart on page 304 for lock down location.



**Molded Sprocket Data<sup>a</sup>**

No. of Teeth (Chordal Action)	Nom. Pitch Dia. in.	Nom. Pitch Dia. mm	Nom. Outer Dia. in.	Nom. Outer Dia. mm	Nom. Hub Width in.	Nom. Hub Width mm	Available Bore Sizes			
							U.S. Sizes		Metric Sizes	
							Round in. <sup>b</sup>	Square in.	Round mm <sup>b</sup>	Square mm
12 (3.41%)	2.3	58	2.3	58	0.75	19	1.0	1.0	25	25
16 (1.92%)	3.1	79	3.1	79	1.0	25	1 to 1-1/4	1.5	25 to 30	40
18 (1.52%)	3.5	89	3.5	89	0.75	19		1.0		25
20 (1.23%)	3.8	97	3.8	97	1.0	25		1.5		40
24 (0.86%)	4.6	117	4.7	119	1.0	25	1 to 1-1/4	1.5	25 to 30	40
26 (0.73%)	5.1	130	5.1	130	1.0	25	1 to 1-1/4	1.5	25 to 30	40
32 (0.48%)	6.1	155	6.2	157	1.0	25	1 to 1-1/4	1.5	25 to 30	40
								2.5		60



1 - Pitch diameter

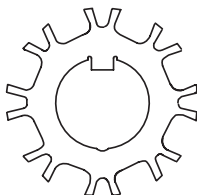
2 - Outer diameter

3 - Hub width

- a. **Contact Customer Service for lead times.**
- b. Round bore molded and split sprockets are frequently furnished with two keyways. Use of two keys is NOT REQUIRED nor recommended. Round bore sprockets do not have set screws for locking the sprockets in place. As with square bore sprockets, only the center-most sprocket needs to be locked down. Imperial key sizes on round bore sprockets conform to ANSI standard B17.1-1967 (R1989) and metric key sizes conform to DIN standard 6885.

**Stainless Steel Sprocket Data<sup>a</sup>**


No. of Teeth (Chordal Action)	Nom. Pitch Dia. in.	Nom. Pitch Dia. mm	Nom. Outer Dia. in.	Nom. Outer Dia. mm	Nom. Hub Width in.	Nom. Hub Width mm	Available Bore Sizes			
							U.S. Sizes		Metric Sizes	
							Round in. <sup>b</sup>	Square in.	Round mm <sup>b</sup>	Square mm
8 (7.61%)	1.6	41	1.6	41	0.164	4.2	3/4	5/8	20	
12 (3.41%)	2.3	58	2.3	58	0.164	4.2	1.0	1.0	25	25



- a. **Contact Customer Service for lead times.**
- b. The stainless steel sprockets have a male key in the round bore sizes. Since the key is part of the sprocket, only the center sprockets should be locked down to track the belt. The male key requires that the shaft keyway run the entire length of the shaft. Imperial key sizes on round bore sprockets conform to ANSI standard B17.1-1967 (R1989) and metric key sizes conform to DIN standard 6885

**Split Sprocket Data<sup>a</sup>**

No. of Teeth (Chordal Action)	Nom. Pitch Dia. in.	Nom. Pitch Dia. mm	Nom. Outer Dia. in.	Nom. Outer Dia. mm	Nom. Hub Width in.	Nom. Hub Width mm	Available Bore Sizes			
							U.S. Sizes		Metric Sizes	
							Round in. <sup>b</sup>	Square in.	Round mm <sup>b</sup>	Square mm
18 (1.54%)	3.5	89	3.5	89	1.7	43		1.5		40
24 (0.86%)	4.6	117	4.7	119	1.7	43	1 1-3/16 1-1/4	1.5	30	40
26 (0.73%)	5.1	130	5.1	130	1.7	43	1 1-3/16 1-1/4	1.5		40
32 (0.48%)	6.1	155	6.2	157	1.7	43	1 1-3/16 1-1/4 1-1/2	2.5		60
										60



- a. **Contact Customer Service for lead times.**
- b. Imperial key sizes on round bore sprockets conform to ANSI standard B17.1-1967 (R1989) and metric key sizes conform to DIN standard 6885

### EZ Track™ Molded Sprocket Data<sup>a</sup>

No. of Teeth (Chordal Action)	Nom. Pitch Dia. in.	Nom. Pitch Dia. mm	Nom. Outer Dia. in.	Nom. Outer Dia. mm	Nom. Hub Width in.	Nom. Hub Width mm	Available Bore Sizes			
							U.S. Sizes		Metric Sizes	
							Round in.	Square in.	Round mm	Square mm
16 (1.92%)	3.1	79	3.1	79	1.0	25		1.5		40
18 (1.52%)	3.5	89	3.5	89	1.0	25		1.5		40
24 (0.86%)	4.6	117	4.7	119	1.0	25		1.5		40
								2.5		60
32 (0.48%)	6.1	155	6.2	157	1.0	25		1.5		40
								2.5		60



a. Contact Customer Service for lead times.

### EZ Track™ Molded Glass Filled Nylon Split Sprocket Data<sup>a</sup>

No. of Teeth (Chordal Action)	Nom. Pitch Dia. in.	Nom. Pitch Dia. mm	Nom. Outer Dia. in.	Nom. Outer Dia. mm	Nom. Hub Width in.	Nom. Hub Width mm	Available Bore Sizes			
							U.S. Sizes		Metric Sizes	
							Round in.	Square in.	Round mm	Square mm
24 (0.86%)	4.6	117	4.7	119	1.5	38		1.5		40
32 (0.48%)	6.1	155	6.2	157	1.5	38		1.5		40
								2.5		60



a. Contact Customer Service for lead times.

### EZ Track™/EZ Clean™ Molded Sprocket Data<sup>a</sup>


No. of Teeth (Chordal Action)	Nom. Pitch Dia. in.	Nom. Pitch Dia. mm	Nom. Outer Dia. in.	Nom. Outer Dia. mm	Nom. Hub Width in.	Nom. Hub Width mm	Available Bore Sizes			
							U.S. Sizes		Metric Sizes	
							Round in.	Square in.	Round mm	Square mm
12 (3.41%)	2.3	58	2.3	58	1.0	25	1.0	1.0	25	25
16 (1.92%)	3.1	79	3.1	79	1.0	25	1.0		25	
							1-1/16, 1-1/8, 1-1/4		30	
18 (1.52%)	3.5	89	3.5	89	1.0	25		1.0		25
20 (1.23%)	3.8	97	3.8	97	1.0	25		1.5		40
24 (0.86%)	4.6	117	4.7	119	1.0	25	1.0		25	
							1-1/16, 1-1/8, 1-3/16, 1-1/4		30	
26 (0.73%)	5.1	130	5.1	130	1.0	25	1.0	1.5	25	40
							1-1/16, 1-1/8, 1-1/4		30	
32 (0.48%)	6.1	155	6.2	157	1.0	25	1.0		25	
							1-1/16, 1-1/8, 1-3/16, 1-1/4		30	





a. Contact Customer Service for lead times.



a. Contact Customer Service for lead times.

<b>Flat Top Base Flights (Streamline)</b>		
Available Flight Height		Available Materials
in.	mm	
2	51	
Polypropylene, Polyethylene, Acetal		
<p><b>Note:</b> Flights can be cut down to any height required for a particular application.</p> <p><b>Note:</b> No fasteners required.</p> <p><b>Note:</b> Flat Top flight is smooth (Streamline) on both sides.</p> <p><b>Note:</b> The Flat Top base streamline flights are used in both Flat Top and Flush Grid belts.</p> <p><b>Note:</b> The minimum recommended indent for Flat Top is 2 in. (51 mm). The minimum recommended indent for Flush Grid is 1 in. (25 mm).</p>		
		

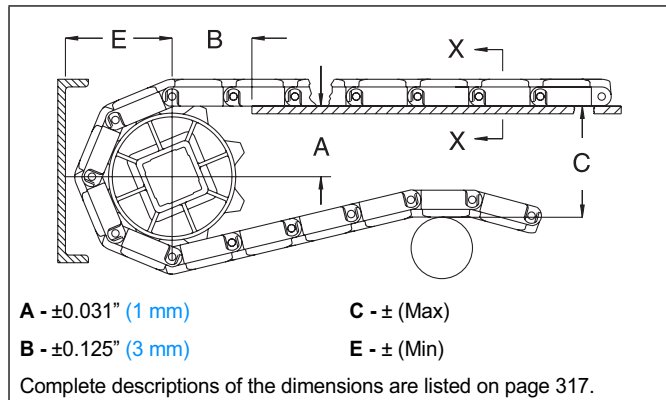
<b>Flush Grid Nub Top Base Flights (No-Cling)</b>			
Available Flight Height		Available Materials	
in.	mm		
2	51		
Polypropylene, Polyethylene, Acetal			
3		76	Polypropylene, Acetal
<p><b>Note:</b> Flights can be cut down to any height required for a particular application.</p> <p><b>Note:</b> Each flight rises out of the center of the module, molded as an integral part. No fasteners required.</p> <p><b>Note:</b> The No-Cling vertical ribs are on both sides of the flight.</p> <p><b>Note:</b> The minimum recommended indent is 1 in. (25 mm).</p>			
			

<b>Sideguards</b>		
Available Sizes		Available Materials
in.	mm	
2	51	
Polypropylene, Polyethylene, Acetal		
<p><b>Note:</b> No fasteners required.</p> <p><b>Note:</b> The minimum indent is 1.3 in. (33 mm). The standard gap between the sideguards and the edge of a flight is 0.2 in. (5 mm).</p> <p><b>Note:</b> When going around the 8, 12, 16 and 18 tooth sprockets, the sideguards will fan out, opening a gap at the top of the sideguard which might allow small products to fall out. The sideguards stay completely closed when wrapping around the 24 tooth and larger sprockets.</p>		
		

## Conveyor Frame Dimensions

Regardless of type or configuration, all conveyors using Intralox belts have some basic dimensional requirements. Specifically, dimensions “A”, “B”, “C” and “E” listed below should be implemented in any design.

For general applications and applications where end transfer of tip-sensitive product is not critical, use the “A” dimension at the bottom of the range.



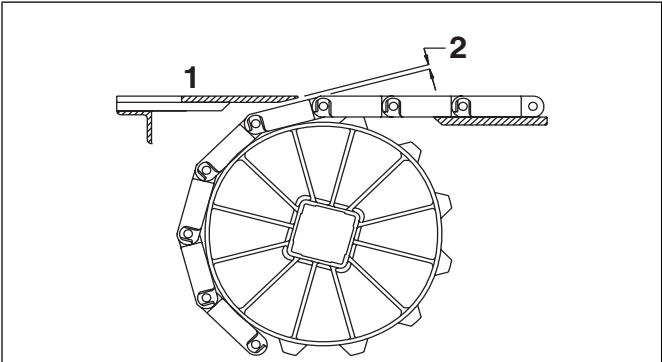
Sprocket Description		A		B		C		E		
Pitch Diameter		No. Teeth	Range (Bottom to Top)		in.	mm	in.	mm	in.	mm
in.	mm		in.	mm						
<b>SERIES 1100 FLUSH GRID, FLAT TOP, PERFORATED FLAT TOP<sup>a</sup>, EMBEDDED DIAMOND TOP</b>										
1.6	41	8	0.53-0.59	13-15	1.02	26	1.70	43	1.00	25
2.3	58	12	0.93-0.97	24-25	1.31	33	2.40	61	1.37	35
3.1	79	16	1.31	33	1.51	38	3.20	81	1.75	44
3.5	89	18	1.51	38	1.66	42	3.60	91	1.94	49
3.8	97	20	1.70	43	1.77	45	3.79	96	2.13	54
4.6	117	24	2.08	53	1.92	49	4.75	121	2.60	66
5.1	130	26	2.28	58	1.96	50	5.14	131	2.73	69
6.1	155	32	2.85	72	2.20	56	6.20	155	3.30	84
<b>SERIES 1100 FLUSH GRID FRICTION TOP<sup>a</sup></b>										
1.6	41	8	0.53-0.59	13-15	1.04	27	1.61	41	1.08	27
2.3	58	12	0.93-0.97	24-25	1.30	33	2.36	60	1.46	37
3.1	79	16	1.31	33	1.55	39	3.12	79	1.84	47
3.5	89	18	1.51	38	1.66	42	3.50	89	2.03	51
3.8	97	20	1.70	43	1.77	45	3.88	98	2.22	56
4.6	117	24	2.08	53	1.97	50	4.64	118	2.60	66
5.1	130	26	2.28	58	2.06	52	5.02	127	2.79	71
6.1	155	32	2.85	72	2.25	57	6.16	157	3.36	85
<b>SERIES 1100 FLUSH GRID NUB TOP<sup>a</sup></b>										
1.6	41	8	0.53-0.59	13-15	1.04	27	1.57	40	1.05	27
2.3	58	12	0.93-0.97	24-25	1.30	33	2.32	59	1.42	36
3.1	79	16	1.31	33	1.55	39	3.08	78	1.80	46
3.5	89	18	1.51	38	1.66	42	3.46	88	1.99	51
3.8	97	20	1.70	43	1.70	43	3.84	98	2.18	55
4.6	117	24	2.08	53	1.97	50	4.60	117	2.56	65
5.1	130	26	2.28	58	2.06	52	4.98	127	2.75	70
6.1	155	32	2.85	72	2.25	57	6.13	156	3.32	84
<b>SERIES 1100 CONE TOP<sup>a</sup></b>										
1.6	41	8	0.54-0.60	14-15	1.04	26	1.66	42	1.13	29
2.3	58	12	0.93-0.97	24-25	1.30	33	2.41	61	1.50	38
3.1	79	16	1.32	34	1.55	39	3.17	81	1.88	48
3.5	89	18	1.51	38	1.66	42	3.55	90	2.07	53
3.8	97	20	1.71	43	1.70	43	3.93	100	2.26	57
4.6	117	24	2.09	53	1.96	50	4.69	119	2.64	67
5.1	127	26	2.28	58	2.05	52	5.07	129	2.83	72
6.1	155	32	2.86	73	2.24	57	6.22	158	3.41	87

a. Refer to "Anti-sag carryway wearstrip configuration" (page 322) for alternative layouts for the "B" dimension.

**Dead Plate Gap**

Where there is a transfer point from a belt without finger transfer plates to a dead plate, there should be a gap between the surfaces to allow for the chordal action of the belt. As the belt engages its sprockets, chordal action causes the modules to move past a *fixed* point (the tip of the dead plate) with *varying* clearances. The table below shows the minimum amount of gap which occurs at the “low point” of the modules if the tip of the dead plate just comes in contact with the “high point” as the modules pass.

In some installations it may be desirable to keep the tip of the dead plate in contact with the belt, rather than allow a gap to occur. This can be done by hinging the mounting bracket for the dead plate. This allows the dead plate to move as the modules pass, but results in a small oscillating motion which may present tippage problems for sensitive containers or products.



1 - Top surface of dead plate      2 - Dead plate gap

**Note:** The top surface of the dead plate is typically 0.031 in. (0.8 mm) above the belt surface for product transfer onto the belt, and 0.031 in. (0.8 mm) below the belt surface for product transfer off the belt.

Sprocket Description		Gap		
Pitch Diameter		No. Teeth	in.	mm
in.	mm			
1.6	41	8	0.058	1.5
2.3	58	12	0.040	1.0
3.1	79	16	0.029	0.7
3.5	89	18	0.026	0.7
3.8	97	20	0.024	0.6
4.6	117	24	0.020	0.5
5.1	130	26	0.018	0.4
6.1	155	32	0.015	0.4

