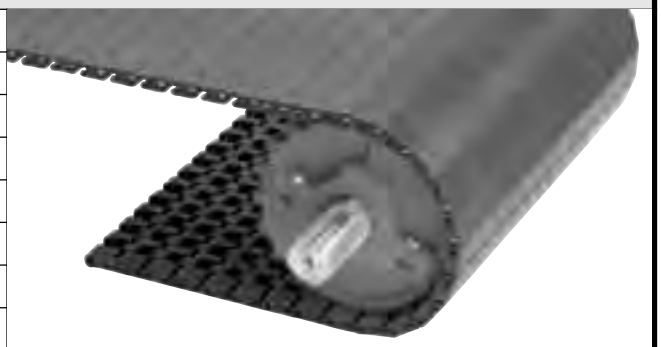
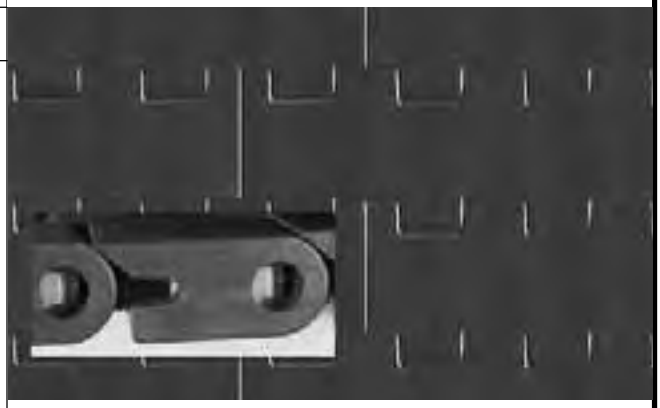
Flat Top

	in.	mm
Pitch	1.00	25.4
Minimum Width	5	127
Width Increments	1.00	25.4
Opening Size (approximate)	-	-
Open Area	0%	
Hinge Style	Closed	
Drive Method	Center/hinge-driven	



Product Notes

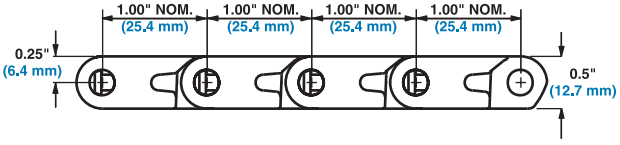
- **Always check with Customer Service for precise belt width measurement and stock status before designing a conveyor or ordering a belt.**
- Smooth, closed surface with fully flush edges.
- Robust design offers excellent belt and sprocket durability, especially in tough glass applications.
- Smooth, flat top provides excellent lateral movement of containers. Ideal for container handling.
- Most Series 1400 sprockets use the split design so shafts do not have to be removed for retrofits and change overs. The Series 1400 sprockets are all plastic.
- The Series 1400 split sprockets are designed with thick, "lug" style teeth for excellent durability and wear life.
- Utilizes SLIDELOX® rod retention system. SLIDELOX® is available in polypropylene or acetal.



Inset: SLIDELOX® Edge

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 0.24 in. (6.1 mm)	BS Belt Strength lb/ft	BS Belt Strength kg/m	Temperature Range (continuous) °F	Temperature Range (continuous) °C	W Belt Weight lb/ft²	W Belt Weight kg/m²	Agency Acceptability: 1=White, 2=Blue, 3=Natural, 4=Grey FDA (USA)	USDA Dairy[a]	CFA[b]	A[c]	J[d]	EU MC[e]
Acetal	Nylon	2500	3720	-50 to 200	-46 to 93	2.75	13.43	•				3	•
Polypropylene	Nylon	1800	2678	34 to 220	1 to 104	1.85	9.03	•				3	•
Non FDA HR Nylon	Nylon	2000	2976	-50 to 310	-46 to 154	2.23	10.89						
EC Acetal	Nylon	1600	2380	-50 to 200	-46 to 93	2.69	13.13						

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.

Mold to Width Flat Top

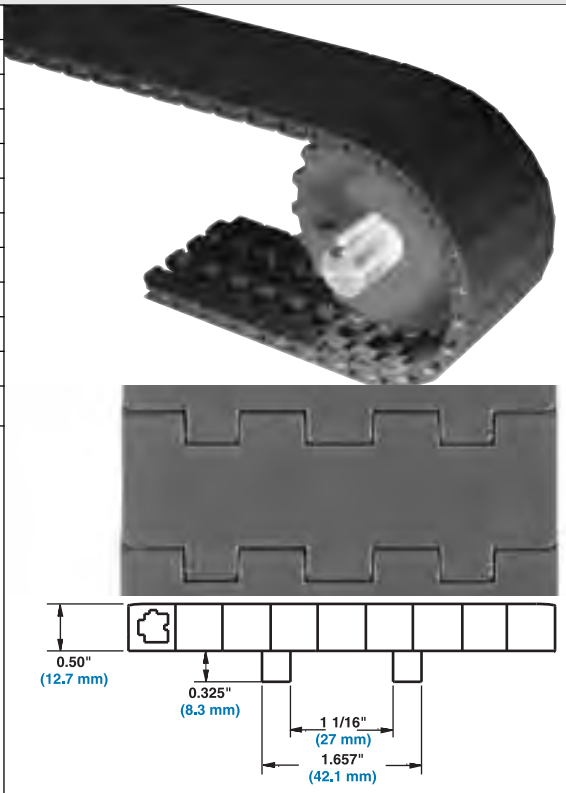
	in.	mm
Pitch	1.00	25.4
Molded Widths	3.25	83
	4.5	114
	6.0	152
	7.5	191
	-	85.0
Opening Size (approximate)	-	-
Open Area	0%	
Hinge Style	Closed	
Drive Method	Center/hinge-driven	

Product Notes

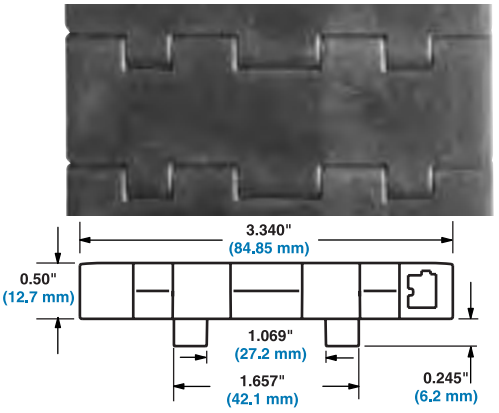
- **Always check with Customer Service for precise belt width measurement and stock status before designing a conveyor or ordering a belt.**
- Tracking tabs provide lateral tracking.
- Smooth, closed surface with fully flush edges.
- Robust design offers excellent belt and sprocket durability, especially in tough, glass applications.
- Smooth, flat top provides excellent lateral movement of containers. Ideal for container handling.
- Optional tracking tabs fit into single barreled belt wearstrip with 1.75 in. (44.5 mm) spacing.
- One sprocket can be placed on the 3.25 in. (83 mm) mold to width belt and the 4.5 in. (114 mm) tabbed mold to width belt. One or two sprockets can be placed on the 4.5 in. (114 mm) no tab mold to width belt. Up to three sprockets can be placed on the 6.0 in. (152 mm) and the 7.5 in. (191 mm) mold to width belt.
- Most Series 1400 sprockets use the split design so shafts do not have to be removed for retrofits and change overs. The Series 1400 sprockets are all plastic.
- The Series 1400 split sprockets are designed with thick, "lug" style teeth for excellent durability and wear life.
- Width tolerances for the Series 1400 Mold To Width belts are +0.000/-0.020 in. (+0.000/-0.500 mm).
- Series 1400 Mold To Width belts are boxed in 10 ft. (3.05 m) increments.
- Utilizes SLIDELOX® rod retention system. SLIDELOX® is available in polypropylene or acetal.

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)



Series 1400 Flat Top Mold to Width



Series 1400 Flat Top 85 mm Mold to Width

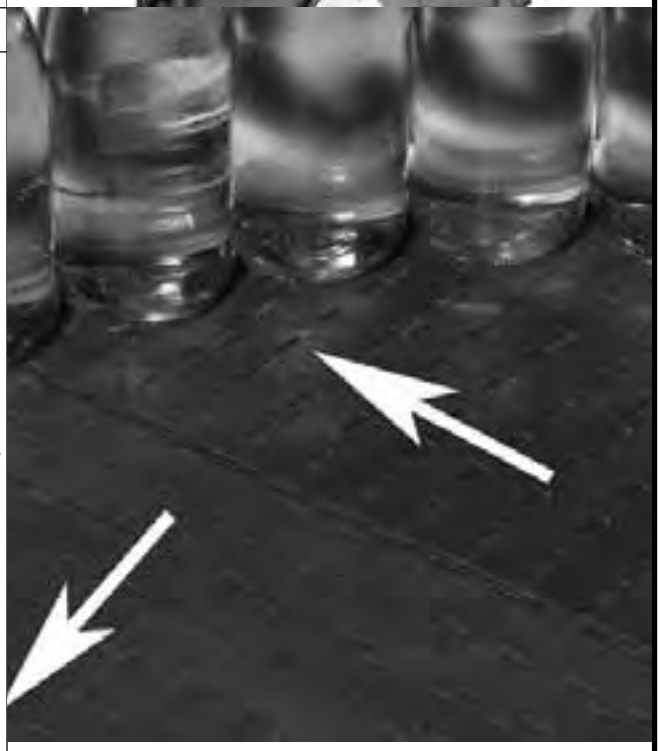
Belt Data

Belt Width		Belt Material	Standard Rod Material Ø 0.24 in. (6.1 mm)	BS Belt Strength[a]		Temperature Range (continuous)		W Belt Weight				Agency Acceptability: 1=White, 2=Blue, 3=Natural, 4=Grey		
								Tab		No Tab				
inch	mm			lb	kg	°F	°C	lb/ft	kg/m	lb/ft	kg/m	FDA (USA)	J[b]	EU MC[c]
3.25	83	Acetal	Nylon	700	318	-50 to 200	-46 to 93	0.80	1.19	0.75	1.12	•	3	•
4.5	114	Acetal	Nylon	850	386	-50 to 200	-46 to 93	1.13	1.68	1.07	1.59	•	3	•
6.0	152	Acetal	Nylon	1200	544	-50 to 200	-46 to 93	1.40	2.08	1.35	2.01	•	3	•
6.0	152	Polypropylene	Nylon	850	386	34 to 220	1 to 104	0.95	1.14	0.90	1.34	•	3	•
7.5	191	Acetal	Nylon	1550	703	-50 to 200	-46 to 93	1.75	2.60	1.71	2.54	•	3	•
	85	Acetal	Nylon	700	318	-50 to 200	-46 to 93	0.80	1.19	-	-	•	3	•

a. Rating are based on non-tabbed belts using the maximum number of sprockets.
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.

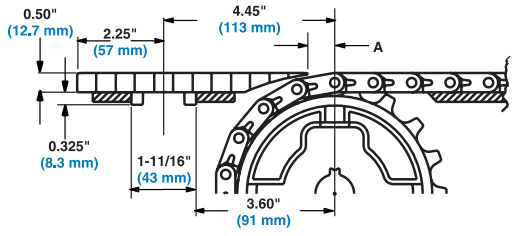
ONEPIECE™ Live Transfer Flat Top

	in.	mm
Pitch	1.00	25.4
Molded Width	6	152
Width Increments	-	-
Open Area	0%	
Hinge Style	Closed	
Drive Method	Center/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.
- Transfer edge is an integral part of this belt, designed for smooth, self-clearing, right angle transfers onto takeaway belts.
- Smooth, flat top surface with fully flush edges provides excellent lateral movement of containers, especially PET and glass.
- Built with nylon rods for superior wear resistance. Utilizes SLIDELOX® rod retention system. SLIDELOX® is available in polypropylene or acetal.
- Robust design offers excellent belt and sprocket durability, especially in tough, glass applications.
- Molded with robust tracking tabs to support belt in heavy, side-loading applications.
- When product is moving from the transfer belt to a takeaway belt, the top of the transfer belt should be no more than 0.06 in. (1.5 mm) above the top of the takeaway belt. When product is moving from the infeed belt onto the transfer belt, the top of the belts should be level.
- 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 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)
- Most Series 1400 sprockets use the split design so shafts do not have to be removed for retrofits and change overs. The Series 1400 sprockets are all plastic.
- The Series 1400 split sprockets are designed with thick, "lug" style teeth for excellent durability and wear life.
- Series 1400 Live Transfer belts are boxed in 10 ft. (3.05 m) increments.



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)
- See *"90° CONTAINER TRANSFERS"* (page 335)

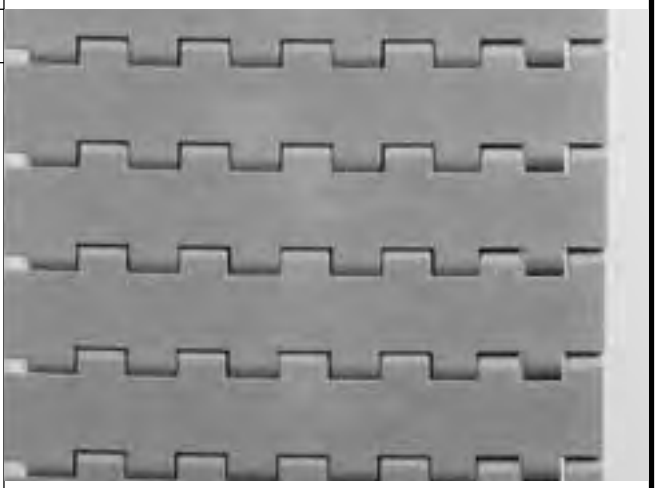
Belt Data

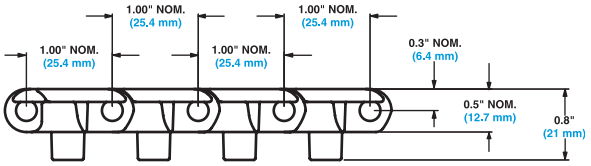
Belt Material	Standard Rod Material Ø 0.24 in. (6.1 mm)	BS Belt Strength		Temperature Range (continuous)		W Belt Weight		Agency Acceptability: 1=White, 2=Blue, 3=Natural, 4=Grey		
		lb	kg	°F	°C	lb/ft	kg/m	FDA (USA)	J[a]	EU MC[b]
Acetal	Nylon	850	386	-50 to 200	-46 to 93	1.25	1.86	•	3	•

a. Japan Ministry of Health, Labour, and Welfare
b. European Migration Certificate providing approval for food contact according to EU Directive 2002/72/EC and all its amendments to date.

6” Flat Top MTW Self-Clearing Edge

	in.	mm
Pitch	1.00	25.4
Minimum Width	6	152
Width Increments	-	-
Opening Sizes (approx.)	-	-
Open Area	0%	
Hinge Style	Closed	
Drive Method	Center/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.**
- Fully flush edges with headed rod retention.
- Robust design offers excellent belt and sprocket durability, especially in tough, material handling applications.
- Most Series 1400 sprockets use the split design so shafts do not have to be removed for retrofits and change overs. All Series 1400 sprockets are plastic.
- 100% self-clearing transfers of all container types, including energy drink cans, when used in conjunction with finger transfer plate.
- Belt is bidirectional, It can perform left- and right-hand transfers.

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)

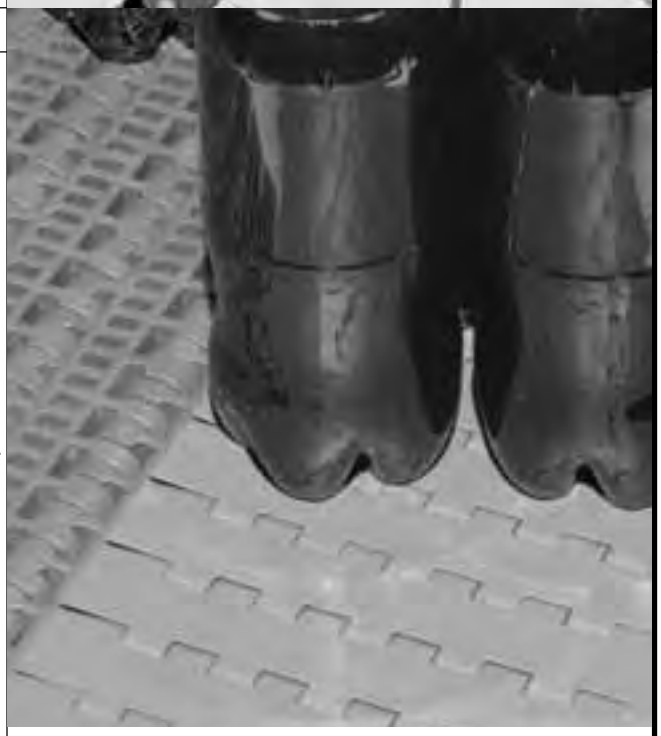
Belt Data

Belt Material	Standard Rod Material Ø 0.24 in. (6.1 mm)	BS Belt Strength lb	BS Belt Strength kg	Temperature Range (continuous) °F	Temperature Range (continuous) °C	W Belt Weight lb/ft	W Belt Weight kg/m	Agency Acceptability 1 = White, 2 = Blue, 3 = Natural, 4 = Grey FDA (USA)	USDA Dairy[a]	CFA[b]	A[c]	J[d]	EU MC[e]
Acetal	Nylon	1000	454	-50 to 200	-46 to 93	1.08	1.61						

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.

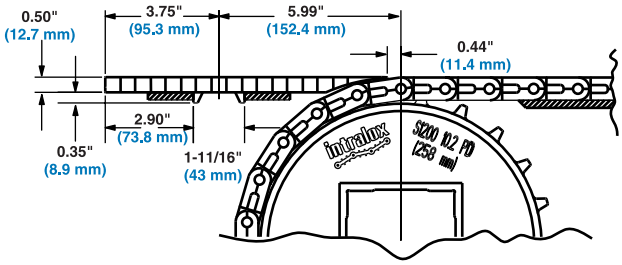
ONEPIECE™ 9.3 in. (236 mm) Live Transfer Flat Top

	in.	mm
Pitch	1.00	25.4
Molded Width	9.3	236
Width Increments	-	-
Open Area	0%	
Hinge Style	Closed	
Drive Method	Center/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.
- Transfer edge is an integral part of this belt, designed for smooth, self-clearing, right angle transfers onto takeaway belts.
- Smooth, flat top surface with fully flush edges provides excellent lateral movement of containers, especially PET and glass.
- Built with nylon rods for superior wear resistance. Utilizes SLIDELOX® rod retention system. SLIDELOX® is available in polypropylene or acetal.
- Robust design offers excellent belt and sprocket durability, especially in tough, glass applications.
- Molded with robust tracking tabs to support belt in heavy, side-loading applications. Tab height is 0.35 in. (8.9 mm). Tab spacing is 1 11/16 in. (43 mm).
- When product is moving from the transfer belt to a takeaway belt, the top of the transfer belt should be no more than 0.06 in. (1.5 mm) above the top of the takeaway belt. When product is moving from the infeed belt onto the transfer belt, the top of the belts should be level.
- 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 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).
- Most Series 1400 sprockets use the split design so shafts do not have to be removed for retrofits and change overs. The Series 1400 sprockets are all plastic.
- The Series 1400 split sprockets are designed with thick, "lug" style teeth for excellent durability and wear life.
- Series 1400 Live Transfer belts are boxed in 10 ft. (3.05 m) increments.



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)
- See *"90° CONTAINER TRANSFERS"* (page 335)

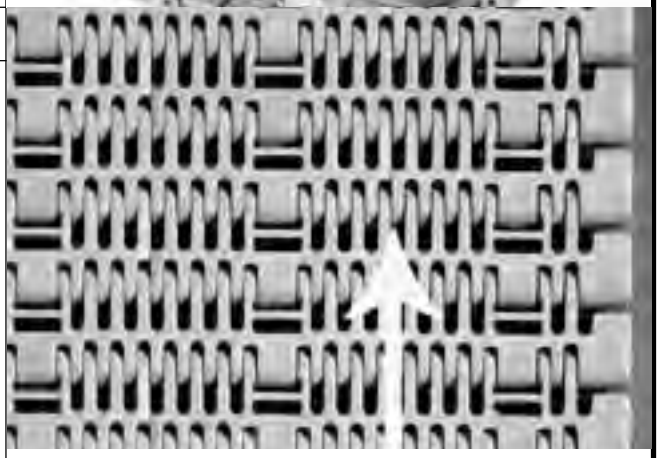
Belt Data

Belt Material	Standard Rod Material Ø 0.24 in. (6.1 mm)	BS Belt Strength		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)	J[a]	EU MC[b]
Acetal	Nylon	1550	703	-50 to 200	-46 to 93	1.86	2.77	•	3	•

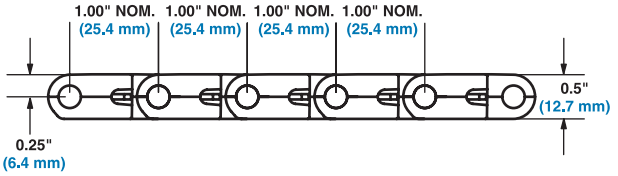
a. Japan Ministry of Health, Labour, and Welfare
b. European Migration Certificate providing approval for food contact according to EU Directive 2002/72/EC and all its amendments to date.

Flush Grid

	in.	mm
Pitch	1.0	25.4
Minimum Width	9	229
Width Increments	1.0	25.4
Opening Size (approx.)	0.17 × 0.30	4.2 × 7.6
Open Area	21%	
Hinge Style	Closed	
Drive Method	Center/Hinge-driven	



Arrow indicates run direction



Product Notes

- **Always check with Customer Service for precise belt width measurement and stock status before designing a conveyor or ordering a belt.**
- Headless rod retention system allows re-use of rods.
- Utilizes SLIDELOX® rod retention system. SLIDELOX® is available in polypropylene or acetal.
- Polypropylene belts are grey with blue PP SLIDELOX®. Acetal belts are grey with yellow AC SLIDELOX®.
- Installation is the same as current Series 1400 belts with the addition of a locked sprocket location chart and preferred run direction.
- Minimum sprocket spacing is 3 inches (76.2 mm) and is recommended for an adjusted belt pull greater than 900 lb/ft (1339 kg/m). Maximum recommended sprocket spacing is 6 inches (152.4 mm).
- Fully flush edges with SLIDELOX® closures.

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)

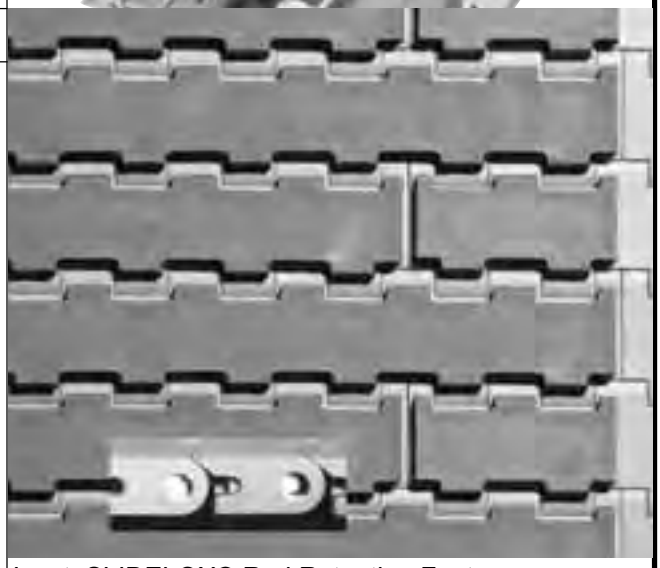
Belt Data

Belt Material	Standard Rod Material Ø 0.24 in. (6.1 mm)	BS Belt Strength[a]		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[b]	CFA[c]	A[d]	J[e]	Z[f]	EU MC[g]
Polypropylene	Polypropylene	1800	2679	34 to 220	1 to 104	1.61	7.86	•				3		•
Polypropylene	Nylon	1800	2679	34 to 220	1 to 104	1.66	8.10	•				3		•
Acetal	Nylon	2500	3720	-50 to 200	-46 to 93	2.52	12.30	•				3		•

a. Belt strength is divided by 2 when using 6 inch sprocket spacing; full strength when using 3 inch sprocket spacing.
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.

Intralox® Flat Friction Top

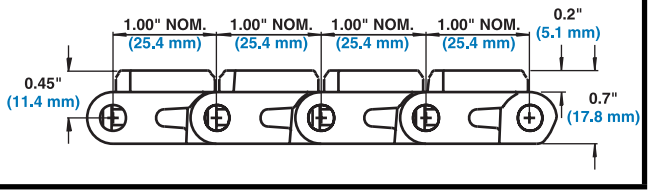
	in.	mm
Pitch	1.00	25.4
Minimum Width (FFT)	6	152
Minimum Width (FFT Ultra)	6	152
Width Increments	1.00	25.4
Hinge Style	Closed	
Drive Method	Center/Hinge-driven	



Inset: SLIDELOX® Rod Retention Feature

Product Notes

- **Always check with Customer Service for precise belt width measurement and stock status before designing a conveyor or ordering a belt.**
- Fully flush edges with SLIDELOX® rod retention feature. SLIDELOX® is available in polypropylene or acetal.
- Robust design offers excellent belt and sprocket durability, especially in tough, material handling applications.
- Standard indents for friction top surface are 2 in. (51 mm) and 0.22 in. (6 mm).
- Most Series 1400 sprockets use the split design so shafts do not have to be removed for retrofits and change overs.
- Friction top available in grey PP with grey rubber, grey PP with black rubber and white PP with white rubber.
- Grey rubber has a hardness of 64 shore A. White and black rubber have a hardness of 55 Shore A.
- White and Black Rubber are FDA approved.
- 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.
- 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.



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)

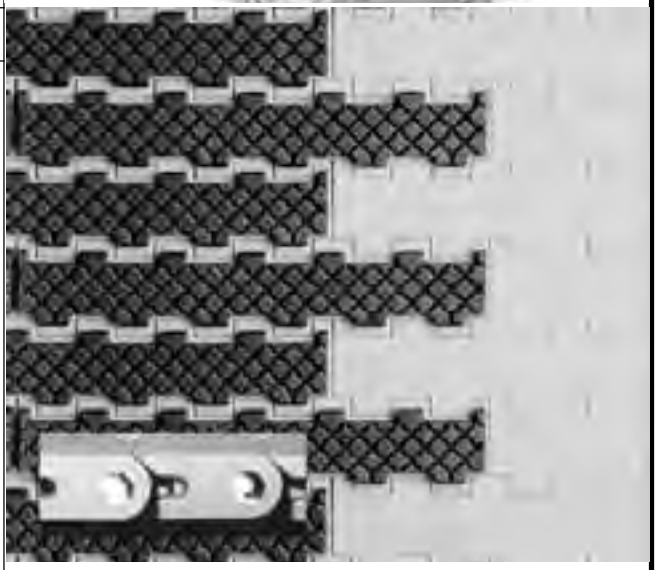
Belt Data

Belt Material	Standard Rod Material Ø 0.24 in. (6.1 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)	J[a]	EU MC[b]
Polypropylene (FFT)	Nylon	1800	2678	34 to 150	1 to 66	2.24	10.94	1		
Polypropylene (FFT Ultra)	Nylon	1800	2678	34 to 150	1 to 66	2.62	12.79	1		
Polyethylene (FFT)	Nylon	1000	1488	-50 to 120	-46 to 49	2.33	11.38			
Polyethylene (FFT Ultra)	Nylon	1000	1488	-50 to 120	-46 to 49	2.70	13.18			

a. Japan Ministry of Health, Labour, and Welfare
b. European Migration Certificate providing approval for food contact according to EU Directive 2002/72/EC and all its amendments to date.

Square Friction Top

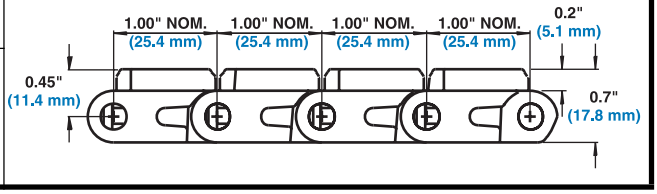
	in.	mm
Pitch	1.00	25.4
Minimum Width (SFT)	6	152
Minimum Width (SFT Ultra)	6	152
Width Increments	1.00	25.4
Hinge Style	Closed	
Drive Method	Center/hinge-driven	



Inset: SLIDELOX® Rod Retention Feature

Product Notes

- **Always check with Customer Service for precise belt width measurement and stock status before designing a conveyor or ordering a belt.**
- Fully flush edges with SLIDELOX® rod retention feature. SLIDELOX® is available in polypropylene or acetal.
- Robust design offers excellent belt and sprocket durability, especially in tough, material handling applications.
- Most Series 1400 sprockets use the split design so shafts do not have to be removed for retrofits and change overs. The Series 1400 sprockets are all plastic.
- Available with black rubber on grey polypropylene or black polyethlyene.
- Black rubber has a hardness of 45 shore A.
- Minimum indent is 2 in. (50.8 mm).
- 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.
- 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.



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 0.24 in. (6.1 mm)	BS Belt Strength lb/ft	BS Belt Strength kg/m	Temperature Range (continuous) °F	Temperature Range (continuous) °C	W Belt Weight lb/ft²	W Belt Weight kg/m²	Agency Acceptability: 1=White, 2=Blue, 3=Natural, 4=Grey FDA (USA)	Agency Acceptability: 1=White, 2=Blue, 3=Natural, 4=Grey J[a]	Agency Acceptability: 1=White, 2=Blue, 3=Natural, 4=Grey EU MC[b]
Polypropylene (SFT)	Nylon	1800	2678	34 to 150	1 to 66	2.21	13.43			
Polypropylene (SFT Ultra)	Nylon	1800	2678	34 to 150	1 to 66	2.60	12.69			
Polyethylene (SFT)	Nylon	1000	1488	-50 to 120	-46 to 49	2.32	11.31			
Polyethylene (SFT Ultra)	Nylon	1000	1488	-50 to 120	-46 to 49	2.68	13.08			

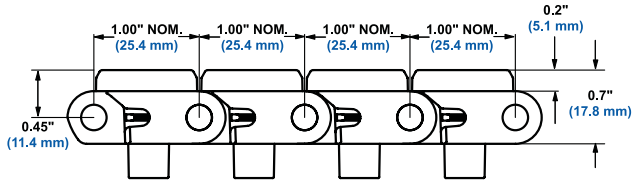
a. Japan Ministry of Health, Labour, and Welfare
b. European Migration Certificate providing approval for food contact according to EU Directive 2002/72/EC and all its amendments to date.

3.25 in. MTW Flat Friction Top w/Tabs

	in.	mm
Pitch	1.00	25.4
Molded Width	3.25	83
Opening Sizes (approx.)	-	-
Open Area	0%	
Hinge Style	Closed	
Drive Method	Center/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.**
- Not recommended for back-up conditions. If friction values between product and belt are required, contact Intralox Sales Engineering.
- Tracking tabs provide lateral tracking.
- Fully flush edges with SLIDELOX™ rod retention feature.
- Robust design offers excellent belt and sprocket durability, especially in tough, material handling applications.
- Available with black rubber on blue acetal.
- Black rubber has a hardness of 54 Shore A.
- Indent for Friction Top surface is 0.5 in. (12.7 mm).
- One sprocket can be placed on the 3.25 in (83 mm) Mold To Width tabbed belt.
- Width tolerances for the Series 1400 Mold to Width belts are +0.000/-0.020 in. (+0.000/-0.500 mm).
- Most Series 1400 sprockets use the split design so shafts do not have to be removed for retrofits and change overs. The Series 1400 sprockets are all plastic.
- Series 1400 Mold to Width belts are boxed in 10 ft. (3.05 m) increments.
- 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.



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 0.24 in. (6.1 mm)	BS Belt Strength		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[a]	CFA[b]	A[c]	J[d]	EU MC[e]
Acetal	Nylon	700	318	-10 to 130	-23 to 54	0.94	1.40						

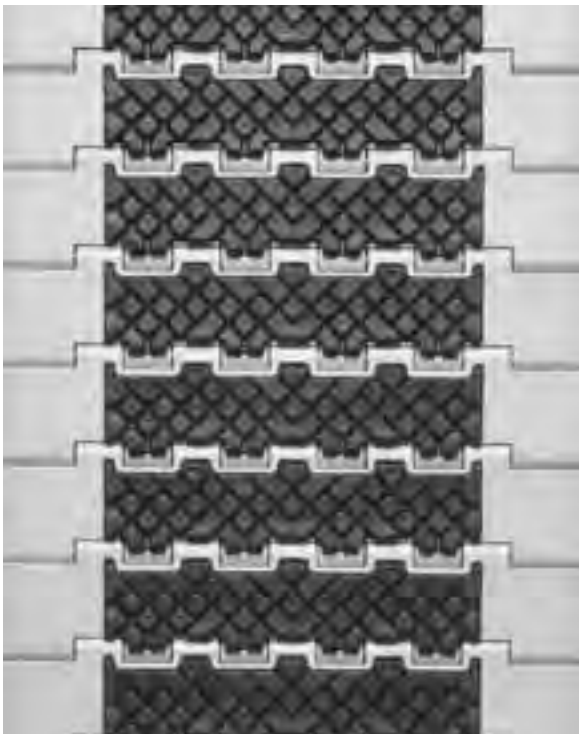
a. USDA Dairy acceptance requires the use of a clean-in-place-system.
b. Canada Food Inspection Agency
c. Australian Quarantine Inspection Service
d. Japan Ministry of Health, Labour, and Welfare
e. European Migration Certificate providing approval for food contact according to EU Directive 2002/72/EC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

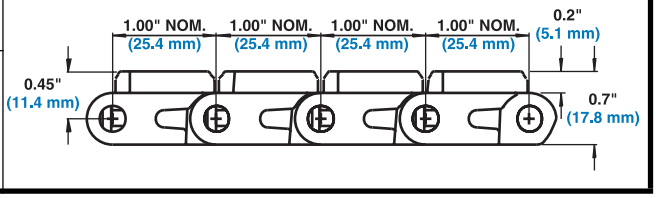
Mold to Width Square Friction Top

	in.	mm
Pitch	1.00	25.4
Molded Width (SFT Ultra)	6	152
Open Area	0%	
Hinge Style	Closed	
Drive Method	Center/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.**
- Fully flush edges with SLIDELOX® rod retention feature. SLIDELOX® is available in polypropylene or acetal.
- Robust design offers excellent belt and sprocket durability, especially in tough, material handling applications.
- Most Series 1400 sprockets use the split design so shafts do not have to be removed for retrofits and change overs. The Series 1400 sprockets are all plastic.
- Available with black or grey rubber on grey polypropylene.
- Black rubber has a hardness of 45 shore A. Grey rubber has a hardness of 64 shore A.
- Rubber indent is 1 in. (25.4 mm).
- 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.
- 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.
- Up to three sprockets can be placed on the 6.0 in. (152 mm) mold to width belt.
- Width tolerances for the Series 1400 Mold To Width belts are +0.000/-0.020 in. (+0.000/-0.500 mm).
- Series 1400 Mold To Width belts are boxed in 10 ft. (3.05 m) increments.





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)

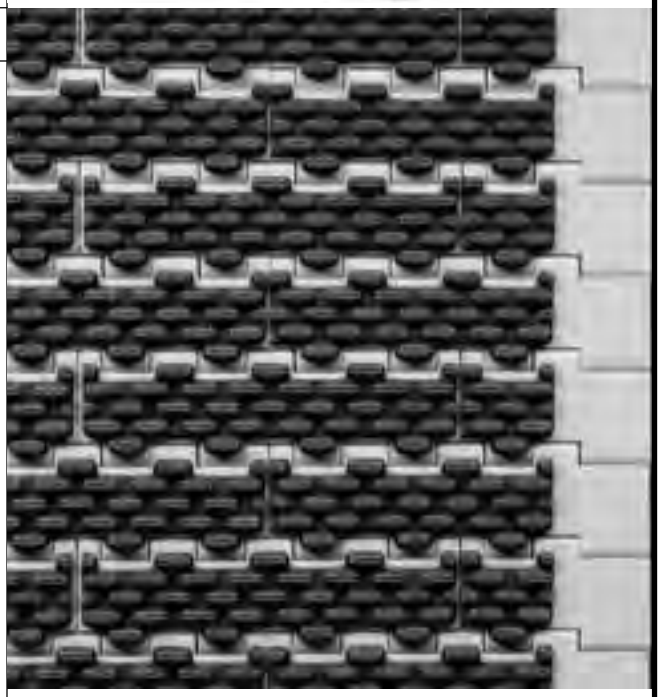
Belt Data

Belt Material	Standard Rod Material Ø 0.24 in. (6.1 mm)	BS Belt Strength		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)	J[a]	EU MC[b]
Polypropylene (SFT Ultra)	Nylon	800	386	34 to 150	1 to 66	1.15	1.71			

a. Japan Ministry of Health, Labour, and Welfare
b. European Migration Certificate providing approval for food contact according to EU Directive 2002/72/EC and all its amendments to date.

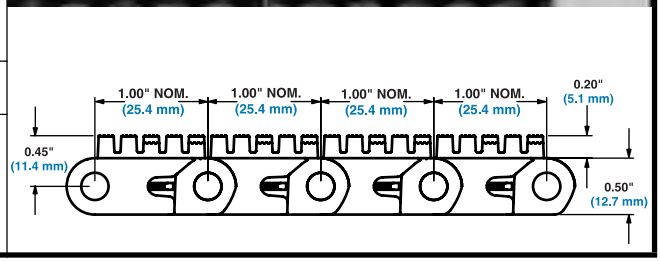
Oval Friction Top

	in.	mm
Pitch	1.00	25.4
Minimum Width	6	152
Width Increments	1.00	25.4
Open Area	0%	
Hinge Style	Closed	
Drive Method	Center/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.**
- Fully flush edges with SLIDELOX® rod retention feature. SLIDELOX® is available in polypropylene or acetal.
- Robust design offers excellent belt and sprocket durability, especially in tough, material handling applications.
- Most Series 1400 sprockets use the split design so shafts do not have to be removed for retrofits and change overs. The Series 1400 sprockets are all plastic.
- Available with black rubber on grey polypropylene.
- Black rubber has a hardness of 55 shore A.
- Rubber indent is 1 in. (25.4 mm).
- 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.
- 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.



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)

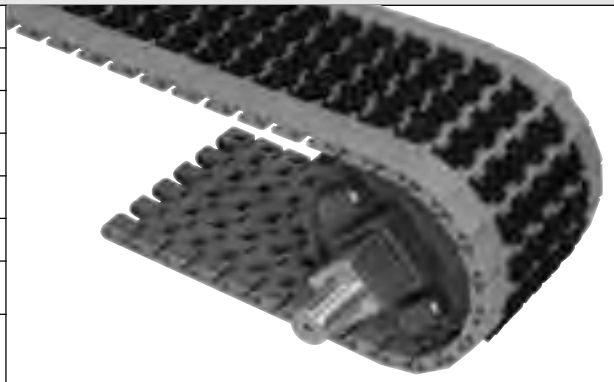
Belt Data

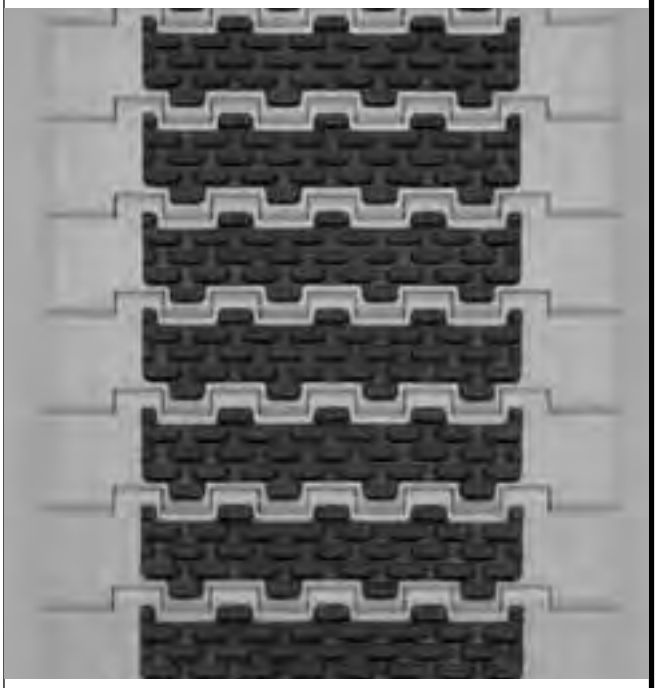
Belt Material	Standard Rod Material Ø 0.24 in. (6.1 mm)	BS Belt Strength		Temperature Range (continuous)		W Belt Weight		Agency Acceptability: 1=White, 2=Blue, 3=Natural, 4=Grey		
		lb/ft	kg/m	°F	°C	lb/ft²	kg/m²	FDA (USA)	J[a]	EU MC[b]
Polypropylene	Nylon	1800	2678	34 to 150	1 to 66	2.29	11.18	•		

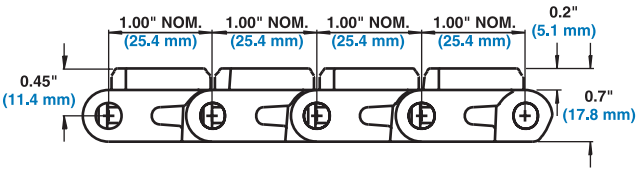
a. Japan Ministry of Health, Labour, and Welfare
b. European Migration Certificate providing approval for food contact according to EU Directive 2002/72/EC and all its amendments to date.

Mold to Width Oval Friction Top

	in.	mm
Pitch	1.00	25.4
Molded Width (SFT Ultra)	6	152
Open Area	0%	
Hinge Style	Closed	
Drive Method	Center/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.**
- Fully flush edges with SLIDELOX® rod retention feature. SLIDELOX® is available in polypropylene or acetal.
- Robust design offers excellent belt and sprocket durability, especially in tough, material handling applications.
- Most Series 1400 sprockets use the split design so shafts do not have to be removed for retrofits and change overs. The Series 1400 sprockets are all plastic.
- Available with black rubber on grey polypropylene.
- Black rubber has a hardness of 55 shore A.
- Rubber indent is 1 in. (25.4 mm).
- 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.
- 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.
- Up to three sprockets can be placed on the 6.0 in. (152 mm) mold to width belt.
- Width tolerances for the Series 1400 Mold To Width belts are +0.000/-0.020 in. (+0.000/-0.500 mm).
- Series 1400 Mold To Width belts are boxed in 10 ft. (3.05 m) increments.

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 0.24 in. (6.1 mm)	BS Belt Strength		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)	J[a]	EU MC[b]
Polypropylene (OFT Ultra)	Nylon	800	386	34 to 150	1 to 66	1.15	1.71	•		

a. Japan Ministry of Health, Labour, and Welfare
b. European Migration Certificate providing approval for food contact according to EU Directive 2002/72/EC and all its amendments to date.

Roller Top™

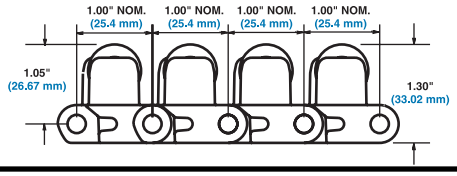
	in.	mm
Pitch	1.00	25.4
Minimum Width	5	127
Width Increments	1.00	25.4
Roller Diameter	0.70	17.8
Roller Length	0.83	21.0
Open Area	0%	
Hinge Style	Closed	
Drive Method	Center/hinge-driven	

Product Notes

- **Always check with Customer Service for precise belt width measurement and stock status before designing a conveyor or ordering a belt.**
- Allows low back pressure accumulation for gentle product handling.
- 144 rollers per square foot of belt provide greater product-to-roller contact.
- Standard roller indent is 0.75 in. (19 mm)
- 1 in. (25.4 mm) roller spacing.
- Available in white and grey acetal.
- Stainless steel roller axle pins for durability.
- Robust design offers excellent belt and sprocket durability.
- SLIDELOX® flush edges. SLIDELOX® is available in polypropylene or acetal.
- Back-up load is 5-10% of product weight.

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)



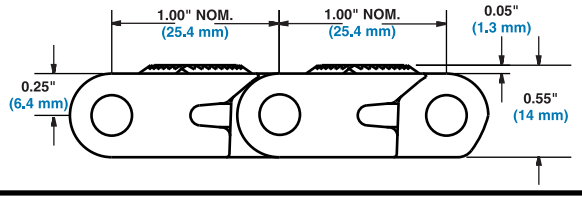
Belt Data

Belt Material	Standard Rod Material Ø 0.24 in. (6.1 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)	J[a]	EU MC[b]
Acetal	Nylon	2500	3720	-50 to 200	-46 to 93	5.83	28.47	•	3	•

a. Japan Ministry of Health, Labour, and Welfare
b. European Migration Certificate providing approval for food contact according to EU Directive 2002/72/EC and all its amendments to date.

Non Skid

	in.	mm
Pitch	1.00	25.4
Minimum Width	9	229
Width Increments	1.00	25.4
Opening Size (approx.)	-	-
Open Area	0%	
Hinge Style	Closed	
Drive Method	Center/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.**
- Robust design offers excellent belt and sprocket durability.
- SLIDELOX® rod retention system. SLIDELOX® is available in polypropylene or acetal.
- 1.00 (25.4 mm) pitch accommodates small drive sprockets for low-profile people carriers.
- Diamond tread pattern provides a non-skid walking surface to increase safety.
- Staggered yellow edges make it easy to distinguish the moving belt from the stationary floor.
- Edges have Flat Top surface (no treads).

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)

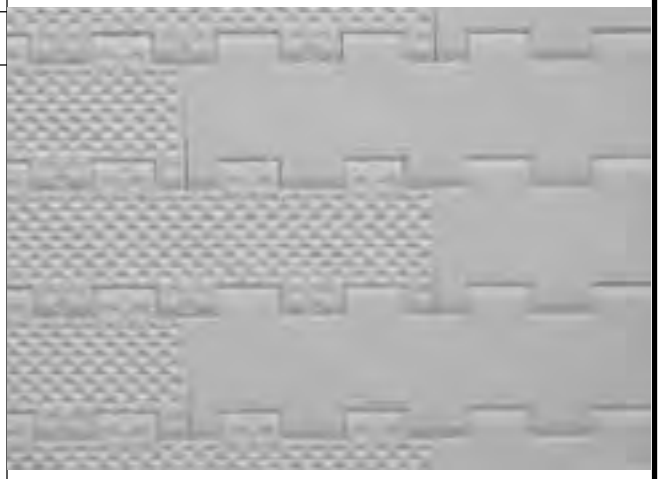
Belt Data

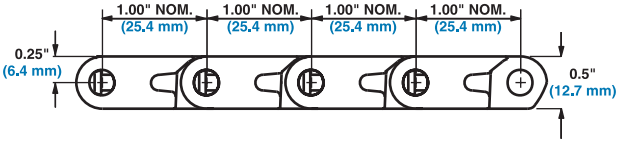
Belt Material	Standard Rod Material Ø 0.24 in. (6.1 mm)	BS Belt Strength		Temperature Range (continuous)		W Belt Weight		Agency Acceptability: 1=White, 2=Blue, 3=Natural, 4=Grey						
		lb/ft	kg/m	°F	°C	lb/ft²	kg/m²	FDA (USA)	USDA Dairy[a]	CFA[b]	A[c]	J[d]	Z[e]	EU MC[f]
HS EC Acetal	Nylon	1875	2790	-50 to 200	-46 to 93	2.78	13.57					3		•
Polypropylene	Nylon	1800	2678	34 to 220	1 to 104	2.32	11.33	•				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.

Embedded Diamond Top

	in.	mm
Pitch	1.00	25.4
MInimum Width	12.0	304.8
Opening Sizes (approx.)	-	-
Open Area	0%	
Hinge Style	Closed	
Drive Method	Center/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.
- Minimum 2 inch (51 mm) Flat Top indent from flush edge.
- Smooth, closed surface with fully flush edges.
- Robust design offers excellent belt and sprocket durability.
- Most Series 1400 sprockets use the split design so shafts do not have to be removed for retrofits and change overs.
- Series 1400 split sprockets are designed with thick, “lug” style teeth for excellent durability and wear life.
- Utilizes SLIDELOX® rod retention system.

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 0.24 in. (6.1 mm)	BS Belt Strength lb/ft	BS Belt Strength kg/m	Temperature Range (continuous) °F	Temperature Range (continuous) °C	W Belt Weight lb/ft²	W Belt Weight kg/m²	Agency Acceptability 1=White, 2=Blue, 3=Natural, 4=Grey FDA (USA)	USDA Dairy[a]	CFA[b]	A[c]	J[d]	Z[e]	EU MC[f]
Polypropylene	Nylon	1800	2678	34 to 220	1 to 104	1.70	8.30	•				3		•

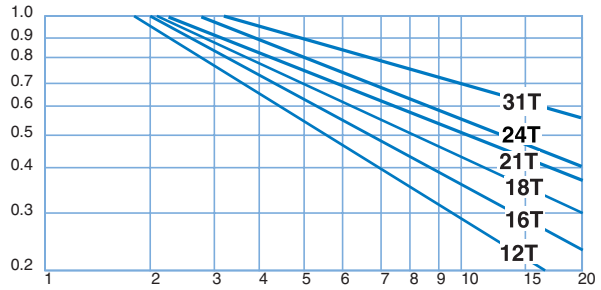
a. USDA Dairy acceptance requires the use of a clean-in-place system.
b. Canada Food Inspection Agency
c. Australian Quarantine Inspection Service
d. Japan Ministry of Health, Labour, and Welfare
e. MAF-New Zealand Ministry of Agriculture and Forestry. MAF acceptance requires the use of a clean-in-place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

Sprocket and Support Quantity Reference

Belt Width Range[a]		**Minimum** Number of Sprockets Per Shaft[b]	Wearstrips	
in.	mm		Carryway	Returnway
5	127	2	2	2
6	152	2	2	2
7	178	2	3	2
8	203	2	3	2
10	254	2	3	2
12	305	3	3	2
14	356	3	4	3
16	406	3	4	3
18	457	3	4	3
20	508	5	5	3
24	610	5	5	3
30	762	5	6	4
32	813	7	7	4
36	914	7	7	4
42	1067	7	8	5
48	1219	9	9	5
54	1372	9	10	6
60	1524	11	11	6
72	1829	12	13	7
84	2134	15	15	8
96	2438	17	17	9
For Other Widths, Use Odd Number of Sprockets[c] at Maximum 6 in. (152 mm) ℄ Spacing			Maximum 6 in. (152 mm) ℄ Spacing	Maximum 12 in. (305 mm) ℄ Spacing

a. 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 5 in. (127 mm). **If the actual width is critical, consult Customer Service.**
b. These are the minimum number of sprockets. Additional sprockets may be required for heavily loaded applications.
c. 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. For Flush Grid, see Locked Sprocket Location chart in the Installation Instruction Guidelines or call Customer Service for lock down location.

S Strength Factor

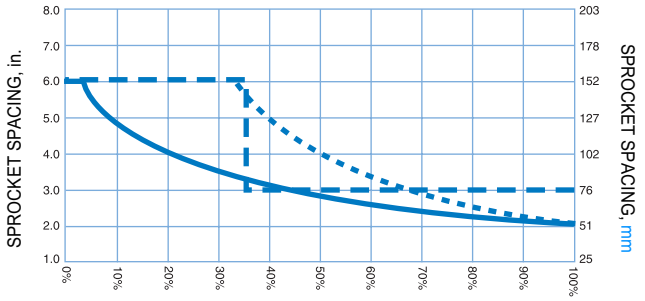


SPEED/LENGTH RATIO (V/L)

V = ft/min (m/min)
T = number of teeth
L = ft (m)

Divide belt speed "V" by the shaft ℄ distance "L". Strength Factor is found at intersection of speed/length ratio and appropriate sprocket line. See page 36 for more information.

Sprocket Spacing as a Function of Belt Strength Utilized



PERCENT OF ALLOWABLE BELT STRENGTH UTILIZED, %

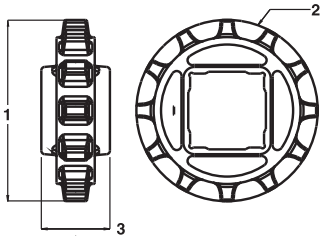
Solid line: All other styles

Long dash line: Flush grid

Short dash line: Round bores

Plastic Sprocket Data[a]

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%)	3.9	99	3.9	99	1.5	38	-	1.5	-	40
18 (1.52%)	5.7	145	5.8	148	1.5	38	2	2.5	50	60
24 (0.86%)	7.7	196	7.8	198	1.5	38		2.5		60



1 - Pitch diameter
2 - Outer diameter
3 - Hub width

a. **Contact Customer Service for lead times.**

Maximum Belt Rating for Glass Filled Nylon Round Bore Split Sprockets Based on Round Bore Size Range[a]

No. of Teeth	Nom. Pitch Diameter		1 in. - 1-3/16 in.		1-1/4 in. - 1-3/8 in.		1-7/16 in. - 1-3/4 in.		1-13/16 in. - 2 in.		25 mm - 35 mm		40 mm - 50 mm	
	in.	mm	lb/ft	kg/m	lb/ft	kg/m	lb/ft	kg/m	lb/ft	kg/m	lb/ft	kg/m	lb/ft	kg/m
16	5.1	130	1500	2232	1740	2589	2100	3125	2160	3214	1140	1697	2160	3214
18	5.7	145	1800	2679	2040	3036	2400	3572	3240	4822	1440	2143	2460	3661
21	6.7	170	1350	2009	1650	2455	2100	3125	3000	4464	1050	1563	2400	3572

a. The belt rating based on round bore sprocket size is used to determine sprocket spacing as a function of belt strength utilized. It may also be used for all other calcuations. However, if the rating for the belt material and belt style is lower then the belt rating based on the round bore sprocket size, then the lower rating should be used for all calculations other than sprocket spacing.

Glass Filled Nylon Split Sprocket Data[a]

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.[b]	Square in.	Round mm[b]	Square mm
16 (1.92%)	5.1	130	5.2	132	2.0	51	1 to 2 in 1/16 increments	1.5	25 to 50 in 5 increments	40
18 (1.52%)	5.7	145	5.8	148	2.0	51	1 to 2 in 1/16 increments	1.5	25 to 50 in 5 increments	40
								2.5		60
21 (1.12%)	6.7	170	6.8	172	2.0	51	1 to 2 in 1/16 increments[c]	1.5	25 to 50 in 5 increments	40
								2.5		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.
c. Tight fit round bores are available in 1-1/4, 1-3/16, 1-1/2, and 1-7/16 in.

Natural FDA Nylon Split Sprocket Data[a]

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.[b]	Square in.	Round mm[b]	Square mm
16 (1.92%)	5.1	130	5.2	132	1.5	38	1.25	1.5		
18 (1.52%)	5.7	145	5.8	148	1.5	38	1.25	1.5		

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.

Polypropylene Composite Split Sprocket Data[a]

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.[b]	Square in.	Round mm[b]	Square mm
18 (1.52%)	5.7	145	5.8	148	2.0	51		1.5		40
								2.5		60
21 (1.12%)	6.7	170	6.8	172	2.0	51		1.5		40
								2.5		

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.

Polyurethane Composite Split Sprocket Data[a]

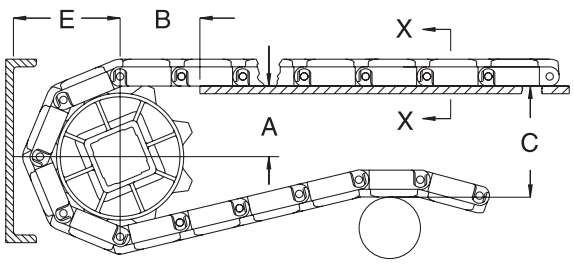
No. of Teeth (Chordal Action)	Nom. Pitch Dia. in.	Nom. Pitch Dia. mm	Nom. Outer Dia. in.	Nom. Outer Dia. mm	Nom. Hub Width in.	Nom. Hub Width mm	Available Bore Sizes			
							U.S. Sizes		Metric Sizes	
							Round in.	Square in.	Round mm	Square mm
31 (0.51%)	9.9	251	10.1	257	1.50	38		3.5		
					1.67	44		2.5[b]		

a. **Contact Customer Service for lead times.**
b. The 2.5" square bore is created by using a bore adapter in the 3.5" square bore sprocket.

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.



A - ±0.031" (1 mm)
B - ±0.125" (3 mm)
C - ± (Max)
E - ± (Min)

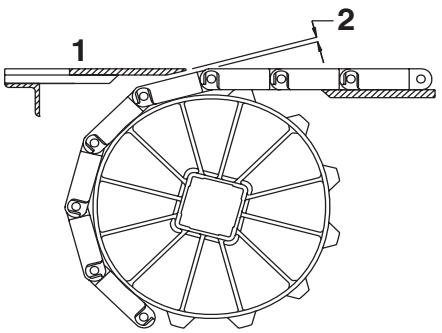
Complete descriptions of the dimensions are listed on page 317.

Sprocket Description			A		B		C		E	
Pitch Diameter		No. Teeth	Range (Bottom to Top)		in.	mm	in.	mm	in.	mm
in.	mm		in.	mm						
SERIES 1400 FLAT TOP, FLUSH GRID, EMBEDDED DIAMOND TOP										
3.9	99	12	1.62-1.68	41-43	1.80	46	3.86	98	2.24	57
5.1	130	16	2.26-2.32	57-59	2.11	54	5.13	130	2.88	73
5.7	145	18	2.59-2.63	66-67	2.22	56	5.76	146	3.19	81
6.7	170	21	3.07-3.10	78-79	2.44	62	6.71	170	3.75	95
7.7	196	24	3.55-3.58	90-91	2.64	67	7.66	195	4.14	105
9.9	251	31	4.67	119	3.07	78	9.88	251	5.25	133
SERIES 1400 FLAT FRICTION TOP, SQUARE FRICTION TOP, OVAL FRICTION TOP										
3.9	99	12	1.62-1.68	41-43	1.80	46	4.06	103	2.44	62
5.1	130	16	2.26-2.31	57-59	2.11	54	5.33	135	3.08	78
5.7	147	18	2.59-2.63	66-67	2.22	56	5.96	151	3.39	86
6.7	170	21	3.07-3.10	78-79	2.44	62	6.91	176	3.87	98
7.7	196	24	3.55-3.58	90-91	2.64	67	7.86	200	4.34	110
9.9	251	31	4.67	119	3.07	78	10.08	256	5.45	138
SERIES 1400 ROLLER TOP										
3.9	99	12	1.62-1.68	41-43	1.80	46	4.66	118	3.04	77
5.1	130	16	2.26-2.31	57-59	2.11	54	5.93	151	3.68	93
5.7	145	18	2.59-2.63	66-67	2.22	56	6.56	167	3.99	101
6.7	170	21	3.07-3.10	78-79	2.44	62	7.51	191	4.47	113
7.7	196	24	3.55-3.58	90-91	2.64	67	8.46	215	4.94	125
9.9	251	31	4.67	119	3.07	78	10.68	271	6.05	154
SERIES 1400 NON SKID										
3.9	99	12	1.62-1.68	41-43	1.80	46	3.91	99	2.29	58
5.1	130	16	2.26-2.31	57-59	2.11	54	5.18	132	2.93	74
5.7	145	18	2.59-2.63	66-67	2.22	56	5.81	148	3.24	82
6.7	170	21	3.07-3.10	78-79	2.44	62	6.76	172	3.72	94
7.7	196	24	3.55-3.58	90-91	2.64	67	7.71	196	4.19	106
9.9	251	31	4.67	119	3.07	78	9.93	252	5.30	135

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			
3.9	99	12	0.066	1.7
5.1	130	16	0.050	1.3
5.7	145	18	0.044	1.1
6.7	170	21	0.038	1.0
7.7	196	24	0.033	0.8
9.9	251	31	0.025	0.6