
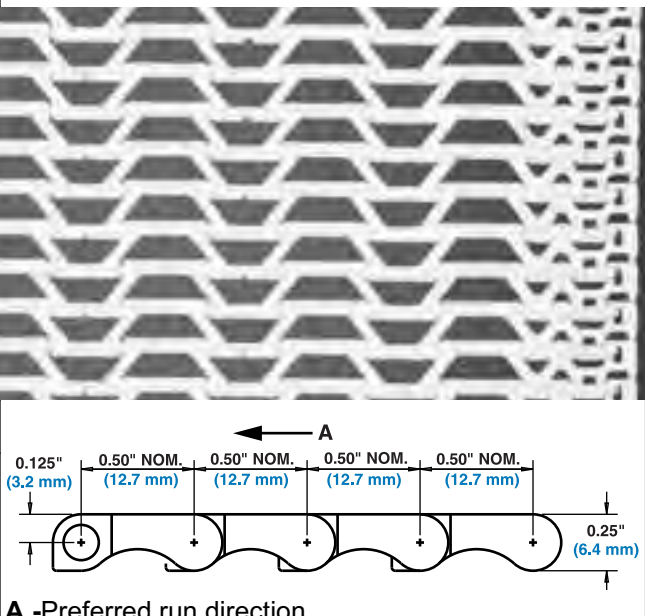


Flush Grid		
	in.	mm
Pitch	0.50	12.7
Minimum Width	8	203
Width Increments	0.50	12.7
Opening Sizes (approximate)	0.87 × 0.30	22.1 × 7.6
	0.66 × 0.30	16.8 × 7.6
Open Area	48%	
Hinge Style	Open	
Drive Method	Hinge-driven	
Product Notes		
<ul style="list-style-type: none"> • Always check with Customer Service for precise belt width measurement and stock status before designing a conveyor or ordering a belt. • Designed for a 0.5 in. (12.7 mm) nosebar. • Smooth upper surface with fully flush edges. • 0.140 in. (3.6 mm) diameter rods. • The detectable material has Surface Resistivity per ASTM_D257 of 545 Ohms per square. 		
Additional Information		
<ul style="list-style-type: none"> • 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 0.140 in. (3.6 mm)	BS Belt Strength	Temperature Range (continuous)		W Belt Weight	Agency Acceptability ^a 1=White, 2=Blue, 3=Natural, 4=Grey							
			lb/ft	kg/m		°F	°C	lb/ft ²	kg/m ²	FDA (USA)	USDA Dairy ^b	CFA ^c	A ^d
Polypropylene	Polypropylene	125	186	34 to 220	1 to 104	0.44	2.12	•				•	3
Polypropylene	Acetal	150	223	34 to 200	1 to 93	0.51	2.40	•				•	3
FDA HR Nylon ^g	Nylon	175	260	-50 to 240	-46 to 116	0.58	2.83	•					
Acetal	Acetal	240	357	-50 to 200	-46 to 93	0.73	3.56	•				•	3
Detectable Polypropylene ^h	Acetal	80	119	0 to 150	-18 to 66	0.56	2.73	•				•	4
X-Ray Detectable Acetal ⁱ	Acetal	240	357	-50 to 200	-46 to 93	0.78	3.66	•					

a. Prior to Intralox's development of the Series 1500, USDA-FSIS Meat and Poultry discontinued publishing a list of acceptable new products designed for food contact. As of the printing of this literature, third party approvals are being investigated, but are not yet sanctioned by the USDA-FSIS.

b. USDA Dairy acceptance requires the use of a clean-in-place-system.

c. Canada Food Inspection Agency

d. Australian Quarantine Inspection Service

e. European Migration Certificate providing approval for food contact according to EU Directive 2002/72/EC and all its amendments to date.

f. Japan Ministry of Health, Labour, and Welfare

g. This product may not be used for food contact articles that will come in contact with food containing alcohol.

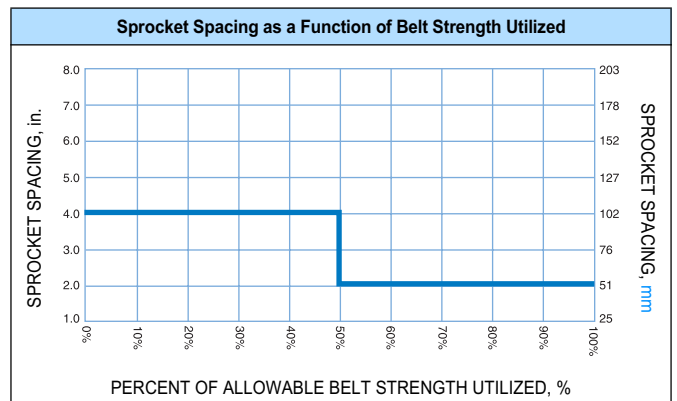
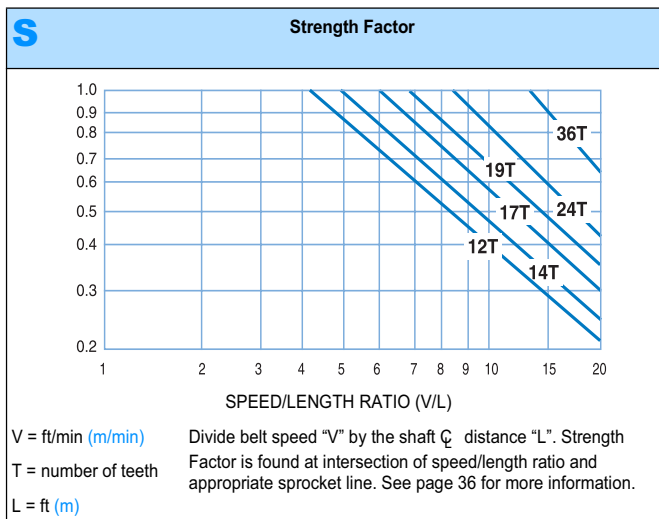
h. Detectable Polypropylene can be sensed with metal detection equipment. Testing the material on a metal detector in a production environment is the best method for determining detection sensitivity.

i. Designed specifically to be detected by x-ray machines.

Sprocket and Support Quantity Reference

Belt Width Range ^a		Minimum Number of Sprockets Per Shaft ^b	Wearstrips	
in.	mm		Carryway	Returnway
8	203	3	3	2
10	254	3	3	2
12	305	3	3	2
14	356	3	4	3
16	406	5	4	3
18	457	5	4	3
20	508	5	5	3
22	559	5	5	3
24	610	7	5	3
26	660	7	6	4
28	711	7	6	4
30	762	7	6	4
32	813	9	7	4
34	864	9	7	4
36	914	9	7	4
38	965	9	8	5
40	1016	11	8	5
42	1067	11	8	5
44	1118	11	9	5
46	1168	11	9	5
48	1219	13	9	5
50	1270	13	10	6
52	1321	13	10	6
54	1372	13	10	6
56	1422	15	11	6
58	1473	15	11	6
60	1524	15	11	6
62	1575	15	12	7
64	1626	17	12	7
For Other Widths, Use Odd Number of Sprockets ^c at Maximum 6 in. (152 mm) \varnothing Spacing			Maximum 6 in. (152 mm) \varnothing Spacing	Maximum 12 in. (305 mm) \varnothing Spacing

- a. Belts are available in 0.50 in. (12.7 mm) increments beginning with 8 in. (203 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 Locked Sprocket Location chart in the Installation Instruction Guidelines or call Customer Service for lock down location.



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	
10 (4.89%)	1.6	41	1.8	46	0.64	16		5/8			
12 (3.41%)	1.9	48	2.1	53	0.67	17	1	1.0	25		
14 (2.51%)	2.3	58	2.4	61	0.75	19	3/4, 1, 1-3/16, 1-1/4	1.0	25		
17 (1.70%)	2.7	69	2.9	73	0.75	19	3/4, 1, 1-3/16, 1-1/4, 1-3/8		25		
19 (1.36%)	3.1	79	3.2	82	0.75	19	1, 1-3/8				
24 (0.86%)	3.8	97	4.0	101	0.75	19	1	1.5	25	40	
36 (0.38%)	5.7	145	5.9	150	0.75	19	1	1.5		40	



- 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.

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	
24 (0.86%)	3.8	97	4.0	101	1.5	38				40	
36 (0.38%)	5.7	145	5.9	150	1.5	38				40	



- 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.

Flush Grid Base Flights (Streamline)

Available Flight Height		Available Materials
in.	mm	
1	25	

Note: Flights can be cut down to any height required for a particular application.

Note: Each flight rises out of the center of its supporting module, molded as an integral part. No fasteners are required.

Note: Flush Grid flight is smooth (Streamline) on both sides.

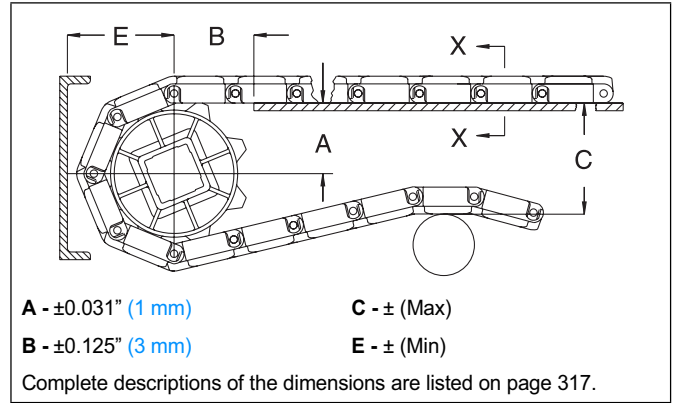
Note: The minimum indent is a function of belt width and ranges from 3 in. (76 mm) to 3.75 in. (95 mm).



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.

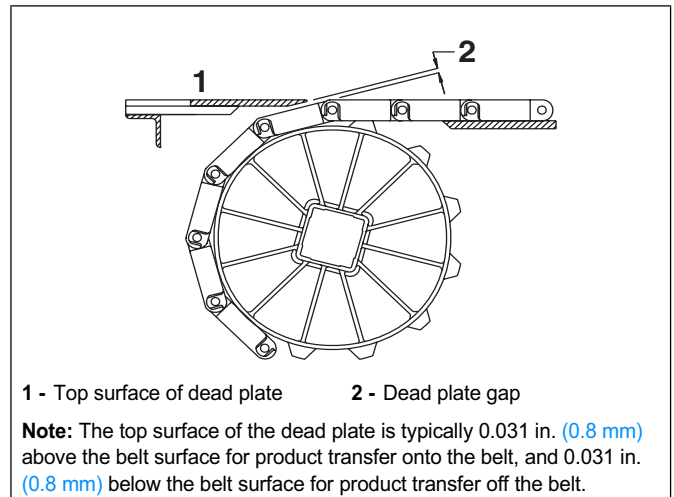


Sprocket Description			A		B		C		E	
Pitch Diameter		No. Teeth	Range (Bottom to Top)		in.	mm	in.	mm	in.	mm
in.	mm		in.	mm						
SERIES 1500 FLUSH GRID										
1.6	41	10	0.64-0.68	16-17	1.13	29	1.62	41	1.00	25
1.9	48	12	0.81-0.84	21	1.24	31	1.93	49	1.15	29
2.3	58	14	0.97-1.00	25	1.34	34	2.25	57	1.31	33
2.7	69	17	1.21-1.24	31	1.49	38	2.72	69	1.55	39
3.1	79	19	1.37-1.39	35	1.59	40	3.04	77	1.71	43
3.8	97	24	1.77-1.79	45	1.76	45	3.83	97	2.10	53
5.7	145	36	2.73-2.74	69-70	2.71	55	5.74	146	3.06	78

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 tipping problems for sensitive containers or products.



Sprocket Description			Gap	
Pitch Diameter		No. Teeth	in.	mm
in.	mm			
1.6	41	10	0.040	1.0
1.9	48	12	0.033	0.8
2.3	58	14	0.028	0.7
2.7	69	17	0.023	0.6
3.1	79	19	0.021	0.5
3.8	97	24	0.017	0.4
5.7	145	36	0.011	0.3

