

Open Hinge Flat Top

	in.	mm
Pitch (nominal)	1.00	25.4
Minimum Width	5	127
Width Increments	0.50	12.7
Opening Size (approx.)	—	—
Open Area	0%	
Hinge Style	Open	
Drive Method	Center-driven	

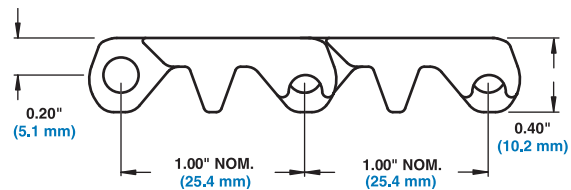
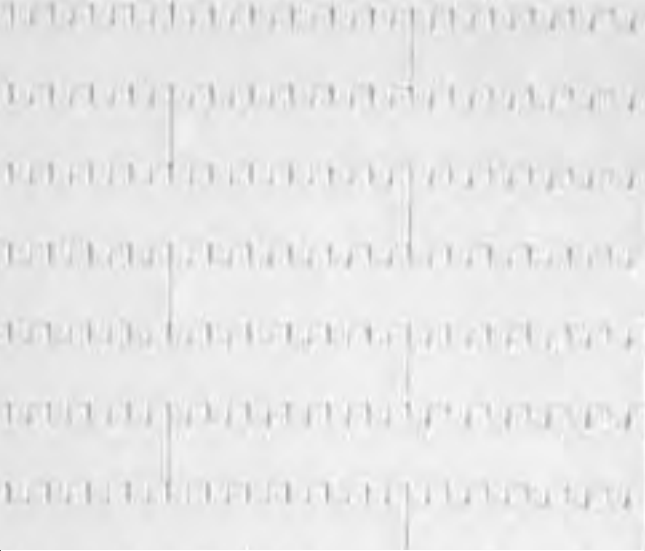


Product Notes

- **Always check with Customer Service for precise belt width measurement and stock status before designing a conveyor or ordering a belt.**
- Smooth, closed upper surface with fully flush edges and recessed rods.
- Cam-link designed hinges - expose more hinge and rod area as belt goes around the sprocket. This exclusive Intralox feature allows unsurpassed cleaning access to this area.
- Fully sculpted and radius corners - no pockets or sharp corners to catch and hold debris.
- Drive Bar - like Series 800 and Series 1800, the drive bar on the underside of Series 1600 Open Hinge Flat Top channels water and debris to the outside of the belt for easier, faster clean up. The drive bar's effectiveness has been proven both in-house and in field tests.
- No-Cling flights are available. Standard height is 4" (102 mm) or they can be cut down to custom heights.

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 ^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	J ^e	Z ^f	EU MC ^g
Polypropylene	Polypropylene	700	1040	34 to 220	1 to 104	1.05	5.13	•	1				3	•
Polyethylene	Polyethylene	350	520	-50 to 150	-46 to 66	1.10	5.37	•	3				3	•
Acetal	Polypropylene	1400	2100	34 to 200	1 to 93	1.58	7.71	•	1				3	•
Acetal	Polyethylene ^h	1000	1490	-50 to 150	-46 to 66	1.58	7.71	•	1				3	•

a. Prior to Intralox's development of the Series 1600, 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. 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.

h. Polyethylene rods can be used in cold applications when impacts or sudden starts/stops occur. Please note lower rating.

Nub Top™

	in.	mm
Pitch	1.00	25.4
Minimum Width	5	127
Width Increments	0.50	12.7
Open Area	0%	
Product Contact Area	10%	
Hinge Style	Open	
Drive Method	Center-Driven	



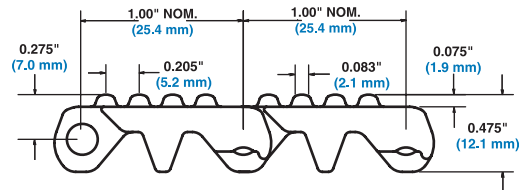
Product Notes

- Always check with Customer Service for precise belt width measurement and stock status before designing a conveyor or ordering a belt.
- No-Cling flights are 4" (102 mm) high and can be cut to any size. Molded as an integral part of the belt, the flights are available in polypropylene, polyethylene, and acetal.
- Belt has closed upper surface with fully flush edges and recessed rods.
- Recommended for products large enough to span the distance between the nubs [0.250" (6.35 mm)].
- Standard flights available.
- Not recommended for back-up conditions. If values are required, contact Intralox Sales Engineering.
- Standard nub indent is 1.3" (33 mm).



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 ^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	J ^e	Z ^f	EU MC ^g	
Polypropylene	Polypropylene	700	1040	34 to 220	1 to 104	1.13	5.52	•					3		•
Polyethylene	Polyethylene	350	520	-50 to 150	-46 to 66	1.18	5.76	•					3		•
Acetal	Polypropylene	1400	2100	34 to 200	1 to 93	1.74	8.49	•					3		•
Acetal	Polyethylene ^h	1000	1490	-50 to 150	-46 to 66	1.74	8.49	•					3		•

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d. Australian Quarantine Inspection Service

e. Japan Ministry of Health, Labour, and Welfare

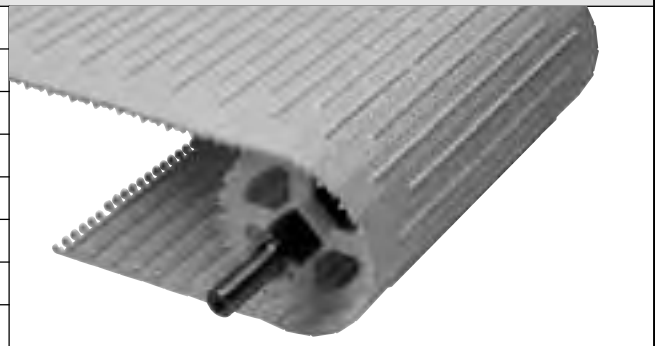
f. MAF-New Zealand Ministry of Agriculture and Forestry. MAF acceptance requires the use of a clean-in-place system.

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

h. Polyethylene rods can be used in cold applications when impacts or sudden starts/stops occur. Please note lower rating.

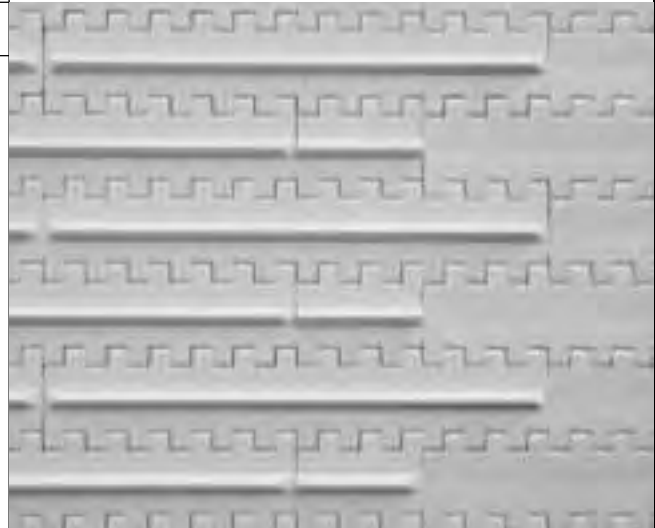
Mini Rib

	in.	mm
Pitch (nominal)	1.00	25.4
Minimum Width	5	127
Width Increments	0.50	12.7
Opening Size (approx.)	—	—
Open Area	0%	
Hinge Style	Open	
Drive Method	Center-driven	



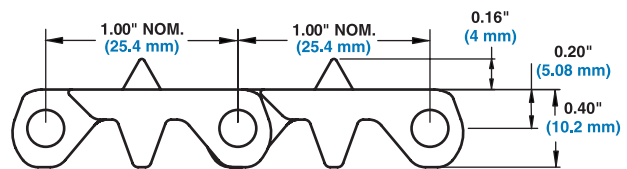
Product Notes

- **Always check with Customer Service for precise belt width measurement and stock status before designing a conveyor or ordering a belt.**
- Closed upper surface with fully flush edges and recessed rods.
- Cam-link designed hinges - expose more hinge and rod area as belt goes around the sprocket. This exclusive Intralox feature allows unsurpassed cleaning access to this area.
- Fully sculpted and radius corners - no pockets or sharp corners to catch and hold debris.
- Drive Bar - like Series 800 and Series 1800, the drive bar on the underside of Series 1600 Open Hinge Mini Rib channels water and debris to the outside of the belt for easier, faster clean up. The drive bar's effectiveness has been proven both in-house and in field tests.
- No-Cling flights are available. Standard height is 4 in. (102 mm) or they can be cut down to custom heights.
- 0.16 in. (4 mm) Mini Rib on surface accommodates gradual inclines and declines. Not recommended for back-up conditions.
- Minimum rib indent is 1.5 in. (38 mm).



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


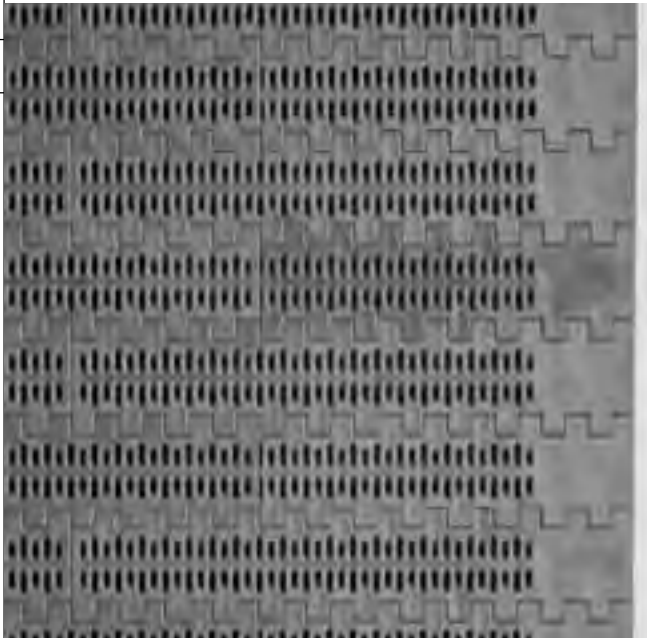
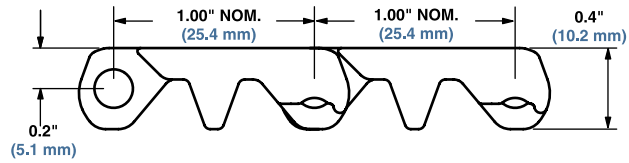
Belt Material	Standard Rod Material Ø 0.18 in. (4.6 mm)	BS	Belt Strength	Temperature Range (continuous)		W	Belt Weight	Agency Acceptability ^a 1=White, 2=Blue, 3=Natural, 4=Grey				
				lb/ft	kg/m			°F	°C	lb/ft ²	kg/m ²	FDA (USA)
Polypropylene	Polypropylene	700	1040	34 to 220	1 to 104	1.05	5.13	•	1		3	•
Acetal	Polypropylene	1400	2100	34 to 200	1 to 93	1.58	7.71	•	1		3	•

a. Prior to Intralox's development of the Series 1600, 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.
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 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.

Mesh Top™		
	in.	mm
Pitch	1.00	25.4
Minimum Width	5	127
Width Increments	0.50	12.7
Min. Opening Size (approx.)	0.06 x 0.12	1.5 x 3.0
Max. Opening Size (approx.)	0.06 x 0.20	1.5 x 5.1
Open Area (fully extended)	16%	
Hinge Style	Open	
Drive Method	Center-driven	

Product Notes

- Always check with Customer Service for precise belt width measurement and stock status before designing a conveyor or ordering a belt.
- Cam-link designed hinges - expose more hinge and rod area as belt goes around the sprocket. This exclusive Intralox feature allows unsurpassed cleaning access to this area.
- Fully sculpted and radius corners - no pockets or sharp corners to catch and hold debris.
- Drive Bar - like Series 800 and Series 1800, the drive bar on the underside of Series 1600 Mesh Top channels water and debris to the outside of the belt for easier, faster clean up. The drive bar's effectiveness has been proven both in-house and in field tests.
- No-Cling flights are available. Standard height is 4 in. (102 mm) or they can be cut down to custom heights.
- Standard Mesh Top indent is 1 in. (25 mm).

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 0.18 in. (4.6 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	J ^e	Z ^f
Acetal	Polypropylene	1200	1780	34 to 200	1 to 93	1.40	6.84	•					3		•
Polypropylene	Polypropylene	700	1040	34 to 220	1 to 104	0.94	4.59	•					3		•

a. Prior to Intralox's development of the Series 1600, 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

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

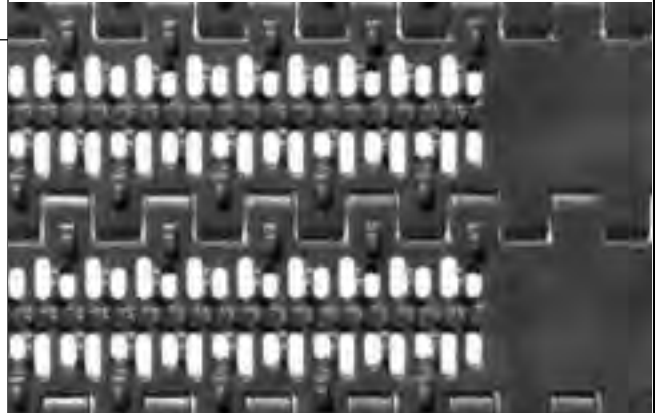
Mesh Nub Top™

	in.	mm
Pitch	1.00	25.4
Minimum Width	5	127
Width Increments	0.50	12.7
Min. Opening Size (approx.)	0.06 x 0.12	1.5 x 3.0
Max. Opening Size (approx.)	0.06 x 0.20	1.5 x 5.1
Open Area	16%	
Hinge Style	Open	
Drive Method	Center-Driven	



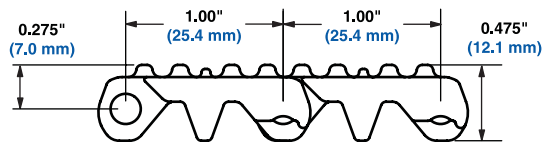
Product Notes

- Always check with Customer Service for precise belt width measurement and stock status before designing a conveyor or ordering a belt.
- Fully sculpted and radius corner – no pockets or sharp corners to catch and hold debris.
- Drive Bar – like Series 800 and Series 1800, the drive bar on the underside of the S1600 Mesh Nub Top channels water and debris to the outside of the belt for easier, faster cleanup. The drive bar's effectiveness has been proven both in-house and in field tests.
- No Cling Flights are available. Standard height is 4 in. (102 mm) or they can be cut down to custom heights.
- Standard Mesh Nub Top indent is 1 in. (25.4 mm).



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

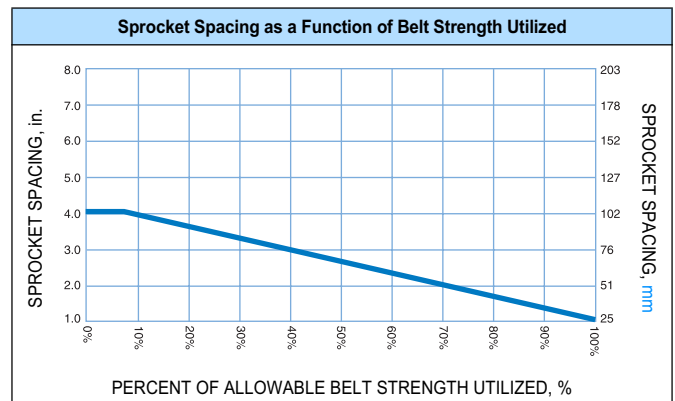
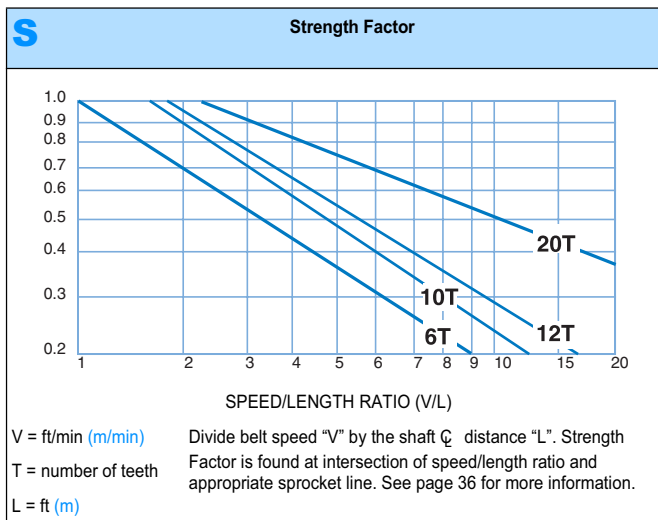
Belt Material	Standard Rod Material Ø 0.18 in. (4.6 mm)	BS Belt Strength		Temperature Range (continuous)		W Belt Weight		Agency Acceptability: 1=White, 2=Blue, 3=Natural, 4=Grey							
		lb/ft	kg/m	°F	°C	lb/ft ²	kg/m ²	FDA (USA)	USDA-FSIS - Meat & Poultry	USDA Dairy ^a	CFA ^b	A ^c	J ^d	EU MC ^e	
Acetal	Polypropylene	1200	1780	34 to 200	1 to 93	1.45	7.08	•						3	
Polypropylene	Polypropylene	700	1040	34 to 220	1 to 104	0.98	4.81	•						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.

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	3	3	2
9	229	3	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 ^c at Maximum 4 in. (102 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 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.



EZ Clean 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
6 (13.40%)	2.0	51	1.8	46	1.0	25	1.0		25	
10 (4.89%)	3.2	81	3.2	81	1.0	25	1.0	1.5	25	40
12 (3.41%)	3.9	99	3.8	97	1.0	25		1.5		40
20 (1.23%)	6.4	163	6.4	163	1.0	25		1.5		40



- a. Contact customer Service for lead times. When using Polyurethane sprockets, the Belt Strength for belts rated over 500 lb/ft (744 kg/m) will be de-rated to 500 lb/ft (744 kg/m) and all other belts will maintain their published rating. The temperature range for Polyurethane sprockets is 0° F (-18 °C) to 120 °F (49 °C). Contact Customer Service for availability of Polyurethane sprockets.
- 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.

Angled EZ Clean 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	3.8	97	2.0	50.8		1.5		40
16 (1.92%)	5.2	132	5.1	130	2.0	50.8		1.5		40
20 (1.23%)	6.4	163	6.4	163	2.0	50.8		1.5		40



- a. Contact customer Service for lead times.

Open Hinge Flat Top Base Flight (No-Cling)

Available Flight Height		Available Materials
in.	mm	
4.0	102	Polypropylene, Polyethylene, Acetal

- Note:** Minimum indent is 1.0 in (25.4 mm)
- 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:** The no-cling vertical ribs are on both sides of the flight.



Mesh Nub Top™ Base Flight (No-Cling)

Available Flight Height		Available Materials
in.	mm	
4.0	102	Acetal

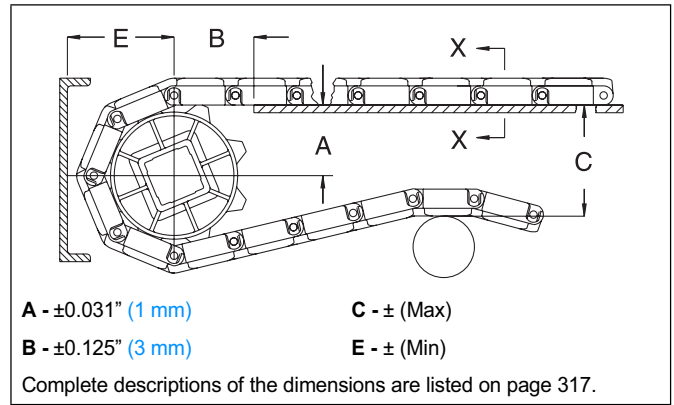
- Note:** Minimum indent is 1.0 in (25.4 mm)
- Note:** Flights can be cut down to any height required for a particular application.
- Note:** Each flight rises out of the center of its supporting module, molded as an integral part. No fasteners are required.
- Note:** The no-cling vertical ribs are on both sides of the flight.



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.

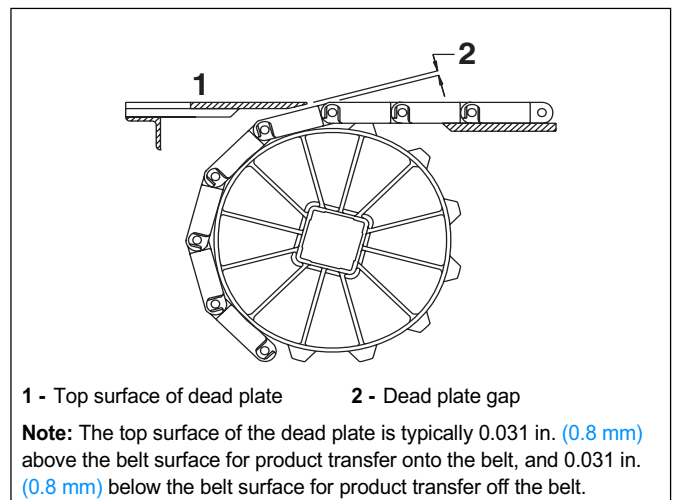


Sprocket Description			A		B		C		E	
Pitch Diameter		No. Teeth	Range (Bottom to Top)		in.	mm	in.	mm	in.	mm
in.	mm		in.	mm						
SERIES 1600 OPEN HINGE FLAT TOP, MESH TOP										
2.0	51	6	0.67-0.80	17-20	1.10	28	2.00	51	1.26	32
3.2	81	10	1.34-1.42	34-36	1.56	40	3.24	82	1.88	48
3.9	99	12	1.67-1.73	42-44	1.70	43	3.86	98	2.19	56
6.4	163	20	2.96-3.00	75-76	2.25	57	6.39	162	3.46	88
SERIES 1600 NUB TOP, MESH NUB TOP										
2.0	51	6	0.67-0.80	17-20	1.10	28	2.08	53	1.34	34
3.2	81	10	1.34-1.42	34-36	1.56	40	3.31	84	1.96	50
3.9	99	12	1.67-1.73	42-44	1.70	43	3.94	100	2.27	58
6.4	163	20	2.96-3.00	75-76	2.25	57	6.47	164	3.53	90
SERIES 1600 MINI RIB										
2.0	51	6	0.67-0.80	17-20	1.10	28	2.16	55	1.42	36
3.2	81	10	1.34-1.42	34-36	1.56	40	3.40	86	2.04	52
3.9	99	12	1.67-1.73	42-44	1.70	43	4.02	102	2.35	60
6.4	163	20	2.96-3.00	75-76	2.25	57	6.55	166	3.62	92

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			
2.0	51	6	0.134	3.4
3.2	81	10	0.079	2.0
3.9	99	12	0.066	1.7
6.4	163	20	0.039	1.0

