

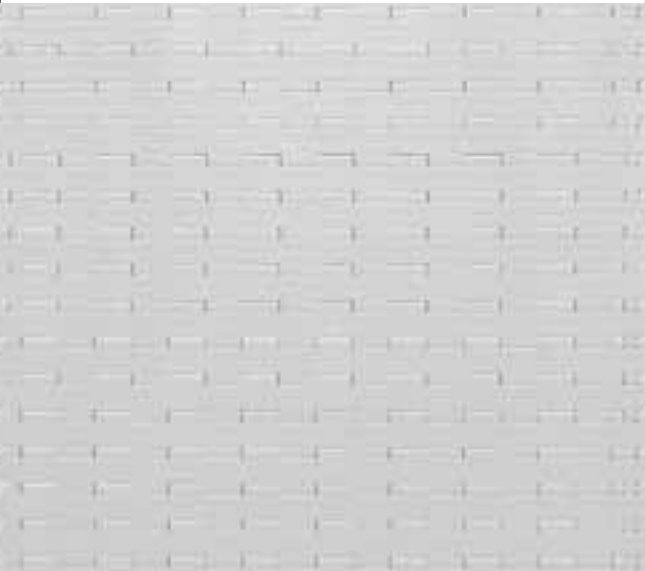
SeamFree Minimum Hinge Flat Top

	in.	mm
Pitch	1.00	25.4
Minimum Width	4	102
Width Increments	1.00	25.4
Opening Sizes (approx.)	-	-
Open Area	0%	
Hinge Style	Open	
Drive Method	Center-Driven	



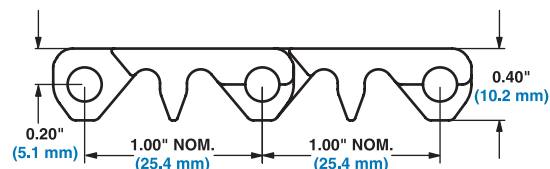
Product Notes

- **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 the belt goes around the sprocket. This exclusive Intralox feature allows unsurpassed cleaning access to this area.
- Fully sculpted and radiused corners - no pockets or sharp corners to catch and hold debris.
- Drive Bar - like Series 800 and Series 1800, the drivebar on the underside of S1650 SeamFree™ Minimum Hinge Flat Top in combination with the patent pending flume feature 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.
- Designed for use with S1600 Angled EZ Clean Sprockets but compatible with standard S1600 EZ Clean sprockets as well.
- Belts over 18" (457 mm) will be built with multiple modules per row, but seams will be minimized.



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

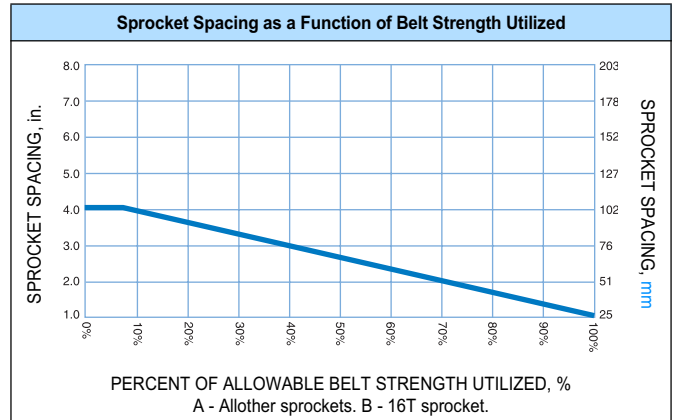
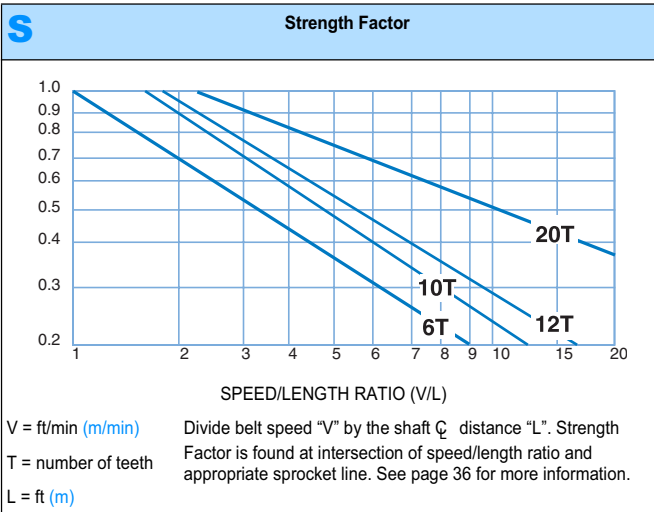
Belt Material	Standard Rod Material Ø 0.18 in. (4.6 mm)	BS		Temperature Range (continuous)		W		Agency Acceptability 1-White, 2-Blue, 3-Natural, 4-Grey							
		Belt Strength lb/ft	kg/m	°F	°C	Belt Weight lb/ft²	kg/m²	FDA (USA)	USDA Dairy ^a	CFA ^b	A ^c	J ^d	Z ^e	EU MC ^f	
Acetal	Acetal	350	520	-50 to 200	-46 to 93	1.47	7.18	•					3		
Acetal	Polypropylene	325	480	34 to 200	1 to 93	1.40	6.84	•					3		
Acetal	Polyethylene	225	330	-50 to 150	-46 to 66	1.40	6.83	•					3		
Polypropylene	Polypropylene	225	330	34 to 220	1 to 104	0.91	4.44	•					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
4	102	2	2	2
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 1.0 in. (25.4 mm) increments beginning with 4 in. (101.6 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.



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

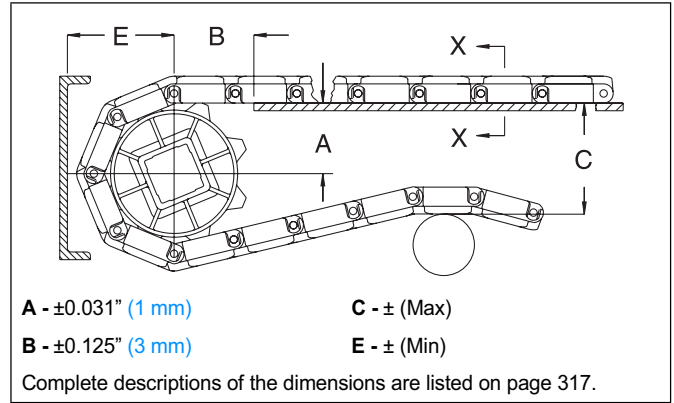


- a. Contact customer Service for lead times.

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.

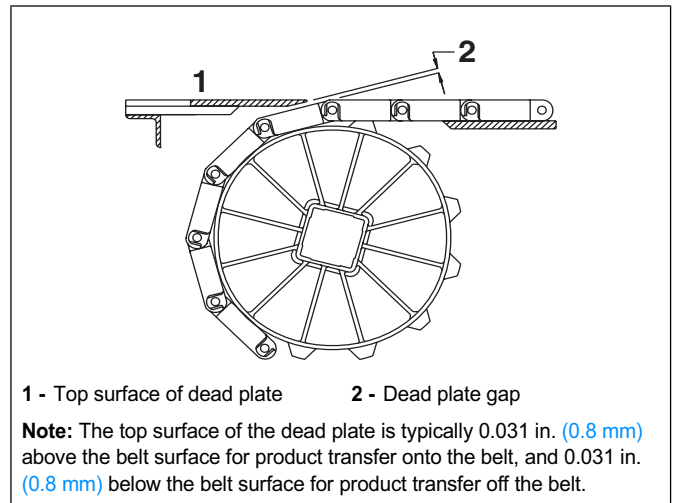


Sprocket Description			A		B		C		E	
Pitch Diameter		No. Teeth	Range (Bottom to Top)		in.	mm	in.	mm	in.	mm
in.	mm		in.	mm						
SEAMFREE™ MINIMUM HINGE FLAT TOP										
2.0	51	6	0.67-0.80	17-20	1.10	28	2.00	51	1.26	32
3.2	81	10	1.34-1.42	34-36	1.56	40	3.24	82	1.88	48
3.9	99	12	1.67-1.73	42-44	1.70	43	3.86	98	2.19	56
6.4	163	20	2.96-3.00	75-76	2.25	57	6.40	163	3.46	88

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