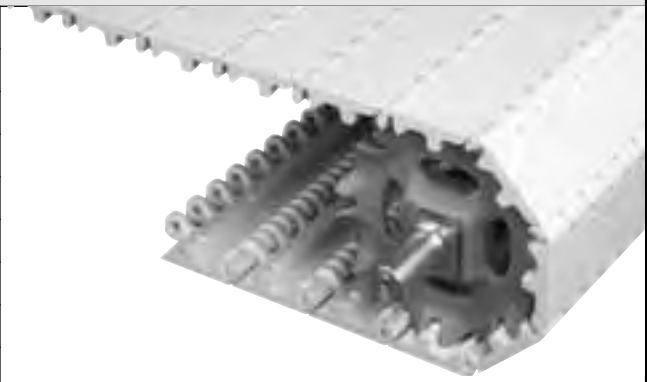


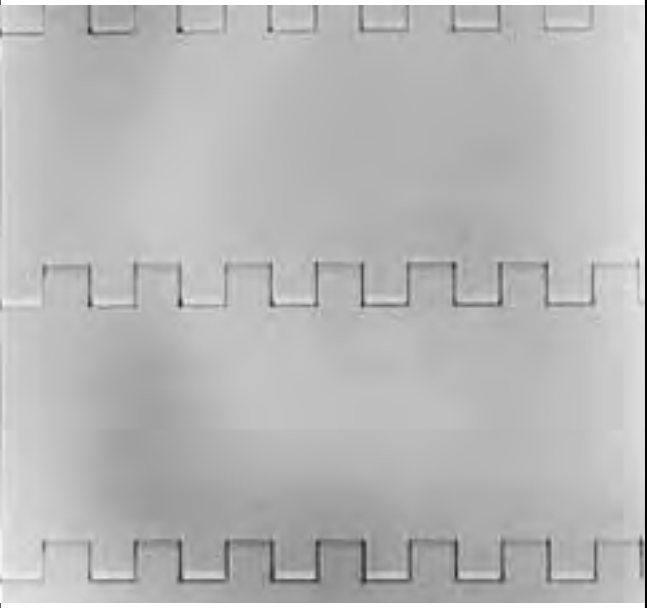
Flat Top

	in.	mm
Pitch	2.50	63.5
Minimum Width	5	127
Width Increments	1.00	25.4
Opening Size (approximate)	-	-
Open Area	0%	
Hinge Style	Open	
Drive Method	Center-driven	



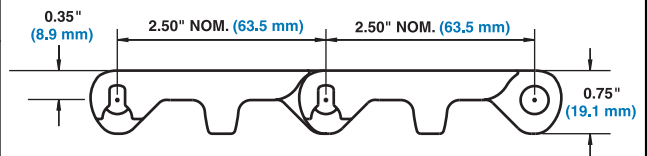
Product Notes

- **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.
- Impact resistant belt designed for abusive applications.
- Easy retrofit from Series 800 without extensive conveyor frame changes for most meat industry applications since the A,B,C,E dimensions are within 1/4 in. (6 mm) of Series 800.
- 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.
- Drive Bar - like Series 800 and Series 1600, the drive bar on the underside of Series 1800 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.



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 0.312 in. (7.9 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	1200	1786	34 to 220	1 to 104	2.06	10.06	•	1			3		•
Polyethylene	Polyethylene	700	1042	-50 to 150	-46 to 66	2.23	10.90	•	3			3		•
Acetal	Polyethylene	1200	1786	-50 to 150	-46 to 66	3.36	16.40	•	1			3		•
Acetal	Polypropylene	1500	2232	34 to 200	1 to 93	3.36	16.40	•	1			3		•

a. Prior to Intralox's development of the Series 1800, 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



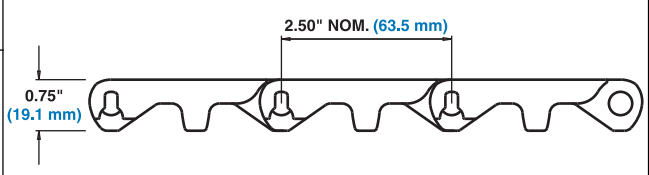
d. Australian Quarantine Inspection Service

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.

Mesh Top™		
	in.	mm
Pitch	2.50	63.5
Minimum Width	5	127
Width Increments	1.00	25.4
Opening Size (approximate)	0.07 × 0.75	1.7 × 19.1
Open Area	32%	
Hinge Style	Open	
Drive Method	Center-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. • Fully flush edges with recessed rods prevent edge damage and rod migration. • Available with Flights and other Series 1800 accessories. 		
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) 		

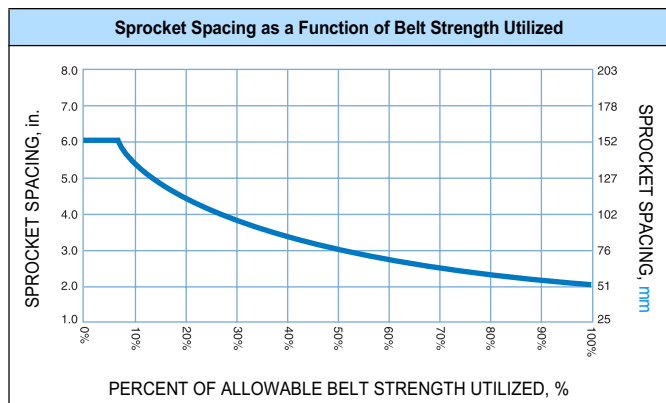
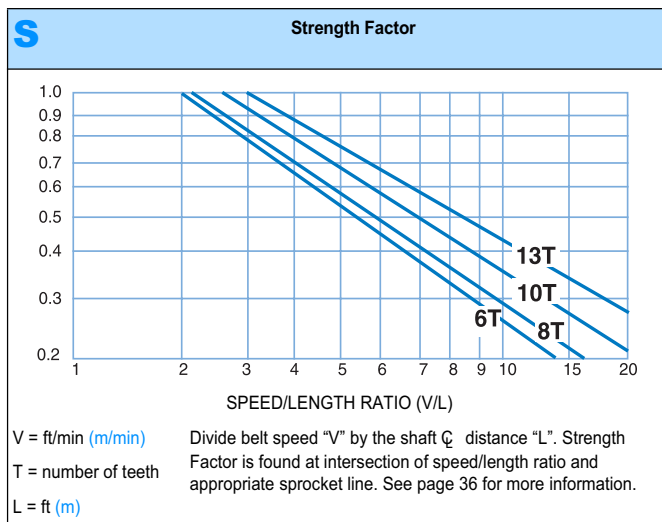
Belt Data																	
Belt Material	Standard Rod Material Ø 0.312 in. (7.9 mm)	BS		Belt Strength		Temperature Range (continuous)		W		Belt Weight		Agency Acceptability ^a 1=White, 2=Blue, 3=Natural, 4=Grey					
		lb/ft	kg/m	°F	°C	lb/ft ²	kg/m ²	FDA (USA)	USDA Dairy ^b	CFA ^c	A ^d	J ^e	Z ^f	EU MC ^g			
Polypropylene	Polypropylene	800	1190	34 to 220	1 to 104	1.44	7.03	•						3	•		
UV Resistant PP	Acetal	1100	1640	34 to 200	1 to 93	1.55	7.56										
UV Resistant Acetal	Acetal	1500	2230	-50 to 200	-46 to 93	2.27	11.08										
Polyethylene	Polyethylene	400	595	-50 to 150	-46 to 66	1.50	7.32	•						3	•		

- a. Prior to Intralox's development of the Series 1800, 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.

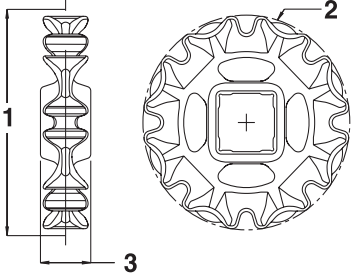
Sprocket and Support Quantity Reference

Belt Width Range ^a		Minimum Number of Sprockets Per Shaft ^b	Wearstrips	
in.	mm		Carryway	Returnway
5	127	1	2	2
6	152	2	2	2
7	178	2	2	2
8	203	2	2	2
9	229	2	2	2
10	254	2	3	2
12	305	3	3	2
14	356	3	3	3
15	381	3	3	3
16	406	3	3	3
18	457	3	3	3
20	508	3	4	3
24	610	5	4	3
30	762	5	5	4
32	813	5	5	4
36	914	7	5	4
42	1067	7	6	5
48	1219	9	7	5
54	1372	9	7	6
60	1524	11	8	6
72	1829	13	9	7
84	2134	15	11	8
96	2438	17	12	9
For Other Widths, Use Odd Number of Sprockets ^c at Maximum 6 in. (152 mm) \varnothing Spacing			Maximum 9 in. (229 mm) \varnothing Spacing	Maximum 12 in. (305 mm) \varnothing 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 5.0 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.	Square in.	Round mm	Square mm
6 (13.40%)	5.0	127	4.6	117	1.5	38		1.5		40
8 (7.61%)	6.5	165	6.2	157	1.5	38		1.5		40
10 (4.89%)	8.1	206	7.8	198	1.5	38		1.5		40
13 (2.91%)	10.5	267	10.3	262	1.5	38		1.5		40
								2.5		60



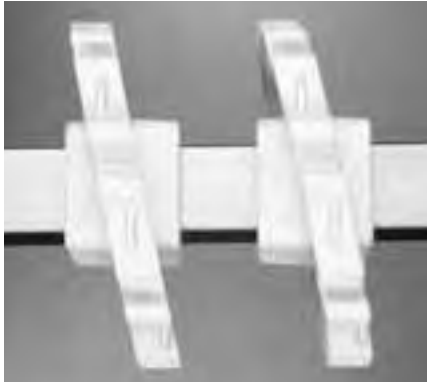
1 - Pitch diameter

2 - Outer diameter

3 - Hub width

a. Contact Customer Service for lead times.

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
8 (7.61%)	6.5	165	6.2	157	2.0	50.8		1.5		40




a. Contact Customer Service for lead times.

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

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

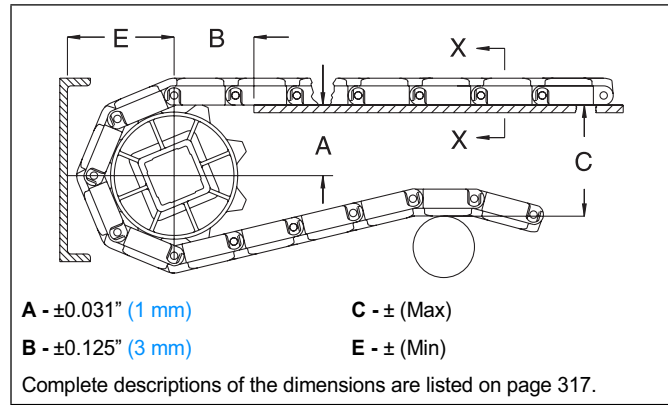
Note: Each flight rises out of the center of its supporting module, molded as an integral part. No fasteners are required.



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.

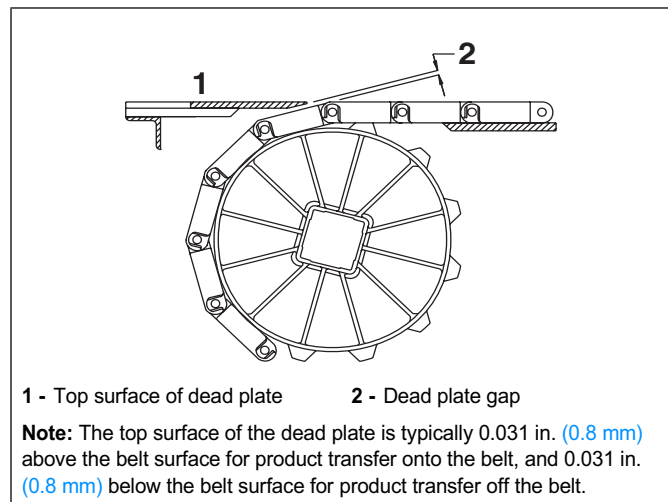


Sprocket Description			A		B		C		E	
Pitch Diameter		No. Teeth	Range (Bottom to Top)		in.	mm	in.	mm	in.	mm
in.	mm		in.	mm						
SERIES 1800 FLAT TOP, MESH TOP										
5.0	127	6	1.77-2.10	45-53	1.87	47	4.95	126	2.91	74
6.5	165	8	2.62-2.87	66-73	2.23	57	6.48	165	3.68	93
8.1	206	10	3.45-3.65	88-93	2.59	66	8.04	204	4.46	113
10.5	267	13	4.67-4.82	119-123	3.02	77	10.40	264	5.64	143

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.



Sprocket Description			Gap	
Pitch Diameter		No. Teeth	in.	mm
in.	mm			
5.0	127	6	0.150	3.8
6.5	165	8	0.108	2.8
8.1	206	10	0.091	2.3
10.5	267	13	0.074	1.9

