
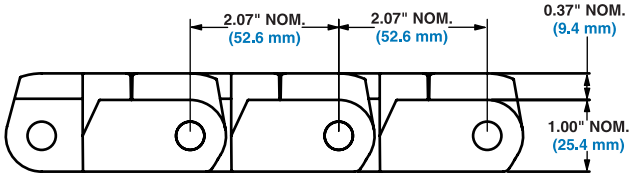


<b>Raised Rib</b>		
	in.	mm
Pitch	2.07	52.6
Minimum Width	15	381
Width Increments	1.00	25.4
Opening Sizes (approx.)	-	-
Open Area	27%	
Hinge Style	Closed	
Drive Method	Center/Hinge-Driven	
<b>Product Notes</b>		
<ul style="list-style-type: none"> <li>• <b>Always check with Customer Service for precise belt width measurement and stock status before designing a conveyor or ordering a belt.</b></li> <li>• Increased module thickness and rod diameter provides superior belt strength and increases belt life.</li> <li>• Shuttleplug™ self-closing rod retention system.</li> <li>• Split sprockets available for easy installation.</li> <li>• Made of engineered resin for increased resistance to chemicals and temperature cycling.</li> <li>• Minimal back tension required.</li> <li>• More robust transfers utilize taller belt ribs and stronger fingers.</li> </ul>		
<b>Additional Information</b>		
<ul style="list-style-type: none"> <li>• See “Belt selection process” (page 5)</li> <li>• See “Standard belt materials” (page 18)</li> <li>• See “Special application belt materials” (page 18)</li> <li>• See “Friction factors” (page 31)</li> </ul>		

<b>Belt Data</b>																
Belt Material	Standard Rod Material 0.38 (9.7 mm)	<b>BS</b>	Belt Strength	Temperature Range (continuous)		<b>W</b>	Belt Weight	Agency Acceptability <sup>a</sup> 1=White, 2=Blue, 3=Natural, 4=Grey								
				lb/ft	kg/m			°F	°C	lb/ft <sup>2</sup>	kg/m <sup>2</sup>	FDA (USA)	USDA Dairy <sup>b</sup>	CFA <sup>c</sup>	A <sup>d</sup>	J <sup>e</sup>
Enduralox™ Polypropylene	Polypropylene	4000	5952	34 to 220	1 to 104	3.90	19.04	•								•
Polypropylene	Polypropylene	4000	5952	34 to 220	1 to 104	3.90	19.04	•								•

a. Prior to Intralox’s development of the Series 1900, 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

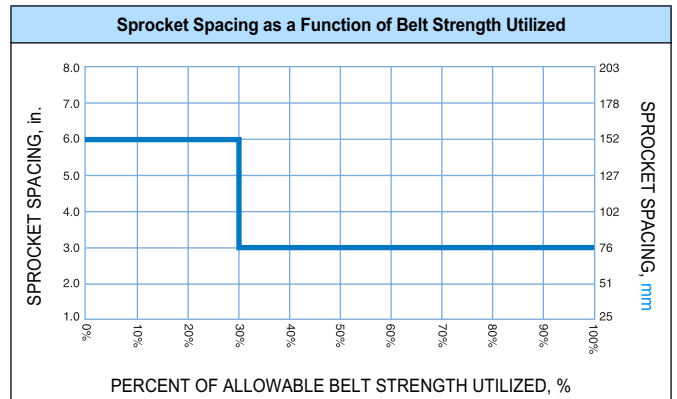
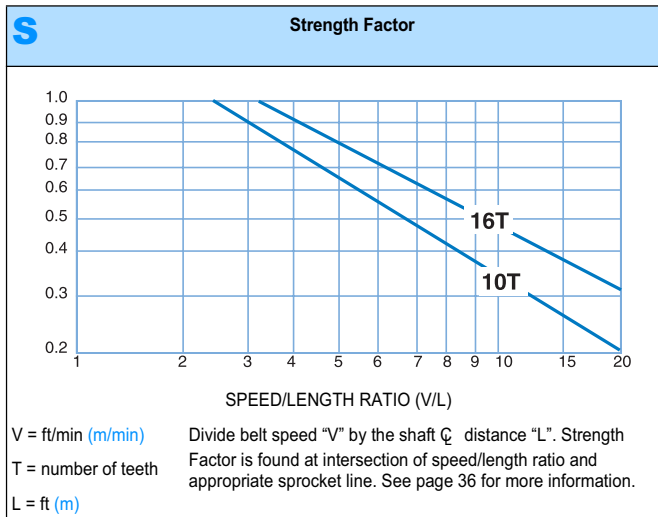
f. MAF-New Zealand Ministry of Agriculture and Forestry. MAF acceptance requires the use of a clean-in-place system.

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 <sup>a</sup>		Minimum Number of Sprockets Per Shaft <sup>b</sup>	Wearstrips	
in.	mm		Carryway	Returnway
15	381	3	3	3
18	457	3	3	3
24	610	5	4	3
30	762	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
120	3048	21	15	11
144	3658	25	17	13
For Other Widths, Use Odd Number of Sprockets <sup>c</sup> 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. **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. See Locked Sprocket Location chart in the Installation Instruction Guidelines or call Customer Service for lock down location.



### Metal Split Sprocket Data

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
10 (4.89%)	6.7	170	7.0	177	1.7	43		2.5		60
15 (2.19%)	10.0	254	10.3	262	1.7	43		3.5		
16 (1.92%)	10.6	269	11.0	279	1.7	43	3.5	3.5		90

**Two-Material Finger Transfer Plates**

Available Widths		Number of Fingers	Available Materials
in.	mm		
6.0	152	18	Glass-Filled Thermoplastic Fingers, Acetal Backplate



**Note:** Plates provide high strength fingers combined with a low-friction back plate.

**Note:** Low-friction back plate is permanently attached to the two high-strength finger inserts.

**Note:** Eliminates product transfer and tipping problems. The 18 fingers extend between the belt's ribs allowing a smooth continuation of the product flow as the belt engages its sprockets.

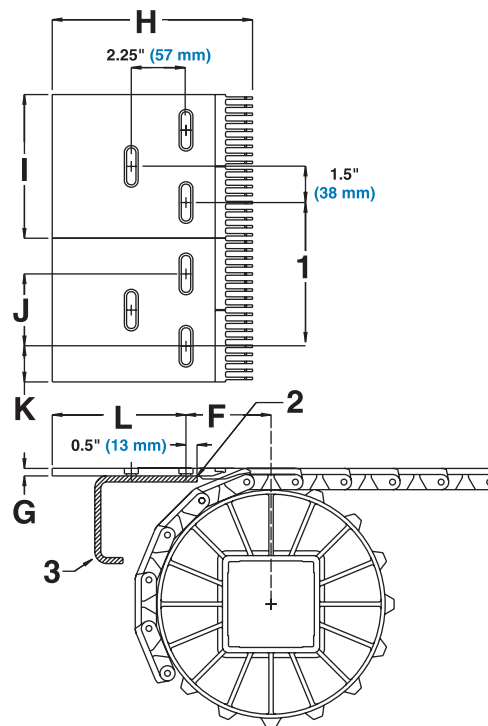
**Note:** Easily installed on the conveyor frame with the shoulder bolts supplied. Caps snap easily into place over the bolts, keeping foreign materials out of the slots.

**Note:** The extended back plate has three attachment slots. Mounting hardware includes stainless steel oval washers and bolts. Plastic bolt covers are also included.

**Dimensional Requirements for Finger Transfer Plate Installation**

	Two-Material	
	in.	mm
F	3.50	89
G	0.31	8
H	9.56	243
I	5.91	150
J	3.00	76
K	1.45	37
L	5.50	140
Spacing at ambient temperature	Enduralox™ PP	
	6.0	152.4

Two-material glass handling finger transfer plate shown



- 1 - SPACING
- 2 - 0.5" (13 mm) RADIUS (LEADING EDGE OF FRAME MEMBER)
- 3 - FRAME MEMBER

## Self-Clearing Finger Transfer Plates

Available Width		Number of Fingers	Available Materials
in.	mm		
6	152	18	Polyurethane



**Note:** The Self-Clearing Finger Transfer System consists of a finger transfer plate and a transfer edge belt that are designed to work together. This system eliminates the need for a sweeper bar, a pusher arm, or wide transfer plates. Transfers are smooth and 100% self-clearing, making right angle transfers possible for all container types. The Self-Clearing Finger Transfer System is ideal for warmer/cooler applications with frequent product changeovers and is compatible with any series and style of Intralox belt on the discharge and infeed conveyors. This system is bi-directional allowing the same transfer belt to be used for both left-hand and right-hand transfers.

**Note:** Self-Clearing Finger Transfer System is capable of transferring product to and from Intralox Series 400, Series 1200 and Series 1900 Raised Rib belts.

**Note:** Smooth, flat top surface provides excellent lateral movement of containers.

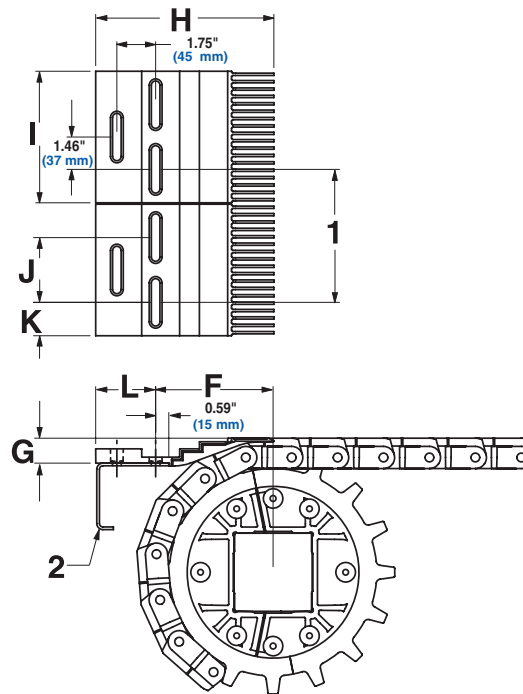
**Note:** Robust design for durability in tough glass applications.

**Note:** Finger Transfer Plates are easily installed and secured to mounting plates of any thickness with supplied stainless steel bolts and oval washers that allow movement with the belt's expansion and contraction.

**Note:** Self-Clearing Transfer Edge Belt is molded with robust tracking tabs for belt support in heavy side-loading conditions. It has fully flush edges, headed rod retention system and nylon rods for superior wear resistance.

## Dimensional Requirements for Self-Clearing Finger Transfer Plate Installations

	Self-Clearing	
	in.	mm
F	5.25	133
G	5.15	29
H	8.05	204
I	5.95	151
J	2.92	74
K	1.51	38
L	2.71	69



**Spacing at ambient temperature**

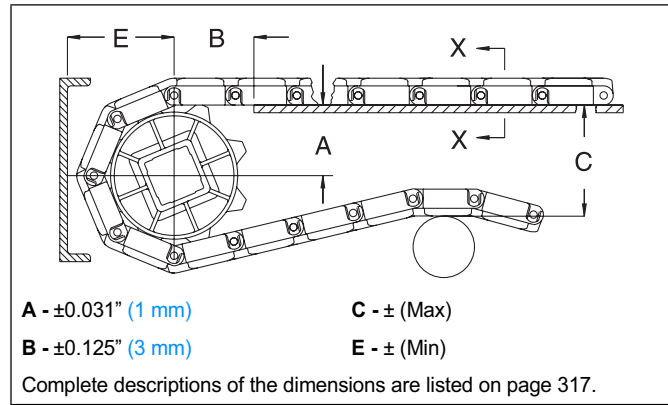
PP	6.000 in.	152.4 mm
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- 1 - Spacing
- 2 - Frame Member

**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.

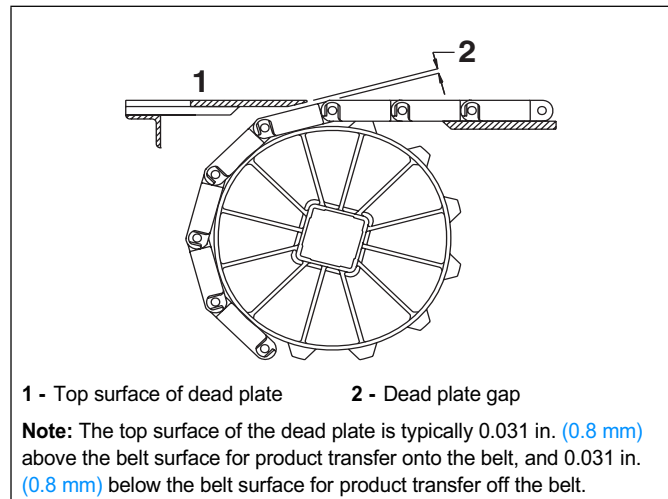


Sprocket Description		A		B		C		E		
Pitch Diameter		No. Teeth	Range (Bottom to Top)		in.	mm	in.	mm	in.	mm
in.	mm		in.	mm						
<b>SERIES 1900</b>										
6.7	170	10	2.69-2.85	68-72	2.82	72	7.08	180	4.29	109
10.0	254	15	4.37-4.48	111-114	3.52	89	10.33	262	5.91	150
10.6	269	16	4.71-4.81	120-122	3.65	93	11	279	6.25	159

**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			
6.7	170	10	0.164	4.2
10.0	254	15	0.109	2.8
10.6	269	16	0.102	2.6

