

**Radius Flush Grid**

	in.	mm
Pitch	1.50	38.1
Minimum Width	5	127
Width Increments	1.00	25.4
Opening Size (approximate)	0.50 × 0.75	12.7 × 19.7
Open Area	50%	
Product Contact Area	37%	
Hinge Style	Open	
Drive Method	Hinge-driven	



**Product Notes**

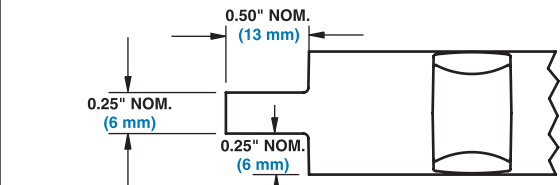
- Always check with Customer Service for precise belt width measurement and stock status before designing a conveyor or ordering a belt.
- Flush edge or tab edge available.
- Designed for radius and low-tension capstan drive spiral applications with a minimum turning radius of 2.2 times belt width (measured from inside edge).
- Lightweight, relatively strong belt with smooth surface grid.
- The Intralox Engineering Program will help predict the strength requirements of most radius and low-tension capstan drive spiral applications, insuring that the belt is strong enough for the application.
- Belt openings pass straight through belt, making it easy to clean.
- Non sliding drive system for reduced belt and sprocket wear, and for low back-side tension.
- Tab edge belt width is measured exclusive of tabs. (Tabs extend approx. 0.5 in. (13 mm) × 0.25 in. (6 mm) thick on each side of belt, inside wearstrip.)
- Polyethylene and/or Tab edge belts are not recommended for low-tension capstan drive spiral applications.
- Maximum belt width in turns is 36 in. (914 mm)



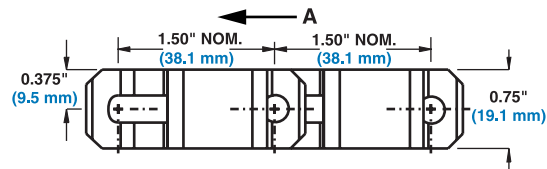
**WARNING:** Personnel must not place their fingers in or on this belt. Fingers can get trapped in the openings of this belt, resulting in personal injury. This belt also has pinch points which result from the spreading and collapsing of the belt as it flexes to follow the conveyor path. These pinch points can trap fingers, hair or clothing, and can cause personal injury. Personnel should also be instructed not to wear loose fitting clothing, loose fitting gloves or hand/finger jewelry when working near this belt. Call Customer Service for tags, flyers and stickers containing this warning.

**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)



Series 2200 Tab Edge Dimensions



A - Preferred direction for flat turning applications

**Belt Data**

Belt Material	Standard Rod Material Ø 0.24 in. (6.1 mm)	BS	Straight Belt Strength	Curved Belt Strength		Temperature Range (continuous)		W	Belt Weight	Agency Acceptability: 1=White, 2=Blue, 3=Natural, 4=Grey							
				lb	kg	°F	°C			lb/ft <sup>2</sup>	kg/m <sup>2</sup>	FDA (USA)	USDA-FSIS - Meat & Poultry	USDA Dairy <sup>a</sup>	CFA <sup>b</sup>	A <sup>c</sup>	J <sup>d</sup>
Polypropylene	Acetal	1600	2380	350	159	34 to 200	1 to 93	1.86	9.10	•	•	1	•	•	3	•	•
Polyethylene <sup>g</sup>	Acetal	1000	1490	200	91	-50 to 150	-46 to 66	1.96	9.56	•	•	3	•	•	3	•	•
Acetal	Nylon	2500	3720	350	159	-50 to 200	-46 to 93	2.82	13.80	•	•	3	•	•	3	•	•
Polypropylene	Polypropylene <sup>h</sup>	1400	2100	200	91	34 to 220	1 to 104	1.78	8.69	•	•	1	•	•	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.  
 g. Polyethylene cannot exceed 150 °F (66 °C)  
 h. Polypropylene rods can be installed in polypropylene belts when extra chemical resistance is required. Please note lower belt strength.

## Radius Flush Grid High Deck

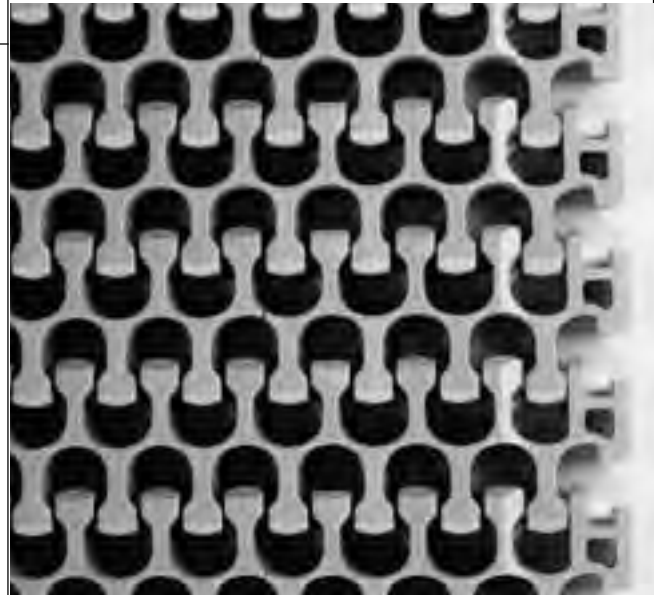
	in.	mm
Pitch	1.50	38.1
Minimum Width	6	152
Width Increments	1.00	25.4
Opening Size (approximate)	0.50 × 0.75	12.7 × 19.7
Open Area	50%	
Product Contact Area	37%	
Hinge Style	Open	
Drive Method	Hinge-driven	



### Product Notes

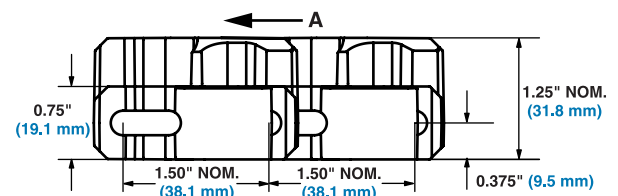
- Always check with Customer Service for precise belt width measurement and stock status before designing a conveyor or ordering a belt.
- Flush Grid High Deck is 0.5 in. (12.7 mm) higher than the standard Series 2200 belt.
- Makes turns with an inside radius of 2.2 times the belt width.
- Flush Grid High Deck has more beam strength than the standard Series 2200 belt, which can reduce retrofit costs in spirals.
- Works with standard Series 2200 wearstrips.
- Standard indent for Flush Grid High Deck is 1.25 in. (31.8 mm)

**WARNING:** Personnel must not place their fingers in or on this belt. Fingers can get trapped in the openings of this belt, resulting in personal injury. This belt also has pinch points which result from the spreading and collapsing of the belt as it flexes to follow the conveyor path. These pinch points can trap fingers, hair or clothing, and can cause personal injury. Personnel should also be instructed not to wear loose fitting clothing, loose fitting gloves or hand/finger jewelry when working near this belt. Call Customer Service for tags, flyers and stickers containing this warning.



### 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)



A -Preferred direction for flat turning applications

### Belt Data

Belt Material	Standard Rod Material Ø 0.24 in. (6.1 mm)	<b>BS</b>	Straight Belt Strength <sup>a</sup>	Curved Belt Strength <sup>b</sup>		Temperature Range (continuous) <sup>c</sup>		<b>W</b>	Belt Weight	Agency Acceptability: 1=White, 2=Blue, 3=Natural, 4=Grey			
				lb/ft	kg/m	lb	kg			°F	°C	lb/ft <sup>2</sup>	kg/m <sup>2</sup>
Acetal	Nylon		2500	3720	350	159	-50 to 200	-46 to 93	3.66	17.87	•	3	•

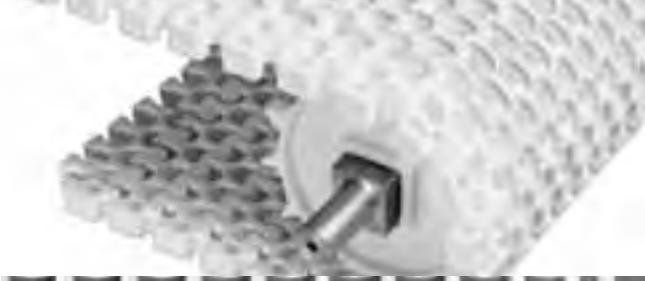
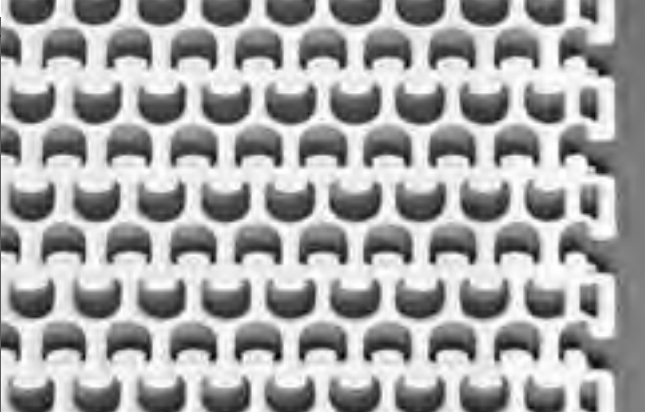
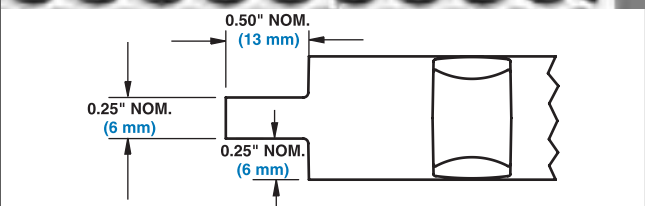
- When using Polyurethane sprockets, the Belt Strength for belts rated over 750 lb/ft (1120 kg/m) will be de-rated to 750 lb/ft (1120 kg/m) and all other belts will maintain their published rating. The temperature range for Polyurethane sprockets is 0 °F (-18 °C) to 120 °F (49 °C). Contact Customer Service for availability of Polyurethane sprockets.
- Published curved belt strengths and their method of calculation vary among spiral belt manufacturers. Please consult an Intralox Spiral Engineer for accurate comparison of curve belt strengths.
- Sideflexing applications should not exceed 180 °F (82 °C).
- Japan Ministry of Health, Labour, and Welfare
- European Migration Certificate providing approval for food contact according to EU Directive 2002/72/EC and all its amendments to date.

Radius Friction Top		
	in.	mm
Pitch	1.50	38.1
Minimum Width	5	127
Width Increments	1.00	25.4
Opening Size (approximate)	0.50 × 0.75	12.7 × 19.7
Open Area	50%	
Hinge Style	Open	
Drive Method	Hinge-driven	

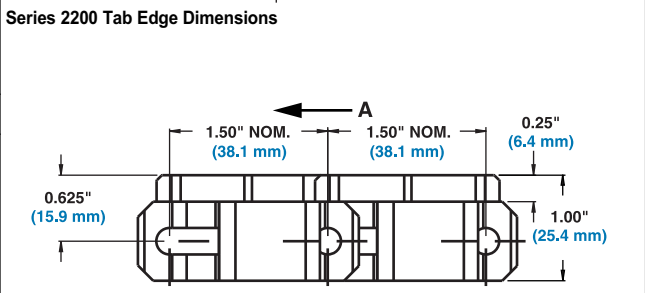
**Product Notes**

- Always check with Customer Service for precise belt width measurement and stock status before designing a conveyor or ordering a belt.
- Flush edge or tab edge available.
- Designed for radius and low-tension capstan drive spiral applications with a minimum turning radius of 2.2 times belt width (measured from inside edge).
- Indent is molded at 1.75 in. (44 mm)
- The Intralox Engineering Program will help predict the strength requirements of most radius and low-tension capstan drive spiral applications, insuring that the belt is strong enough for the application.
- Belt openings pass straight through belt, making it easy to clean.
- Non sliding drive system for reduced belt and sprocket wear, and for low back-side tension.
- Tab edge belt width is measured exclusive of tabs. (Tabs extend approx. 0.5 in. (13 mm) × 0.25 in. (6 mm) thick on each side of belt, inside wearstrip.)
- Polyethylene and/or Tab edge belts are not recommended for low-tension capstan drive spiral applications.
- Maximum belt width in turns is 36 in. (914 mm)
- Dark grey rubber has a hardness of 64 Shore A. White rubber has a hardness of 55 Shore A.
- Temperature, environmental conditions and product characteristics affect the effective maximum degree of incline. Take these items into consideration when designing conveyor systems utilizing these belts.
- Temperature, environmental conditions and product characteristics affect the effective maximum degree of incline. Take these items into consideration when designing conveyor systems utilizing these belts.

**WARNING:** Personnel must not place their fingers in or on this belt. Fingers can get trapped in the openings of this belt, resulting in personal injury. This belt also has pinch points which result from the spreading and collapsing of the belt as it flexes to follow the conveyor path. These pinch points can trap fingers, hair or clothing, and can cause personal injury. Personnel should also be instructed not to wear loose fitting clothing, loose fitting gloves or hand/finger jewelry when working near this belt. Call Customer Service for tags, flyers and stickers containing this warning.

**Series 2200 Tab Edge Dimensions**



A - Preferred direction for flat turning applications

Additional Information		
<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>		

Belt Data												
Belt Material	Standard Rod Material Ø 0.24 in. (6.1 mm)	<b>BS</b>	Straight Belt Strength	Curved Belt Strength		Temperature Range (continuous) <sup>a</sup>		<b>W</b>	Belt Weight	Agency Acceptability: 1=White, 2=Blue, 3=Natural, 4=Grey		
				lb/ft	kg/m	lb	kg			°F	°C	lb/ft <sup>2</sup>
Polypropylene	Acetal	1600	2380	350	159	34 to 150	1 to 66	2.20	10.74	1		
Polyethylene <sup>d</sup>	Acetal	1000	1490	200	91	-50 to 120	-46 to 49	2.30	11.23	•		
Polypropylene	Polypropylene <sup>e</sup>	1400	2100	200	91	34 to 150	1 to 66	2.12	10.35	1		

- a. Sideflexing applications should not exceed 180 °F (82 °C)
- b. Japan Ministry of Health, Labour, and Welfare
- c. European Migration Certificate providing approval for food contact according to EU Directive 2002/72/EC and all its amendments to date.
- d. Polyethylene cannot exceed 150 °F (66 °C)
- e. Polypropylene rods can be installed in polypropylene belts when extra chemical resistance is required. Please note lower belt strength.

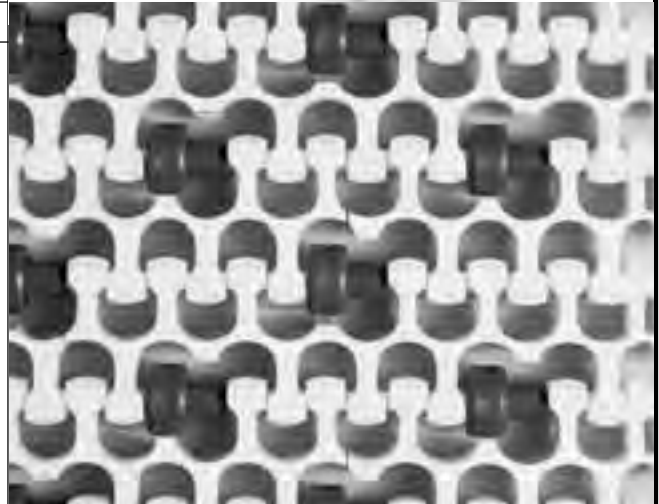
### Radius Flush Grid (2.6) with Insert Rollers

	in.	mm
Pitch	1.50	38.1
Minimum Width	7	178
Width Increments	1.00	25.4
Opening Size (approximate)	0.50 × 0.75	12.7 × 19.7
Open Area	50%	
Hinge Style	Open	
Drive Method	Hinge-driven	



#### Product Notes

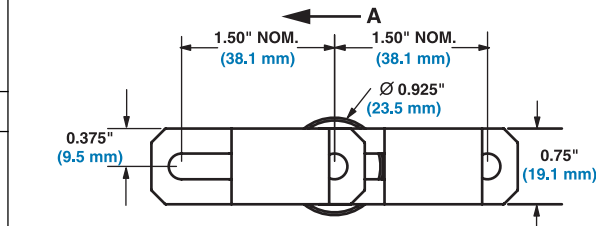
- Always check with Customer Service for precise belt width measurement and stock status before designing a conveyor or ordering a belt.
- For applications where low back pressure accumulation is required.
- Flush edge or tabbed edge available.
- Standard roller spacings across belt width: staggered - 4 in. (102 mm) or inline - 2 in. (51 mm), 3 in. (76 mm), or 4 in. (102 mm).
- Standard roller spacings along belt length: staggered - 1.5 in. (38.1 mm) or inline - 3 in. (76.2 mm).
- Minimum 2.5 in. (63.5 mm) roller indent.
- Contact Customer Service for non-standard roller placement options.
- Sprockets must NOT be placed inline with rollers.
- For low back pressure applications, place wearstrip between rollers. For driven applications, place wearstrip directly under rollers.
- Back-up load is 5% to 10% of product weight.
- Tab edge belt width is measured exclusive of tabs. (Tabs extend approx. 0.5 in. (13 mm) × 0.25 in. (6 mm) thick on each side of belt, inside wearstrip.)
- Due to roller placement, the turning radius increases to 2.6. Belts 16 in. (406 mm) wide and less have a turn ratio of 2.2.
- Contact Sales Engineering before using a belt width greater than 24 in. (610 mm).



**WARNING:** Personnel must not place their fingers in or on this belt. Fingers can get trapped in the openings of this belt, resulting in personal injury. This belt also has pinch points which result from the spreading and collapsing of the belt as it flexes to follow the conveyor path. These pinch points can trap fingers, hair or clothing, and can cause personal injury. Personnel should also be instructed not to wear loose fitting clothing, loose fitting gloves or hand/finger jewelry when working near this belt. Call Customer Service for tags, flyers and stickers containing this warning.

#### 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)



A - Preferred direction for flat turning applications

### Belt Data

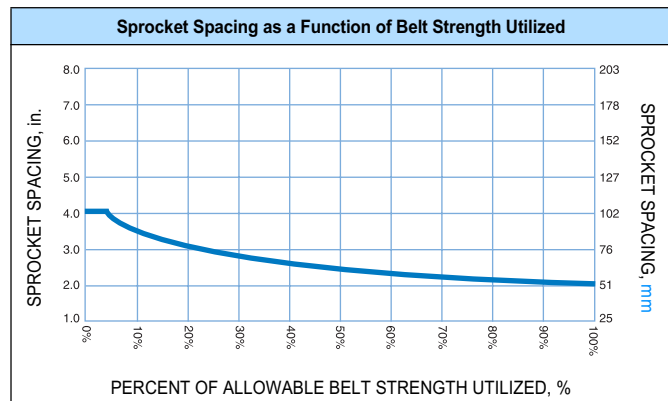
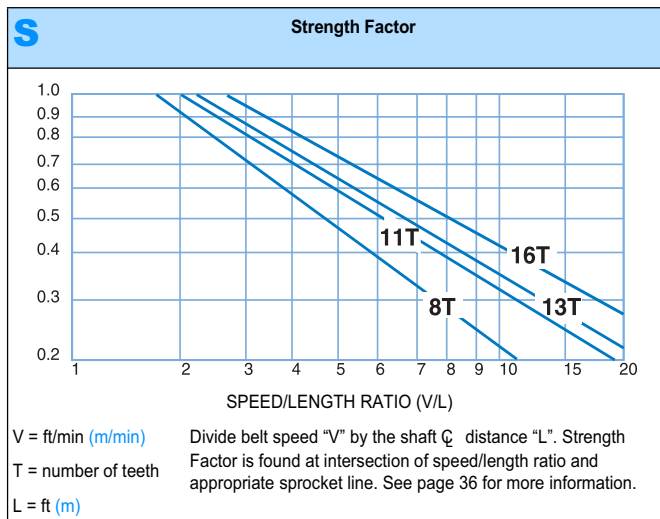
Belt Material	Standard Rod Material Ø 0.24 in. (6.1 mm)	BS	Straight Belt Strength						Roller Indents		Curved Belt Strength		Temperature Range <sup>a</sup> (continuous)		W	Belt Weight	Agency Acceptability: 1=White, 2=Blue, 3=Natural, 4=Grey				
			Roller Width Spacing						in.	mm	lb	kg	°F	°C			lb/ft <sup>2</sup>	kg/m <sup>2</sup>	FDA (USA)	J <sup>b</sup>	EU MC <sup>c</sup>
			2 in.	51 mm	3 in.	7.6 mm	4 in.	102 mm													
Polypropylene	Acetal	400	600	710	1060	900	1340	2.5	64	260	120	34 to 200	1 to 93	1.86	9.08	•	3	•			
								3.5 to 4.5	89 to 114	350	160										
Acetal	Nylon	630	940	1110	1650	1410	2100	2.5	64	260	120	-50 to 200	-46 to 93	2.82	13.8	•	3	•			
								3.5 to 4.5	89 to 114	350	160										
Polypropylene	Polypropylene <sup>d</sup>	350	520	620	920	790	1180	2.5	64	150	70	34 to 220	1 to 104	1.78	8.69	•	3	•			
								3.5 to 4.5	89 to 114	200	90										

a. Sideflexing applications should not exceed 180 °F (82 °C).  
 b. Japan Ministry of Health, Labour, and Welfare  
 c. European Migration Certificate providing approval for food contact according to EU Directive 2002/72/EC and all its amendments to date.  
 d. Polypropylene rods can be installed in polypropylene belts when extra chemical resistance is required. Please note lower belt strength.

## Sprocket and Support Quantity Reference<sup>a</sup>

Belt Width Range <sup>b</sup>		Minimum Number of Sprockets Per Shaft <sup>c</sup>	Wearstrips <sup>d</sup>	
in.	mm		Carryway	Returnway
5	127	2	2	2
6	152	2	2	2
7	178	2	2	2
8	203	2	2	2
10	254	3	3	2
12	305	3	3	2
14	356	5	3	3
15	381	5	3	3
16	406	5	3	3
18	457	5	3	3
20	508	5	4	3
24	610	7	4	3
30	762	9	5	4
32	813	9	5	4
36	914	9	5	4
42	1067	11	6	5
48	1219	13	7	5
54	1372	15	7	6
60	1524	15	8	6
72	1829	19	9	7
84	2134	21	11	8
96	2438	25	12	9
120	3048	31	15	11
144	3658	37	17	13
For Other Widths, Use Odd Number of Sprockets at Maximum 4 in. (102 mm) $\varnothing$ Spacing		Maximum 9 in. (229 mm) $\varnothing$ Spacing	Maximum 12 in. (305 mm) $\varnothing$ Spacing	

- For low-tension capstan drive spirals contact Technical Support Group for suggested carryway support recommendations.
- 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 minimum width of 5 in. (127 mm). If the actual width is critical, consult Customer Service. Intralox does not recommend turning belts wider than 36 in. (914 mm). For turning applications that require wider belts, contact Intralox Sales Engineering.
- These are the minimum number of sprockets. Additional sprockets may be required for heavily loaded applications (sprockets should be placed every inch for heavily loaded applications). See Retainer Rings/Center Sprocket Offset chart on page 304 for lock down location.
- The number of wearstrips given does not include the hold down wearstrip.



Sprocket Data <sup>a</sup>										
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%)	3.9	99	4.0	102	1.0	25		1.5		40
13 (2.91%)	6.3	160	64	163	1.0	25		2.5		60
16 (1.92%)	7.7	196	7.8	198	1.0	25		1.5		40
								2.5		60

1 - Pitch diameter  
2 - Outer diameter  
3 - Hub width  
4 - Section A-A

a. Contact Customer Service for lead times.

EZ Clean Sprocket Data <sup>a</sup>										
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
11 (4.05%)	5.3	135	5.4	137	1.0	25		1.5		40
13 (2.91%)	6.3	160	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 750 lb/ft (1120 kg/m) will be de-rated to 750 lb/ft (1120 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.

Split Sprocket Data <sup>a</sup>										
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
13 (2.91%)	6.3	160	6.4	163	1.5	38	1-7/16 <sup>b</sup>	1.5		

a. Contact Customer Service for lead times.  
b. Tight fit round bore.

**Streamline Flights**

Available Flight Height		Available Materials
in.	mm	
4	102	Polypropylene, Polyethylene

**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:** Flights can be provided in linear increments of 1.5 in. (38 mm).

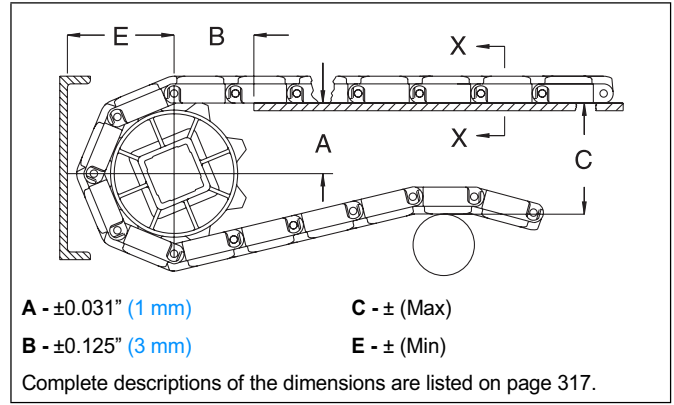
**Note:** The standard indent is 5/8 in. (15.9 mm).



## 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.



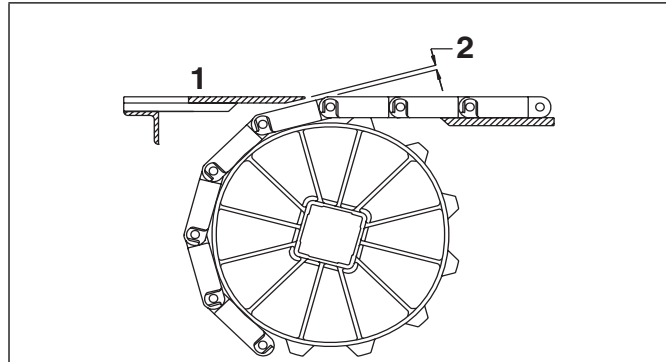
Sprocket Description			A		B		C		E	
Pitch Diameter		No. Teeth	Range (Bottom to Top)		in.	mm	in.	mm	in.	mm
in.	mm		in.	mm						
<b>SERIES 2200 FLUSH GRID</b>										
3.9	99	8	1.44	37	1.93	49	3.92	100	2.40	61
5.3	135	11	2.18	55	2.27	58	5.32	135	3.10	79
6.3	160	13	2.67	68	2.52	64	6.27	159	3.57	91
7.7	196	16	3.40	86	2.78	71	7.69	195	4.28	109
<b>SERIES 2200 FRICTION TOP</b>										
3.9	99	8	1.44-1.58	36-40	1.93	49	4.17	106	2.65	67
5.3	135	11	2.18-2.29	55-58	2.27	58	5.57	142	3.35	85
6.3	160	13	2.67-2.76	68-70	2.52	64	6.52	166	3.82	97
7.7	196	16	3.40-3.47	86-88	2.78	71	7.94	202	4.53	115
<b>SERIES 2200 FLUSH GRID WITH INSERT ROLLERS</b>										
3.9	99	8	1.44-1.58	36-40	1.93	49	4.00	102	2.48	63
5.3	135	11	2.18-2.29	55-58	2.27	58	5.42	138	3.19	81
6.3	160	13	2.67-2.76	68-70	2.52	64	6.36	162	3.66	93
7.7	196	16	3.40-3.47	86-88	2.78	71	7.78	198	4.37	111
<b>SERIES 2200 FLUSH GRID HIGH DECK</b>										
3.9	99	8	1.44-1.58	36-40	1.93	49	4.42	112	2.90	74
5.3	135	11	2.18-2.29	55-58	2.27	58	5.82	148	3.60	91
6.3	160	13	2.67-2.76	68-70	2.52	64	6.77	172	4.07	103
7.7	196	16	3.40-3.47	86-88	2.78	71	8.19	208	4.78	121



**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.



1 - Top surface of dead plate      2 - Dead plate gap

**Note:** The top surface of the dead plate is typically 0.031 in. (0.8 mm) above the belt surface for product transfer onto the belt, and 0.031 in. (0.8 mm) below the belt surface for product transfer off the belt.

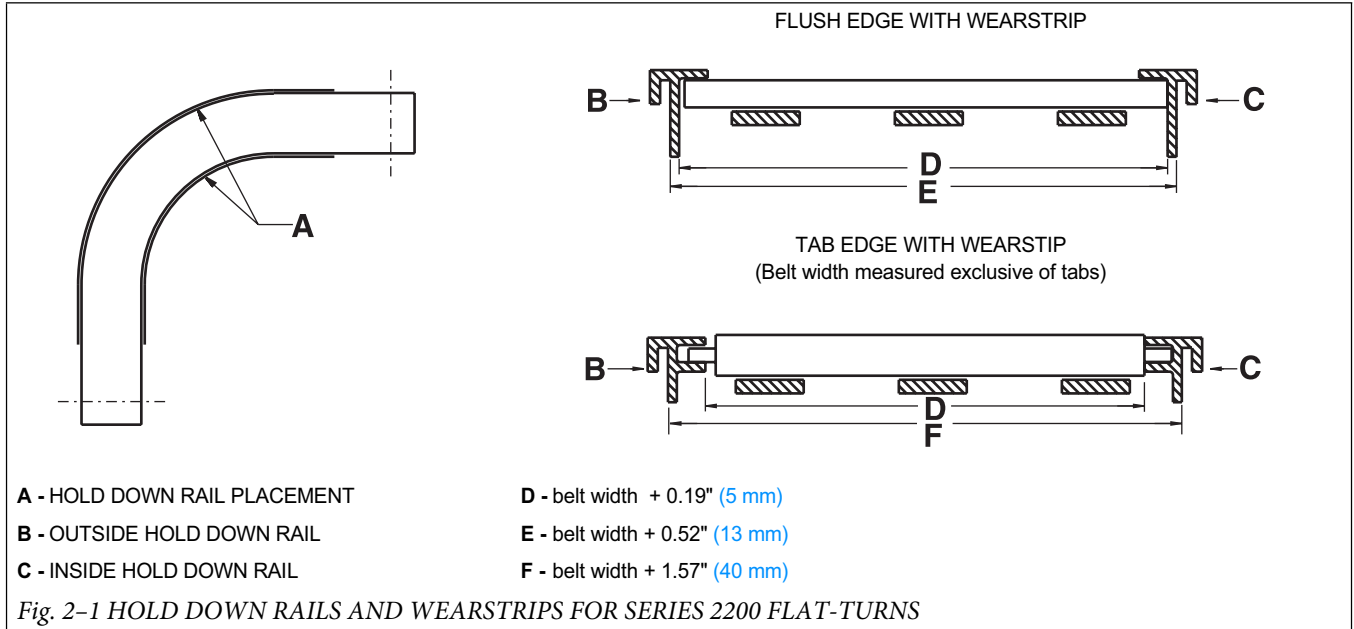
Sprocket Description			Gap	
Pitch Diameter		No. Teeth	in.	mm
in.	mm			
3.9	99	8	0.150	3.8
5.3	135	11	0.108	2.8
6.3	160	13	0.091	2.3
7.7	196	16	0.074	1.9

### HOLD DOWN RAILS AND WEARSTRIPS

Intralox recommends using continuous hold down rails through an entire turn, starting at a distance of 1X the belt width before the turn and ending 1X the belt width after the turn. This applies to both carryway and returnway. The use of

hold down rails along both side of the belt over the full carryway is recommended but not mandatory.

**Series 2200** is available with and without an edge tab. A wearstrip style is available for each edge style. The tab edge design allows the belt to be held down without the wearstrip interfering with the carryway surface. See “*Custom wearstrips*” (page 310).



### BELT SELECTION INSTRUCTIONS

#### ENGINEERING PROGRAM ANALYSIS FOR SERIES 2200

Intralox Customer Service Technical Support Group can calculate the estimated belt pull for radius applications using **Series 2200**. The following information is required (refer to “*Radius belt data sheet*” (page 361)):

- Any environmental conditions which may affect the friction coefficient (for dirty or abrasive conditions, use higher friction coefficients than normal)
- Belt width
- Length of each straight run
- Turning angle of each turn

- Turn direction of each turn
- Inside turning radius of each turn
- Carryway/hold down rail material
- Product loading lb/ft<sup>2</sup> (kg/m<sup>2</sup>)
- Product back-up conditions
- Belt speed
- Elevation changes on each section
- Operating temperatures.

**For assistance with radius belt and low-tension capstan drive spiral selections, contact Intralox Customer Service Technical Support Group. The Engineering Program should be run to insure that the belt is strong enough for the radius application in question.**

**SERIES 2200 DESIGN GUIDE SUMMARY**

For more information, see the *Installation, Maintenance and Troubleshooting manual* available from Intralox.

- A** - The minimum and recommended turning radius for **Series 2200** is 2.2 times the belt width, measured from the inside edge.
- B** - The minimum straight run required between turns of opposing direction is 2.0 times the belt width. Shorter straight sections will lead to high wear on the edge guide rail and high pull stresses in the belt.
- C** - There is no minimum straight run required between turns that are in the same direction.
- D** - The minimum length for the final straight run (leading into the drive shaft) is 1.5 times the belt width. Shorter lengths may lead to sprocket wear or tracking problems. For narrow belts, a weighted take-up may be required since proper catenary cannot be achieved therefore, a 5 ft. (1.50 m) minimum final straight run is recommended. See "Special Take-Up Arrangements" (page 324).

- E** - The minimum length of the first straight run (immediately after the idle shaft) is 1.5 times the belt width. When shorter lengths are required (down to 1.0 times the width), an idle roller may be used in place of sprockets.
- F** - IDLE SHAFT
- G** - 1ST TURN
- H** - BELT WIDTH
- I** - BELT TRAVEL
- J** - 2ND TURN
- K** - DRIVE MOTOR
- L** - DRIVE SHAFT

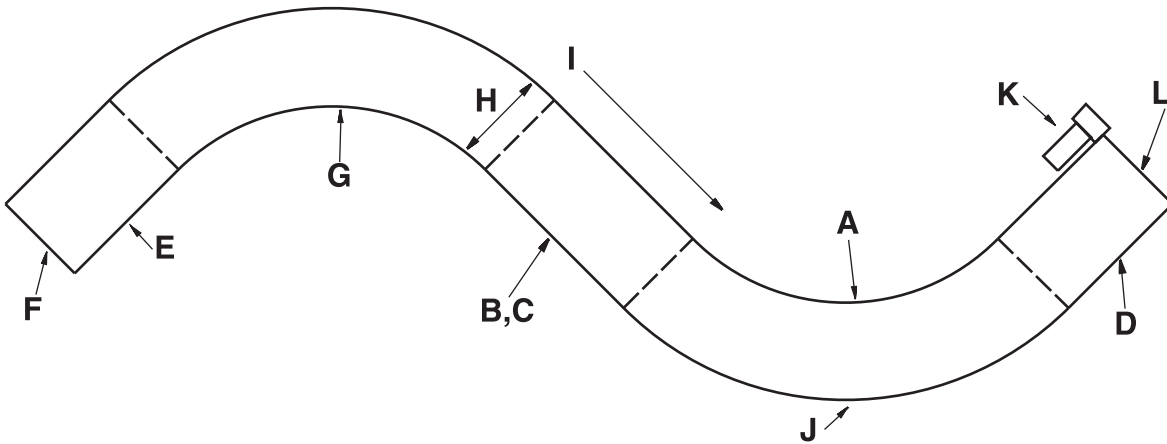


Fig. 2-2 TYPICAL 2-TURN RADIUS LAYOUT

