

Product Manual **V-Belt Live Roller Conveyor**

Application Guidelines, Specifications, Installation
Procedures, Maintenance, Parts Identification, and
Product Index



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Read these documents thoroughly before attempting to perform maintenance or repairs to the applicable Intelligrated conveyor system components or devices. Exercise extreme caution when working around moving and rotating conveyor equipment. Wear the proper clothing and safety equipment. DO NOT attempt to perform any maintenance until the equipment is de-energized, locked out and tagged out in accordance with established company procedures.

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Package Conveyors



 <p>Do Not Climb, Sit, Stand, Walk, Ride, or Touch the Conveyor at Any Time</p>	 <p>Do Not Perform Maintenance on Conveyor Until Electrical, Air, Hydraulic and Gravity Energy Sources Have Been Locked Out or Blocked</p>	 <p>Operate Equipment Only With All Approved Covers and Guards in Place</p>
 <p>Do Not Load a Stopped Conveyor or Overload a Running Conveyor</p>	 <p>Ensure That All Personnel Are Clear of Equipment Before Starting</p>	 <p>Allow Only Authorized Personnel To Operate or Maintain Material Handling Equipment</p>
 <p>Do Not Modify or Misuse Conveyor Controls</p>	 <p>Keep Clothing, BodyParts, and Hair Away from Conveyors</p>	 <p>Remove Trash, Paperwork, and Other Debris Only When Power is Locked Out and Tagged Out</p>
 <p>Ensure That ALL Controls and Pull Cords are Visible and Accessible</p>	 <p>Know the Location and Function of All Stop and Start Controls</p>	 <p>Report All Unsafe Conditions Jams should be cleared ONLY BY Authorized, Trained, Personnel</p>

POST IN PROMINENT AREA

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Product Manual Revision Summary

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December 2006	Section A, Section B, Section C, Section G, and Section I	Bearing update, text and graphic changes Update Part Numbers in Section I.
July 2007	Section I	Key No. changed on page I-13.
August 2007	Section G	Change text regarding tightening bolts to 9 ft.-lbs. of torque.
March 2011	Section I	Changed Figure I-19 on page I-16.

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SECTION A: PRODUCT SUMMARY
V-Belt Live Roller Conveyor Product Summary

Table A 1: Product Summary for V-Belt Live Roller Conveyor - Curves and Junctions

Conveyor	Components				
Model VBLR	Widths "W"	Roller Centers	Carrier Rollers	Belting	
Type/Function Transportation Curves, S-Curves, Junctions, and Parallel Junctions	16" 22" 28" 34" 40"	3" Straight 2-5/8" Curves 2" Straight 1-3/4" Curves	G254HS/A1 G196A1 G196GH	"B" Section V-Belt	
Comments	Curves 2'-6" IR and TT	Speeds (FPM)	Extensions	Live Load Capacity	
Pressure Sheaves Have Eccentric Vertical Adjustment.	30°, 45°, 60°, 90°, and 180°; Right or Left Hand	See Table A-5 and Table A-6.	Infeed and/or Discharge Extension May Be Split Between Infeed and Discharge; Extensions Offered in 1" Increments.	Curve or Junction - 70 Lbs./Ft. Max.; Skew - 50 lbs./ft. Max.	
	Motor/Reducer	Spurs	Spur/Curve	Spur/Curve	
	Reliance, U.S. Motor, Boston, Baldor; 1/2, 3/4, 1, 1-1/2 HP; Flange Side Mounted/ Underhung	30°, 45° RH or LH	30° Spur/60° Curve - RH or LH 45° Spur/45° Curve - RH or LH	90° - RH or LH	
	Fixed Side Guides		Adjustable Side Guides		
	Mounting Type	Rail Type	Mounting Type	Rail Type	
	A: 1-3/4 Angle B: 2-5/8" Channel C: 7" Channel D: 10" Channel	A: Bolt-to-Frame B: Spacer Nuts C: Inset - 2" Outset - 2"	E: Single Rail F: Double Rail G: Set In Single Rail	D: Adjustable Arm	
	Supports/Hangers	PTOs	Accessories	Paint	
	1500# or 2500# Sup- ports Hanger w/o Rods Hanger w/1'-6" Rods Hanger w/12'-0" Rods	Live Roller to Live Roller Drive; Live Roller to Belt Drive	Traffic Controller Case Deflector - Air-Operated RH or LH	Medium Gray	
	Leo Designation: V/B - Curves and Junctions				

Table A 2: Product Summary for V-Belt Live Roller Conveyor - Straight Units

Conveyor	Components			
Model VBLR	Widths "W"	Roller Centers	Carrier Rollers	Belting
Type/Function Transportation Straight Units	16" 22" 28" 34" 40"	2", 3"	G196GH G196A1	"B" Section V-Belt.
Comments	Drive Unit	Idler End	Intermediate	1" Increment O.A. Lengths
Pressure Sheaves Have Eccentric Vertical Adjustment.	Infeed End Only Length - 1'-2".	Length - 1'-2"	Intermediate in 1" increments from 10" to 184".	3'-2" to 17'-8"; Right or Left Hand
		Speeds (FPM)	Motor/Reducer	Capacity Live-Load
		See and	1/2, 3/4, 1, 1-1/2 HP; Flange-Side Mounted/Underhung	70 Lbs./Ft. Max.
	PTO's	Supports/Hangers	Options	Paint
	Live Roller to Live Roller Drive; Live Roller to Belt Drive	1500# or 2500# Supports; Hanger w/o Rods; Hanger w/1'-6" Rods; Hanger w/12'-0" Rods	Traffic Controller; Case Deflector; Air-Operated Right or Left Hand	Medium Gray
	Fixed Side Guides		Adjustable Side Guides	
	Rail Type	Mounting Type	Rail Type	Mounting Type
	Bolt-to-Frame Spacer Nuts Inset - 2" and Offset 2" Bracket	1-3/4" Angle 2-5/8" Channel 7" Channel 10" Channel	Straight Arm Offset Arm	Single Rail Double Rail
Leo Designation: V/B - Straights				

Table A 3: Product Summary for V-Belt Live Roller Conveyor - Merge/Diverge/Crossover

Conveyor	Components			
Model VBLR	Widths "OAW" *	Assembly Lengths "W"	Roller Centers	Carrier Rollers
Type/Function Transportation Merge/Diverge/ Crossover	41"	"W"= 41" - 10'	3" Grooved Rollers with "O"-Rings at Infeed and discharge ends	G196A1 G196GH Maximum Length Roller is 44".
	53"	"W"= 53" - 10' or 15'		
	65"	"W"= 65" - 10' or 15'		
	77"	"W"= 77" - 15'		
	89"	"W"= 89" - 15'		
Comments	Belting	Capacity Live-Load	Motor/Reducer	Speeds (FPM)
*OAW = Standard "W" Plus Nine Inches (For Example, "W" = 16 2 x 16 = 32 plus 9 = OAW of 41"). Pressure Sheaves Have Eccentric Vertical Adjustment.	"B" Section V-Belt.	50 Lbs./Ft Max.	1/2, 3/4, 1, 1-1/2 HP; 2 Flange-Mounted Drives for Bed; 1 Drive for Diverge/ Crossover Divert Arm	See .
		Supports/Hangers	Divert Arm	Paint
		1500 Lb. or 2500 Lb. Supports; Hanger w/o Rods; Hanger w/1'-6" Rods; Hanger w/12'-0" Rods;	Right or Left Hand; Merge - Fixed Channel Guide. Diverge/Crossover - Electric Motor Operated.	Medium Gray
	Fixed Side Guides		Adjustable Side Guides	
	Rail Type	Mounting Type	Rail Type	Mounting Type
	Bolt-to-Frame Spacer Nuts Inset - 2" and Offset 2" Bracket	1-3/4" Angle 2-5/8" Channel 7" Channel 10" Channel	Straight Arm Offset Arm	Single Rail Double Rail
	Leo Designation VBC - Crossover, VBD - V-Belt Diverge, VBM - V-Belt Merge			

Table A 4: Product Summary for V-Belt Live Roller Conveyor - Skews

Conveyor	Components			
Model VBLR	Widths	Assembly Lengths "W"	Roller Centers	Carrier Rollers
Type/Function Transportation Skews	16"	10'-0"	3" Grooved CTR Rollers with "O"-rings at Infeed and Discharge Ends	G196A1; G196GH
	22"	10'-0", 15'-0"		
	28"	10'-0", 15'-0"		
	34"	10'-0", 15'-0" 20"		
	40"	10'-0", 15'-0" 20"		
Comments	Belting	Capacity Live-Load	Motor/Reducer	Speeds (FPM)
Pressure Sheaves Have Eccentric Vertical Adjustment. Drive Available Either Side, Regardless of Skew Direction. Motor Drive at Infeed End Only; PTOs Available Either End. PTO Shaft is ALWAYS on the Same Side as the Driving V-Belt.	"B" Section V-Belt	Skew 50 Lbs./Ft. Max.	1/2, 3/4, 1, 1-1/2 HP Flange-Side Mounted/Underhung	See .
	Skew Angle	Supports/Hangers	PTOs	Paint
	8°	1500 Lb. or 2500 Lb. Supports; Hanger w/o Rods; Hanger w/1'-6" Rods; Hanger w/12'-0" Rods	Live Roller to Live Roller Drive; Live Roller to Belt Drive; Skewed Live Roller; Right or Left Hand	Medium Gray
	Fixed Side Guides		Adjustable Side Guides	
	Rail Type	Mounting Type	Rail Type	Mounting Type
	1-3/4" Angle 2-5/8" Channel 7" Channel 10" Channel	Bolt-to-Frame Spacer Nuts Inset - 2" and Offset 2" Bracket	Single Rail Double Rail	Straight Arm Offset Arm
	Leo Designation: VBS - V-Belt Skew			

Table A 5: Available Horsepower/Speed Combinations for Flange Drives

Base Spd (FPM)	Reliance HP				Boston HP				Winsmith HP				US HP			
	1/2	3/4	1	1-1/2	1/2	3/4	1	1-1/2	1/2	3/4	1	1-1/2	1/2	3/4	1	1-1/2
	Reducer Model 200				Reducer Model 721				Reducer Model 920				Reducer Model 6GWV			
93	X	X	X		X	X	X		X	X	X					
112	X	X	X		X	X	X		X	X	X					
139	X	X	X		X	X	X		X	X	X					
155	X	X	X													
187	X	X	X		X	X	X		X	X	X					
220	X	X	X													
280			X	X			X	X			X	X				
372			X	X							X	X				
89														X	X	
134														X	X	
200														X	X	
367															X	

X = Available

Table A 6: Available Horsepower/Speed Combinations for Underhung Drives

Driver Pulley	Base Speed (FPM)	Reliance HP					Boston HP					Winsmith HP				
		1/2	3/4	1	1-1/2	Ratio	1/2	3/4	1	1-1/2	RATIO	1/2	3/4	1	1-1/2	Ratio
		Reducer Model 200					Reducer Model 721					Reducer Model 920				
24	75	X				30:1	X				30:1	X				30:1
24	90	X				25:1	X				25:1	X				25:1
26	100	X				25:1	X				25:1	X				25:1
22	120	X	X			18:1					18:1					18:1
26	140	X	X			18:1					18:1					18:1
24	154	X	X	X		18:1	X	X	X		18:1	X	X	X		18:1
24	180	X	X	X		15:1	X	X	X		15:1	X	X	X		15:1
22	210	X	X	X		10:1	X	X	X		10:1	X	X	X		10:1
24	240	X	X	X		10:1	X	X	X		10:1	X	X	X		10:1
26	255	X	X	X		10:1	X	X	X		10:1	X	X	X		10:1
22	289	X	X	X	X	8:1						X	X	X	X	7.5:1
24	300	X	X	X	X	8:1						X	X	X	X	7.5:1
28	350	X	X	X	X	8:1						X	X	X	X	7.5:1
30	370	X	X	X	X	8:1						X	X	X	X	7.5:1
32	400	X	X	X	X	8:1						X	X	X	X	7.5:1
	Reducer	200	200	200	200		721	721	721	721		920	920	920	920	

X = Available

Driven Pulley (8 MM HTD) = 40 for All Speeds.

SECTION B: APPLICATION GUIDELINES

Introduction

Product Line

The V-Belt Live Roller (VBLR) conveyor provides curves, s-curves, junctions, parallel junctions, straights, skews, and merge/diverge/crossover sections. Each type has channel sides with bolted cross-bracing. Figure B - 1 illustrates some of the features offered in the VBLR product line.

The carrier rollers are powered from below by an endless V-belt which runs throughout the length of a unit, and receives its driving power from either an integral drive/power unit assembly or a power take-off (PTO) drive assembly connected to an adjacent unit. In addition to the basic VBLR models, combinations can be formed using two or more of the base units. Also, extensions can be added to either, or both, end(s) of curves.

Functions

The VBLR conveyor is used:

- to accomplish a change in direction.
- to feed one line into the side of another.
- to receive product diverted from one conveyor onto another.

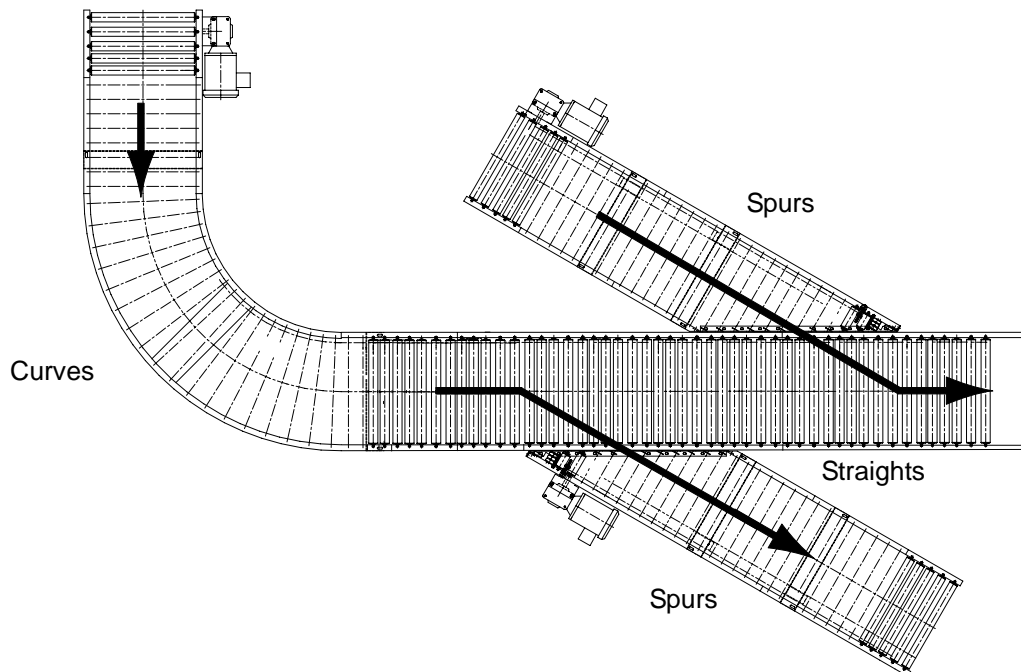


Figure B - 1 VBLR Conveyor Setup Example

Capabilities

The VBLR units are available in nominal widths of 16", 22", 28", 34" and 40" measured between the side frames. The inside radius of curves is measured to the inside of the near side frame member. A significant factor in the choice of a conveyor width is how the intended product will convey around curves. The following calculations (see and Table B 2:) can be used to determine the minimum width curve to carry a given size product, or the largest product that can be carried on a given width curve.

Table dimensions are based on the product being conveyed within the nominal conveyor width, "W" (see and Table B 2:).

The "X" in and Table B 2: indicate a product size which requires a curve width larger than the 40" standard. Such products might be carried on a smaller curve if they are allowed to overhand the rails.

Table B 1: Curve Widths for Various Product Sizes (2'-6" IR)

Dim	Package Length												
	12"	16"	20"	24"	28"	32"	36"	40"	44"	48"	52"	56"	60"
Package Width	2'-6" IR (All Widths)												
6"	16"	16"	16"	16"	16"	16"	16"	16"	16"	16"	22"	22"	22"
8"	16"	16"	16"	16"	16"	16"	16"	16"	22"	22"	22"	22"	22"
10"	16"	16"	16"	16"	16"	16"	22"	22"	22"	22"	22"	22"	28"
12"	16"	16"	16"	22"	22"	22"	22"	22"	22"	22"	22"	22"	28"
14"	22"	22"	22"	22"	22"	22"	22"	22"	22"	28"	28"	28"	28"
16"	22"	22"	22"	22"	22"	22"	28"	28"	28"	28"	28"	28"	28"
18"	22"	22"	22"	28"	28"	28"	28"	28"	28"	28"	28"	34"	34"
20"	28"	28"	28"	28"	28"	28"	28"	28"	28"	28"	34"	34"	34"
22"	28"	28"	28"	28"	28"	28"	28"	34"	34"	34"	34"	34"	34"
24"	28"	28"	28"	34"	34"	34"	34"	34"	34"	34"	34"	34"	40"
26"	34"	34"	34"	34"	34"	34"	34"	34"	34"	34"	40"	40"	40"
28"	34"	34"	34"	34"	34"	34"	34"	40"	40"	40"	40"	40"	40"
30"	34"	34"	34"	40"	40"	40"	40"	40"	40"	40"	40"	40"	
32"	40"	40"	40"	40"	40"	40"	40"	40"	40"	40"	X	X	X
34"	40"	40"	40"	40"	40"	40"	40"	X	X	X	X	X	X
36"	40"	40"	40"	X	X	X	X	X	X	X	X	X	X

Note: Some of the theoretical product shapes are stated in as though they are being conveyed width-wise. In these cases, the resulting conveyor width requirement is for that orientation. A more logical orientation would be conveyance in the normal position of length aligned with the direction of travel.

Table B 2: Curve Width Selection - "W"

Dim	Package Length												
	12"	16"	20"	24"	28"	32"	36"	40"	44"	48"	52"	56"	60"
Package Width	Model TTF - Variable I.R.												
6"	16"	16"	16"	16"	16"	16"	16"	16"	16"	16"	22"	22"	22"
8"	16"	16"	16"	16"	16"	16"	16"	16"	16"	22"	22"	22"	22"
10"	16"	16"	16"	16"	16"	16"	16"	16"	22"	22"	22"	22"	28"
12"	16"	16"	16"	16"	22"	22"	22"	22"	22"	22"	22"	22"	28"
14"	22"	22"	22"	22"	22"	22"	22"	22"	22"	22"	28"	28"	28"
16"	22"	22"	22"	22"	22"	22"	22"	28"	28"	28"	28"	28"	28"
18"	22"	22"	22"	28"	28"	28"	28"	28"	28"	28"	28"	28"	28"
20"	28"	28"	28"	28"	28"	28"	28"	28"	28"	28"	28"	34"	34"
22"	28"	28"	28"	28"	28"	28"	28"	28"	34"	34"	34"	34"	34"
24"	28"	28"	28"	28"	34"	34"	34"	34"	34"	34"	34"	34"	34"
26"	34"	34"	34"	34"	34"	34"	34"	34"	34"	34"	34"	34"	40"
28"	34"	34"	34"	34"	34"	34"	34"	34"	34"	40"	40"	40"	40"
30"	34"	34"	34"	34"	40"	40"	40"	40"	40"	40"	40"	40"	40"
32"	40"	40"	40"	40"	40"	40"	40"	40"	40"	40"	40"	40"	40"
34"	40"	40"	40"	40"	40"	40"	40"	40"	40"				
36"	40"	40"	40"	40"	40"								

The VBLR conveyor will convey items which have a firm and flat bottom surface, including items such as cartons, cases, tote pans, drums, etc. Junctions require that the conveyed items have side surfaces that can withstand the impact and contact with a deflector or turning wheel.

The minimum length is determined by the requirement that there be at least three rollers under the bottom of the conveyed items at all times. For standard junctions with carrier rollers on 3" centers, this would make the minimum product length 9". For curves of different widths, Table B 2: indicates the nominal minimum product size based on three rollers being under the product at different locations along the curve width. Use the R2 dimension, as shown in Figure B - 2, for the minimum product dimension. Use R3 if narrow items are to be conveyed on wide curves. If the items can be aligned to the inside rail, the more common 9" standard can be applied.

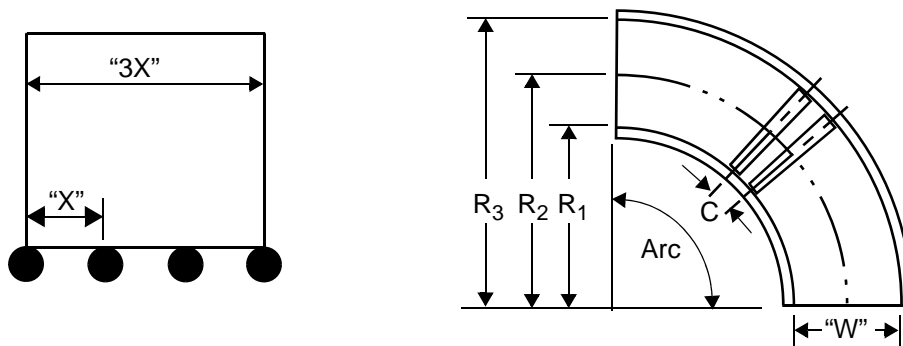


Figure B - 2 Minimum Item Length and Curve Roller Center Dimensions

Table B 3: Minimum Product Sizes for Curves

Minimum Product Size @	Conveyor Width "W", 2'-6" IR, 3" Ctrs.					Conveyor Width "W", True Taper, 2" Ctrs.				
	16"	22"	28"	34"	40"	16"	22"	28"	34"	40"
R1	8"	8"	8"	8"	8"	5-1/2"	5-1/2"	5-1/2"	5-1/2"	5-1/2"
R2	10"	11"	12"	13"	13"	7"	7"	7"	7"	7"
R3	13"	14"	15"	17"	18"	8-1/2"	8-1/2"	8-1/2"	8-1/2"	9"

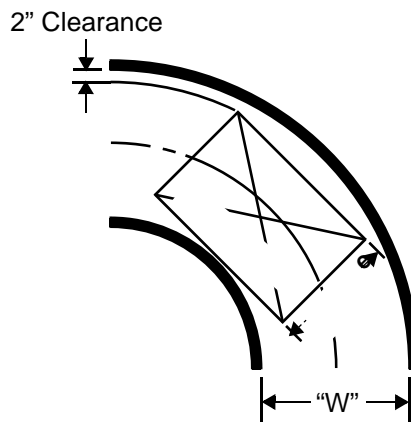


Figure B - 3 Curve Section

The VBLR conveyor is intended for transportation use only; accumulation of product on the carrier rollers, especially on curves, may damage the product and will ultimately cause damage to the equipment. Pressure sheaves should be field positioned to apply just enough pressure to the carrier rollers to move the heaviest load.

Speeds range from 71 to 434 feet per minute (fpm), measured directly above the drive belt. Carrying speeds are uniform across the width for straight sections. For curves the surface speed is the driven speed only at a point on the rollers directly above the drive belt. Because of the tapered rollers in the curves, the surface speed at the larger outer ends of the rollers is much higher. This tends to move the outer edges of products around the curves faster and keep the axis of the products parallel to the direction of travel and the centerline of the conveyors.

Note: Packages will enter and exit in the same orientation only on true taper curves.

Likewise, correct speed of operation is important. VBLR units should run faster than the feeding units and equal to, or slower than, the receiving units so that product items are not forced onto the VBLR units nor restrained from leaving them.

Note: The VBLR conveyor is designed for horizontal applications only and should not be pitched up or down.

Requirements falling outside those outlined above should be addressed to the manufacturer for special consideration.

Advantages

The VBLR conveyor fills a need when there is a required change in direction, a merge, a divert, or a need for alignment. This type of conveyor can also fill an odd-length requirement by using an appropriate length extension. VBLR conveyors are simple to install, adjust, and maintain and are very quiet. The conveyor length is limited because of the available V-belt length limitations. The V-belts applied as original equipment are readily available for replacement purposes.

Large Conveyors

Some VBLR conveyors are too large to ship in one piece. If conveyors exceed certain size limitations they are shipped in sections that must be assembled. Section G of this manual contains general guidelines that can be used to determine how a unit may be shipped, and critical adjustments that should be made when assembling in the field.

Product Description

Equipment

Frames

The VBLR conveyor has 10 gauge formed steel side channels 10" deep with 1-1/4" inch flanges. Tube-type cross members are bolted between side channels to form a rigid frame. Heavy duty channel-type spreaders are used at the midpoints of curves to support the return belt idler sheaves. Tube cross ties are used on 3" center curves; bolt-in carrying rollers are used as ties on 2" center assemblies.

The frame members are not provided with pop-out slots. The V-belt driving medium is narrow and occupies a known path along one side of the assembly and is guarded by finger guards located over the belt path between each pair of rollers.

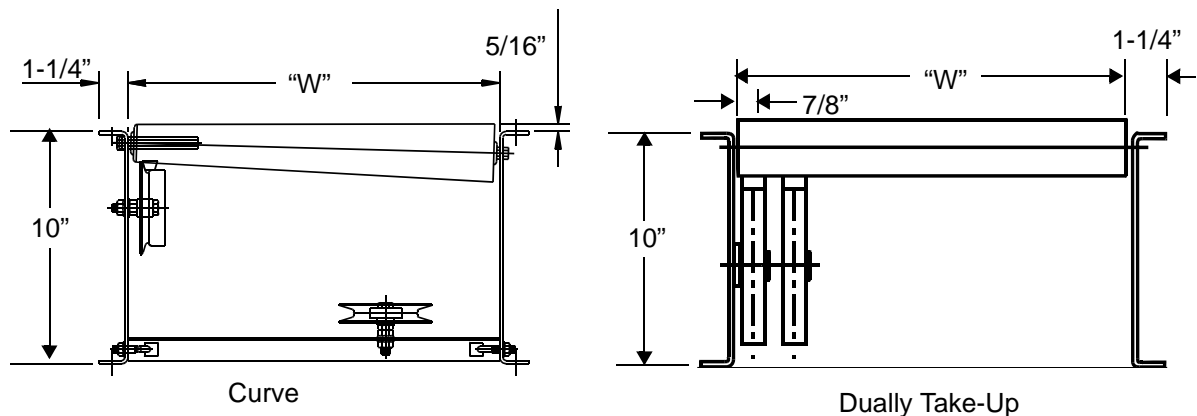


Figure B - 4 Standard Curve Cross-Section and Dually Take-Up Cross-Section

Rollers

The carrier rollers for all straight sections and straight ends of curves are standard 1.9" diameter, 16 ga. galvanized steel rollers with pressed-in ball bearings on 7/16" hex shafts spaced on 2" or 3" centers.

The carrier rollers in curves are tapered with the small end at 1-5/8" diameter and the large end at 2-1/2" diameter. Spacing at the inside rail is 2-5/8" or 1-3/4" (3" or 2" centers); spacing at the outside rail varies from about 3" for 16" wide curves to just over 6" for 40" wide curves for 2'-6" IR. True taper close center curves have 3" centers on the outside rail.

The outside rails for 2'-6" IR curves are punched with three axle holes spaced 3/4" apart for each roller, except for close center (2") curves. This allows rollers to be "skewed" to adjust for tracking of product around the curves.

V-Belts

The drive belts are unspliced, continuous standard "B" section V-belts of the correct length for the conveyor in which they are installed. They are guided over sheaves which are adjustable vertically to apply driving pressure to the bottoms of the carrier rollers. The belts are routed through the drive path in such a manner that the belt is never "bent backwards." That is, the

belt is never bent so that the wide surface is on the inside of the bend curve. This avoidance of reverse flexing contributes to a longer belt life.

The drive belts are mounted according to two rules:

1. The belt must be on the inside of a curve so that the small ends of the tapered rollers will be at the same surface speed as the straight rollers in the end sections and in the adjoining equipment.
2. The belt must be positioned on the long side of a junction so it will extend to the short rollers at the angled end.

Only a small amount of belt take-up is needed if the correct belt is installed and given proper care. On each VBLR conveyor, approximately 1-1/2" to 2-1/2" of take-up is provided at the discharge end of the unit, which means the take-up can compensate for about 3" to 5" of overall belt stretch. On units equipped with dually take-up, additional belt take-up is provided.

Drives

The VBLR drive is available in two mounting types - flange-mounted and under hung. The drive consists of a C-face motor coupled to a reducer fastened to a drive plate. For a flange-mounted drive, the extended output shaft of the reducer projects through the drive plate where the drive sheave is mounted (see Figure B - 5). This type of arrangement is normally mounted at the infeed end of the conveyor. The reducer is mounted similarly for the under hung drive, but transfers power to the drive sheave through sprockets and a flat belt (see Figure B - 6).

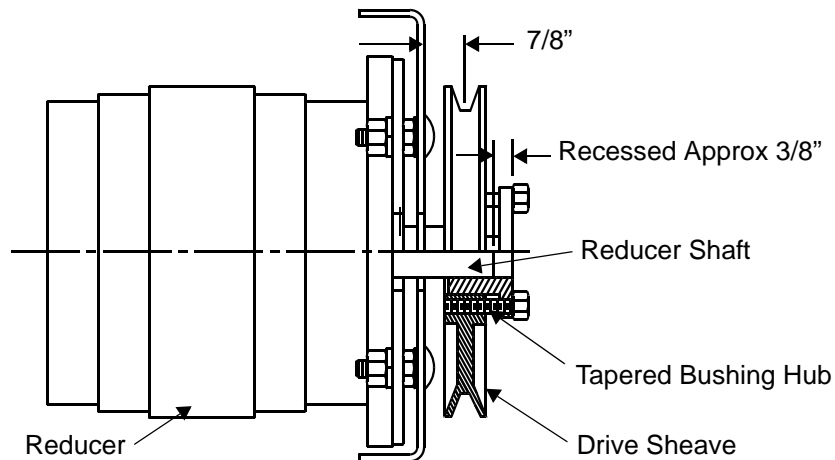


Figure B - 5 Flange-Mounted Drive Sheave Assembly

Soft Start Requirements

Soft starts are required on speeds greater than 350 feet per minute. For push style drives (when the drive is located at the discharge end of the conveyor), soft starts are required for speeds over 250 feet per minute.

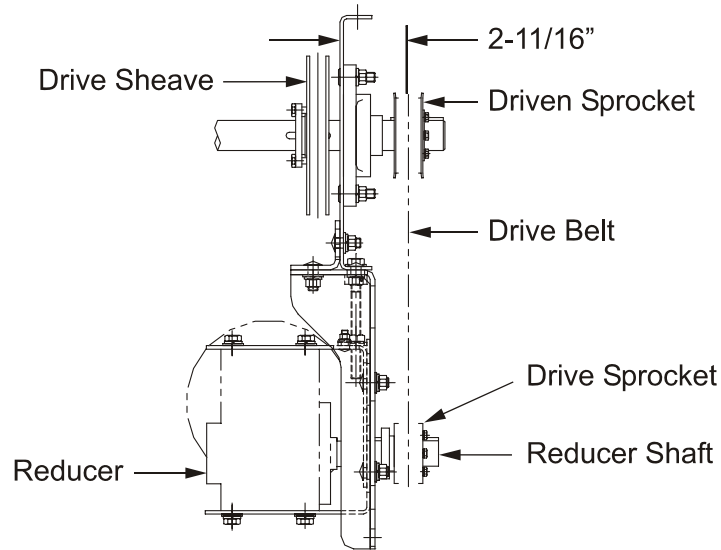


Figure B - 6 Under hung-Mounted Drive Sheave Assembly

Premium Efficient Motors

Most premium efficient motors have cooling fins to dissipate heat produced by the motor. These fins can cause interference when mounting the motor. When ordering a V-Belt conveyor curve with a direct, side-mounted reducer and premium motor, you must order a 10" conveyor extension so the motor will clear the conveyor frame.

Power Take-Off (PTO) Drive

The PTO drive is used at the end of a VBLR unit which connects to an adjacent live roller or belt conveyor. Power is transferred via chain and sprockets. Two different types of drives are available. The unit used with an adjoining live roller, or another VBLR which drives the end sheave of the driven VBLR in the same rotational direction as the end pulley of the driving unit. The transfer drive unit used with a driving belt unit reverses the rotation of the VBLR sheave relative to that of its own end pulley.

Note: The PTO shaft extension is always on the same side as the driving V-belt. The final connection of the chain and guard must be made in the field.

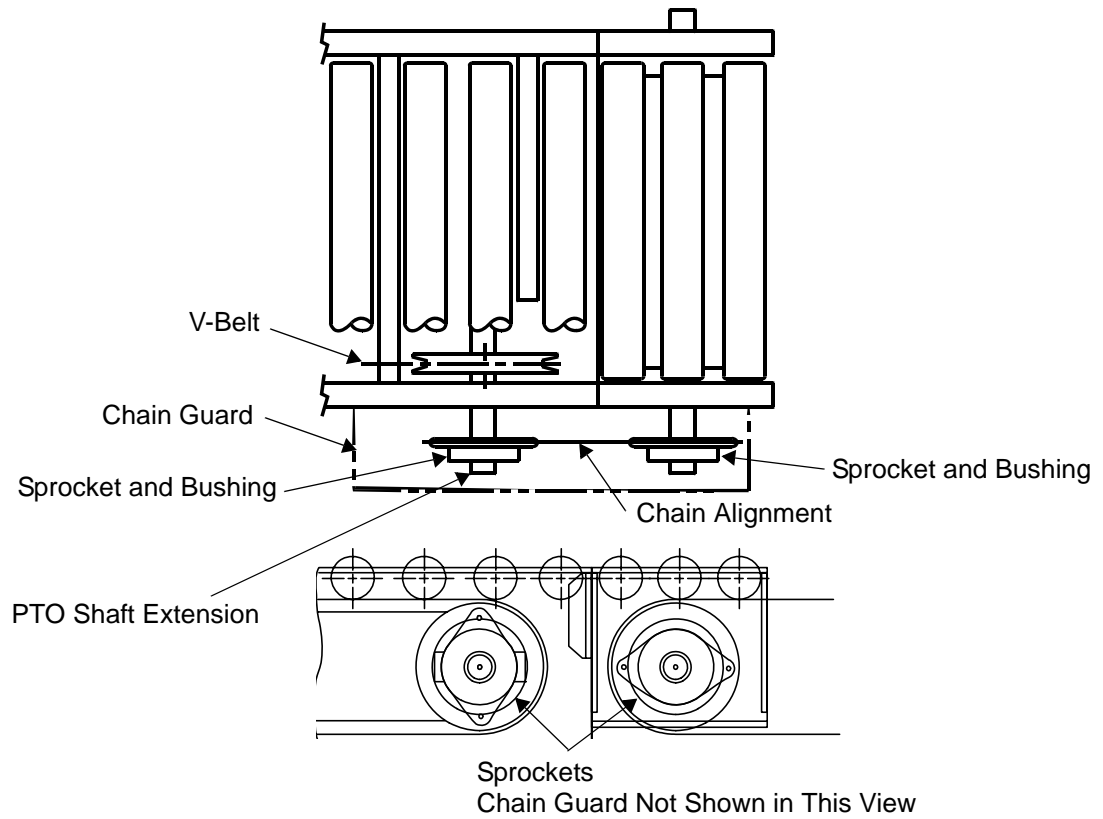
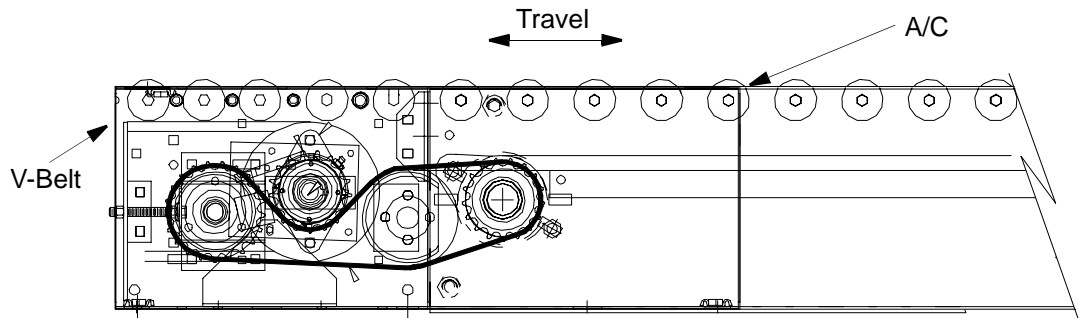


Figure B - 7 PTO Drive

PTOs Available for V-Belt

A/C250 Drive w/LHDIS PTO (Shown)



Note: Clutch can stop the curve when the A/C has accumulated.

Figure B - 8 V-Belt with Spring Wrap Clutch Driven by A/CQ250

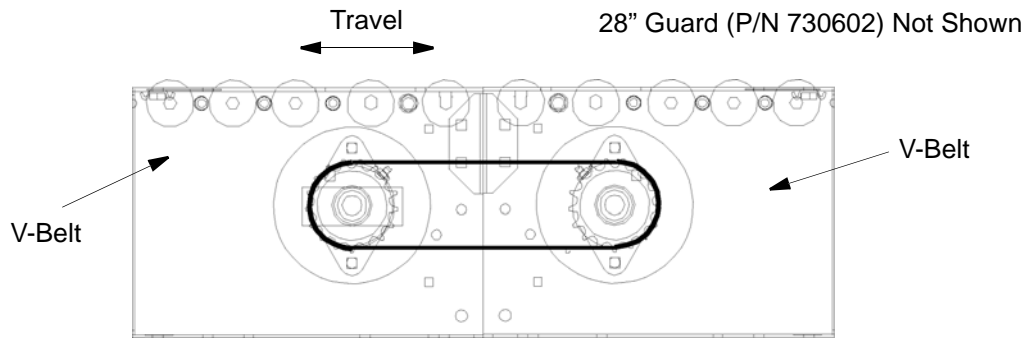


Figure B - 9 V-Belt Drive, by V-Belt with 28" T/C Guard

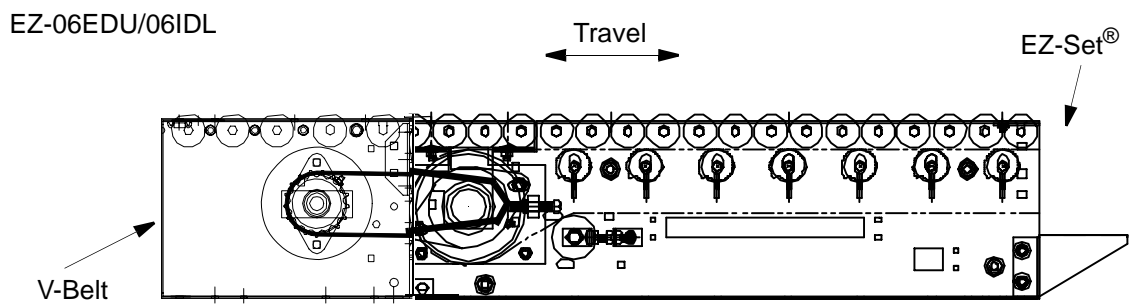


Figure B - 10 V-Belt Drive, by EZ-Set®

A/CQ Drive LHDIS RHINF PTO (Shown)

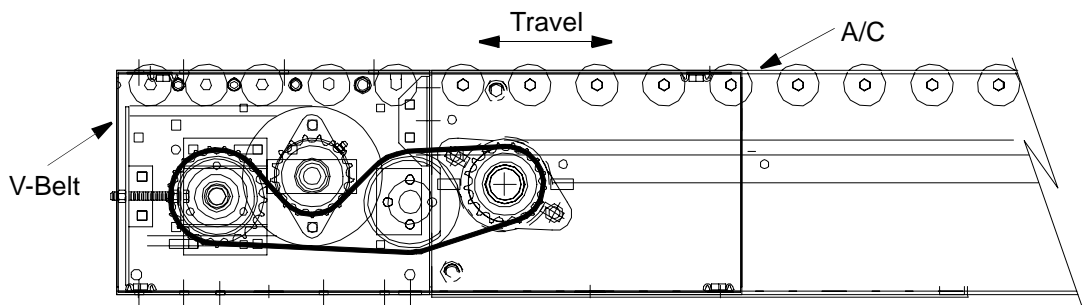


Figure B - 11 V-Belt Drive, by A/CQ

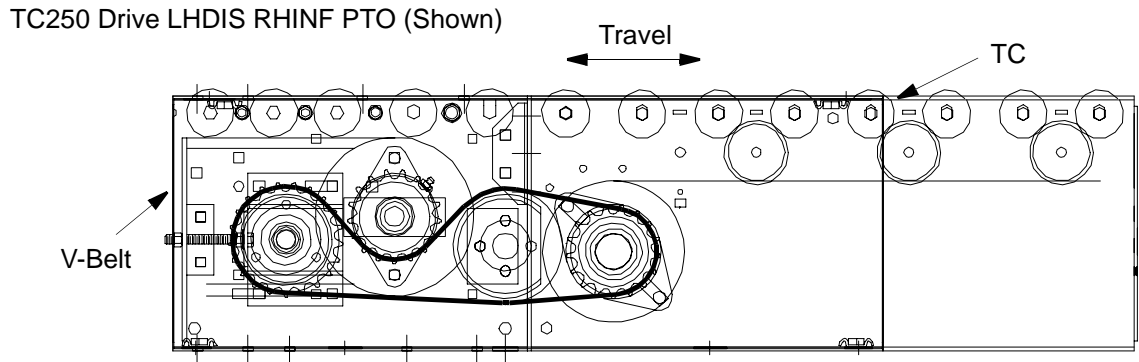


Figure B - 12 V-Belt Drive by TC250

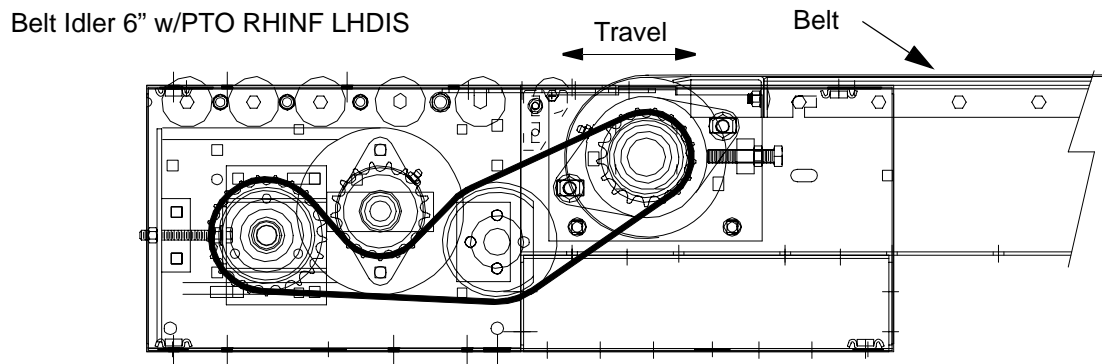


Figure B - 13 V-Belt Drive by Belt 6" Idler

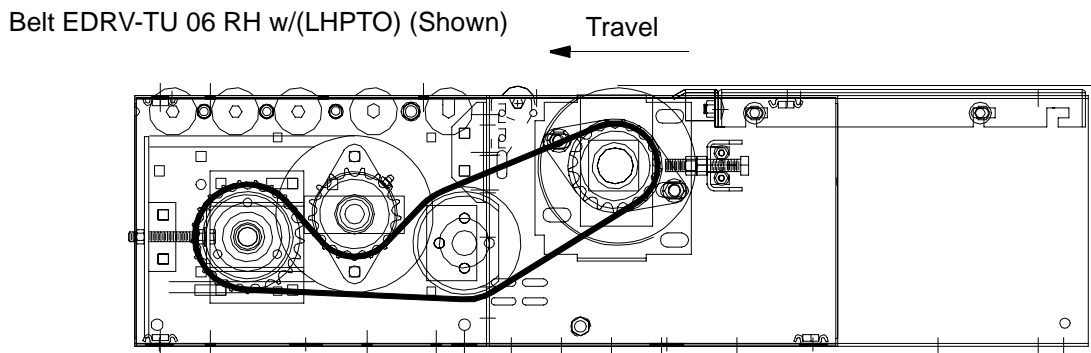


Figure B - 14 V-Belt Driven by Belt EDU Series 600

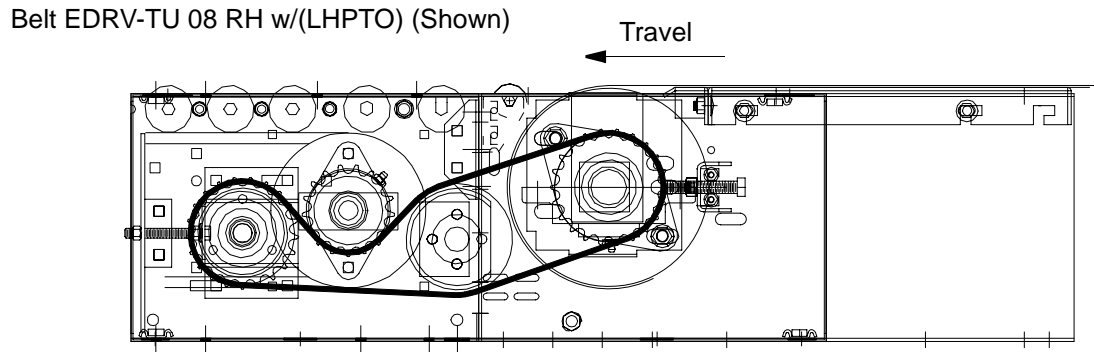


Figure B - 15 V-Belt Driven by Belt EDU Series 800

Extensions

The extensions are straight sections of various lengths which are added between the curve and the idler/drive section, or to the square ends of junctions. The extensions are used:

- to provide a straight portion of conveyor for mounting a mechanical assembly.
- to lengthen a particular conveyor section.
- to meet the planned dimensional layout of a particular system.
- to improve the system flow characteristics.
- to provide a customer-required operational configuration.

See Section J for available extension lengths per style.

Dually Take-Up (Patented)

The dually take-up (see Figure B - 16) is used for curves/spurs where the belt length required is a dimension that falls between standard V-belt lengths and is outside the normal travel of the standard take-up on the curve/spur.

The dually take-up consists of a set of three sheaves (each end) which allows the V-belt to travel in a normal manner (does not back bend the V-belt), allows use of a standard longer V-belt, gives more take-up travel and is screw adjustable.

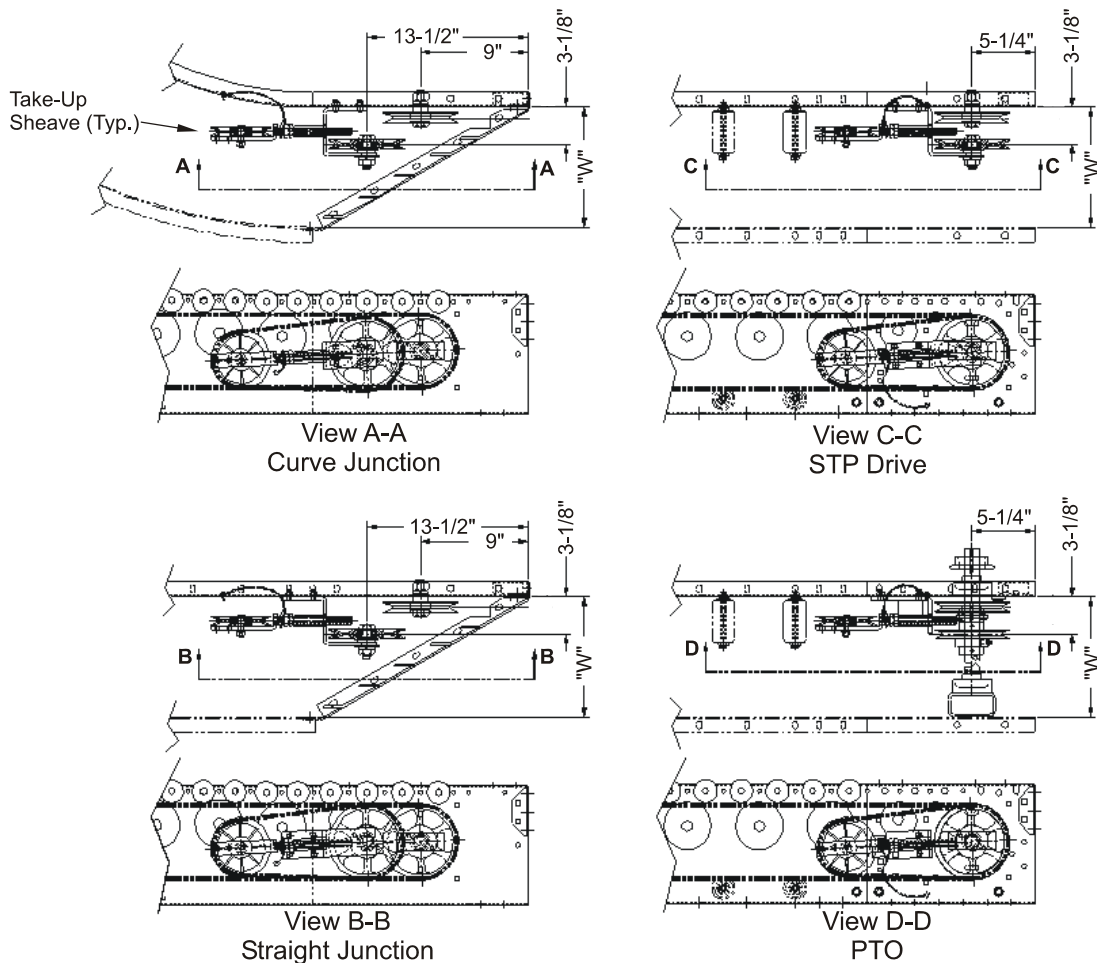


Fig B-16

Figure B - 16 Dually Take-Up (Single Unit Shown)

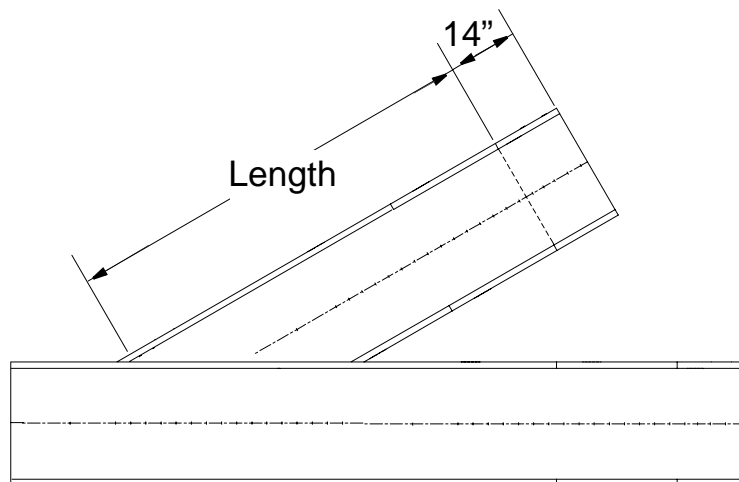
Assemblies

Curves

The curves are 30°, 45°, 60°, 90°, and 180° of arc with 14" straight sections on each end. They can be operated in either direction, but are not reversible. Standing at the infeed end and facing the direction of product travel, right-hand curves will have the short radius on the right side, and left-hand curves will have the short radius rail on the left side. The drive will always be positioned on the inside of the curve at the charge end. Curves may be PTO driven from either end.

Junctions

The junctions are straight sections which have one end cut on an angle. They are available with either a 30° or 45° cut end. The V-belt is always on the long side. They can be operated in either direction, but they are not reversible. Junctions of 16", 22", and 28" widths are 60" long with a 14" long end section added at the square end. Junctions of 34" and 40" width are 90" long plus a 14" straight section. A junction is usually attached to the side of a live roller trunk line.



Width = 16", 22", 28"

Length = 60" (Nominal)

Width = 34" and 40"

Length = 90" (Nominal)

Figure B - 17 Straight Junction

Curve Junctions

The curve junctions are similar to the full curves except they have one end cut off on an angle. See Section E for layout details. Like full curves, spur curves can be driven from either end, but always from the inside of the curve; they can also be PTO-driven.

Combining Junctions with Curves

Junctions are frequently combined with curves to provide special functions. Many different arrangements can be built out of the basic standard components.

SECTION C: STANDARD SPECIFICATIONS**Specifications****Frame**

10 ga. formed steel frames with 1-1/4" flanges x 10" deep; 2'-6" IR and true taper radius to inside rail with 14" drive and idler bolt on ends; extensions also use 10" frame.

Rollers

Curve 2-1/2" large end dia. tapered to 1-5/8" dia. 7/16" hex shaft, spring loaded with (greased-packed) bearings straight in arc; 1.9" dia. x 16 ga. tube, 7/16" hex shaft, spring loaded, with (greased-packed) bearings.

Drive Package

See Table A.5.

Drive Sheave

6.1" pitch dia. sheave.

Snubs

2" flat, 3", and 4" dia. single and double flange sheaves.

Tail Sheave

6.1" pitch dia. idler sheave, 3/4" dia. bore.

Belting

"B" section V-belt, refer to the subsection Curve/Spur Extensions in Section J for lengths.

Dually Takeup

Incorporates additional idler sheaves to allow for extended take up. Section J explains Dually Take up usage.

Supports

Floor Supports for heights up to 9'-10" top of roller; ceiling hangers.

Widths

"W" = 16", 22", 28", 34", and 40".

Speeds

See Tables A.5.

Maximum Load

400 pounds total or 70 lbs./foot (50 lbs. on skews and merge/diverge/crossover).

Voltage

230/460/3PH 60 Hz.

Paint

Satin gray.

SECTION D:ENGINEERING DATA**Power Requirements**

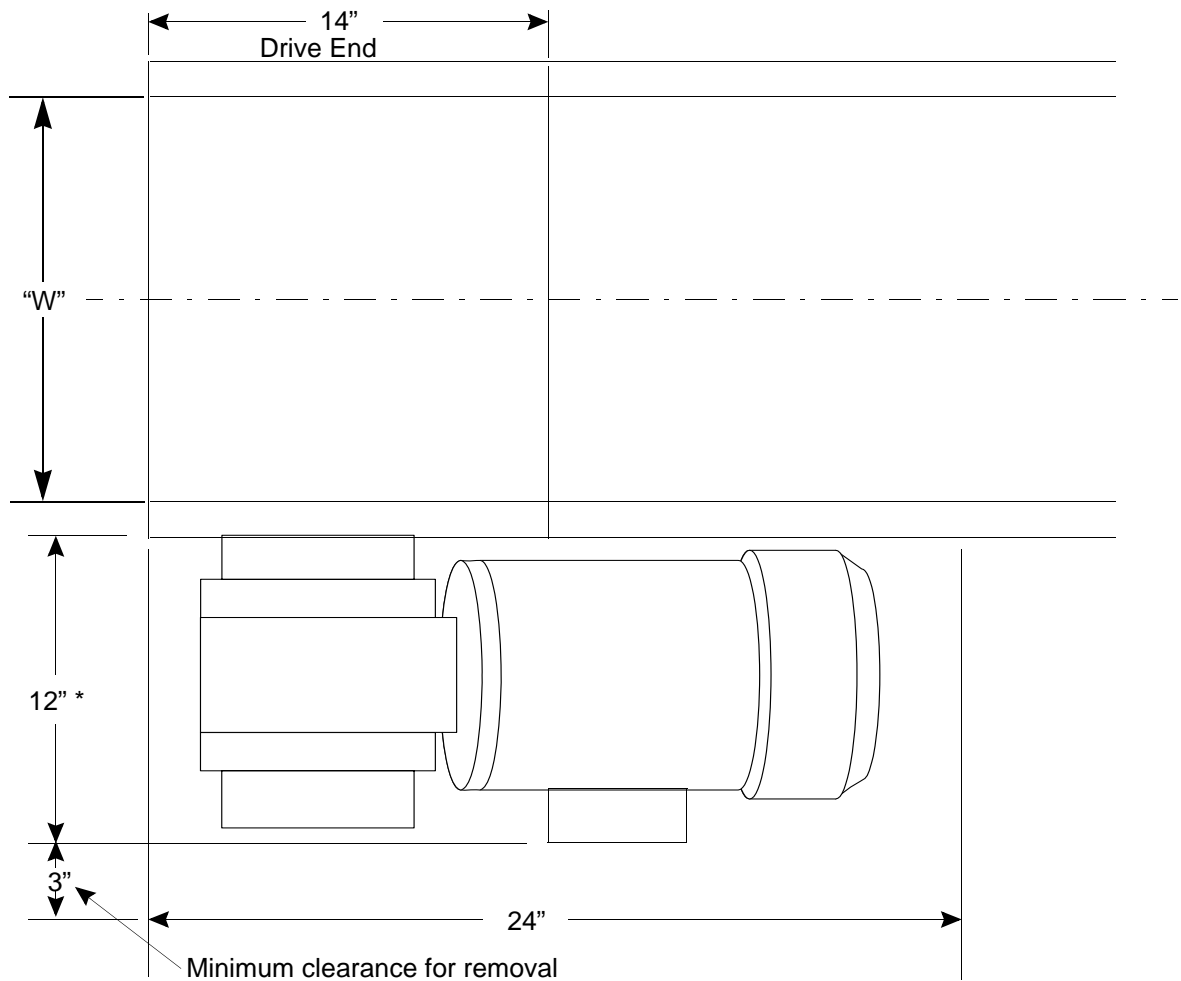
Clean, electric power of 230 or 460 volts, 3PH, 60 Hz controlled to within 10% of nominal will be required by the motors. Supply power must be delivered through a lockable, fusible disconnect switch rated in horsepower. Also, if the disconnect is not within sight and not within 25 feet of the motor, a separate disconnect switch, not fusible, must be located at the motor.

Unless otherwise stated, there are no air operated devices supplied as standard equipment with the VBLR units. Select horsepower according to speed (see Table C.1).

SECTION E: LAYOUT DIMENSIONS

Use the following information for designing a layout for the V-Belt Live Roller Conveyor. All dimensions are in inches.

Motor Clearance



*Clearance for junction box.

Figure E - 1 Motor Clearance for Side-Mounted Models

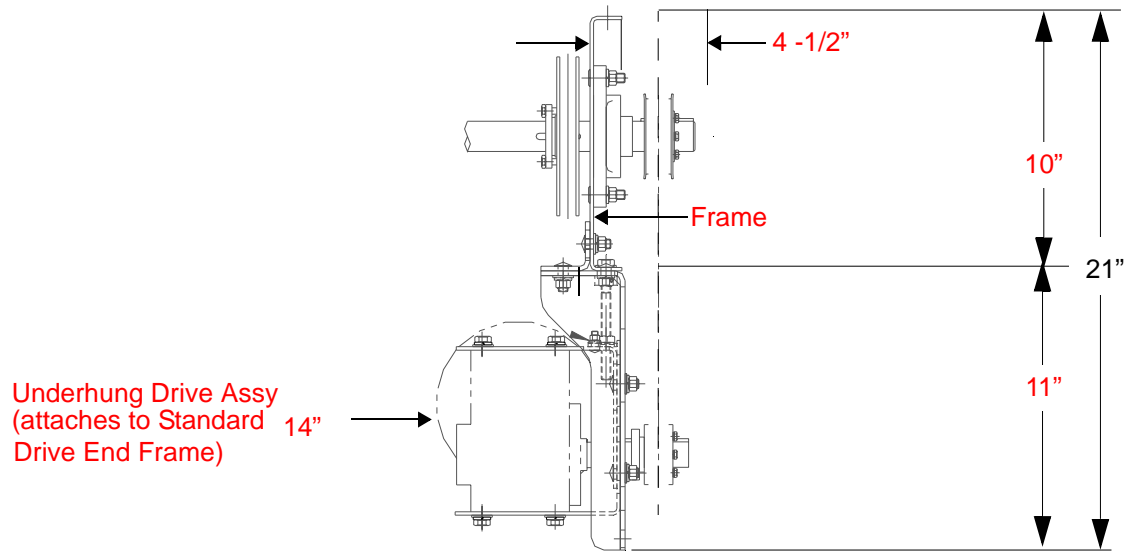


Figure E - 2 Motor Clearance for Underhung Model

Premium Efficient Motors

Most premium efficient motors have cooling fins to dissipate heat produced by the motor. These fins can cause interference when mounting the motor. When ordering a V-Belt conveyor curve with a direct, side-mounted reducer and premium motor, you must order a 10" conveyor extension so the motor will clear the conveyor frame.

Style 5 or 5P - 90° Curve (14" and 24")

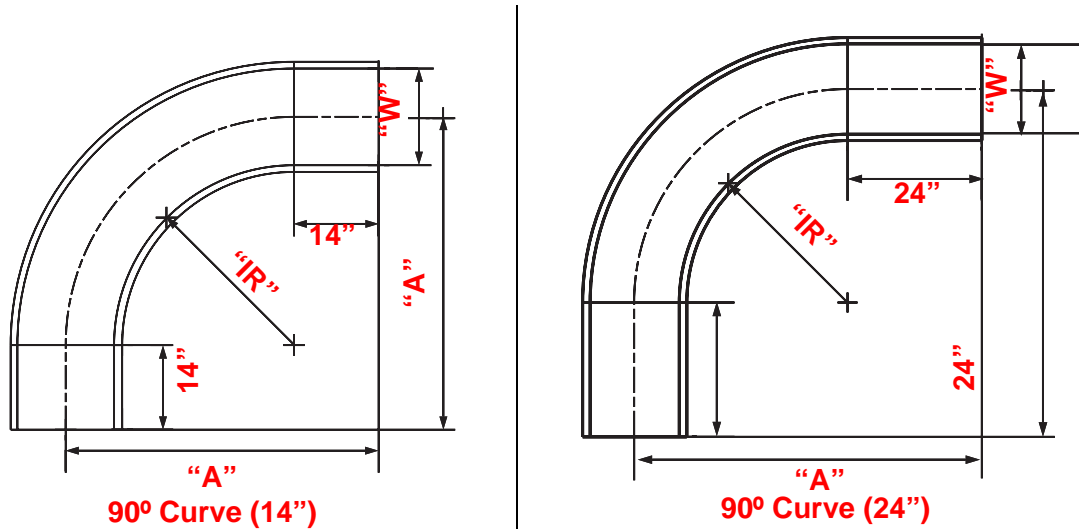


Figure E - 3 Style 5 or 5P - 90° Curves (14" and 24")

Table E 1: Frame Dimensions for Style 5 or 5P - 90° Curves (14" and 24")

Frame Type 2'-6" IR (3" Centers)			
"W"	IR	A (14")	A (24")
16"	30	52	62
22"	30	55	65
28"	30	58	68
34"	30	61	71
40"	30	64	74
Frame Type TTF (2" and 3" Centers)			
16"	30	52	62
22"	40	65	75
28"	48	76	86
34"	60	91	101
40"	60	94	104

Style 6 or 6P - 60° Curve (14" and 24")

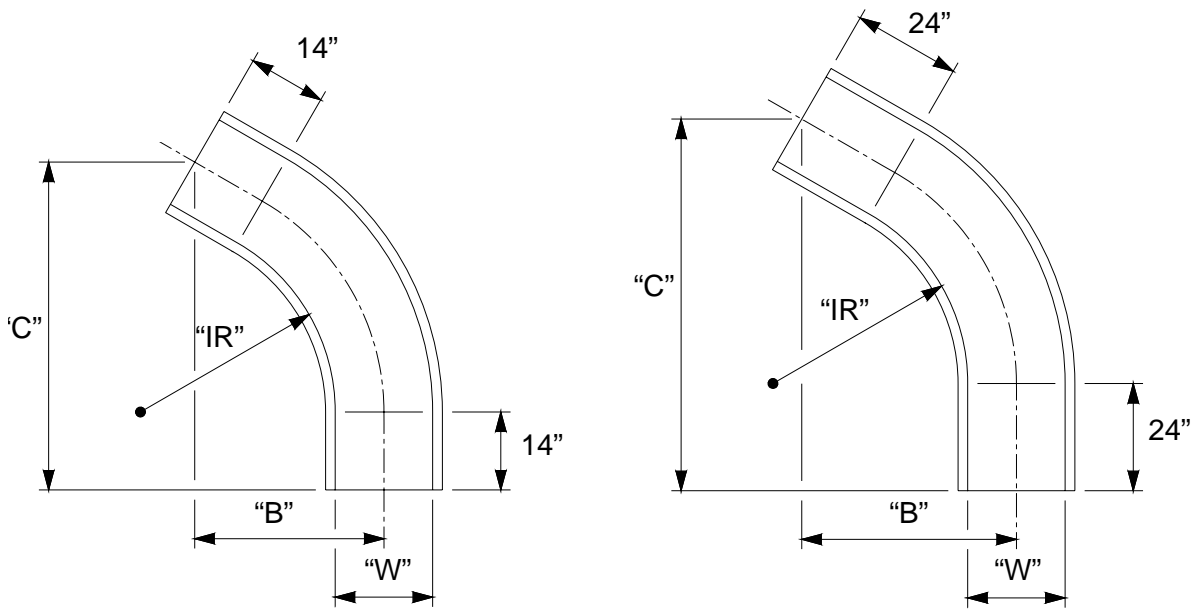


Figure E - 4 Style 6 or 6P - 60° Curves (14" and 24")

Table E 2: Frame Dimensions for Style 6 or 6P - 60° Curves (14" and 24")

Frame Type 2'-6" IR (3" Centers)					
"W"	IR	B (14")	C (14")	B (24")	C (24")
16"	30	31-1/8	53-15/16	39-13/16	68-15/16
22"	30	32-5/8	56-1/2	41-5/16	71-1/2
28"	30	34-1/8	59-1/8	42-13/16	74-1/8
34"	30	35-5/8	61-11/16	44-5/16	76-11/16
40"	30	37-1/8	64-5/16	45-13/16	79-5/16
Frame Type TTF (2" and 3" Centers)					
16"	30	31-1/8	53-15/16	39-13/16	68-15/16
22"	40	37-5/8	65-3/16	46-5/16	80-3/16
28"	48	43-1/8	74-11/16	51-13/16	89-11/16
34"	60	50-5/8	87-11/16	59-5/16	102-11/16
40"	60	52-1/8	90-5/16	60-13/16	105-5/16

Style 7 or 7P - 45° Curve (14" and 24")

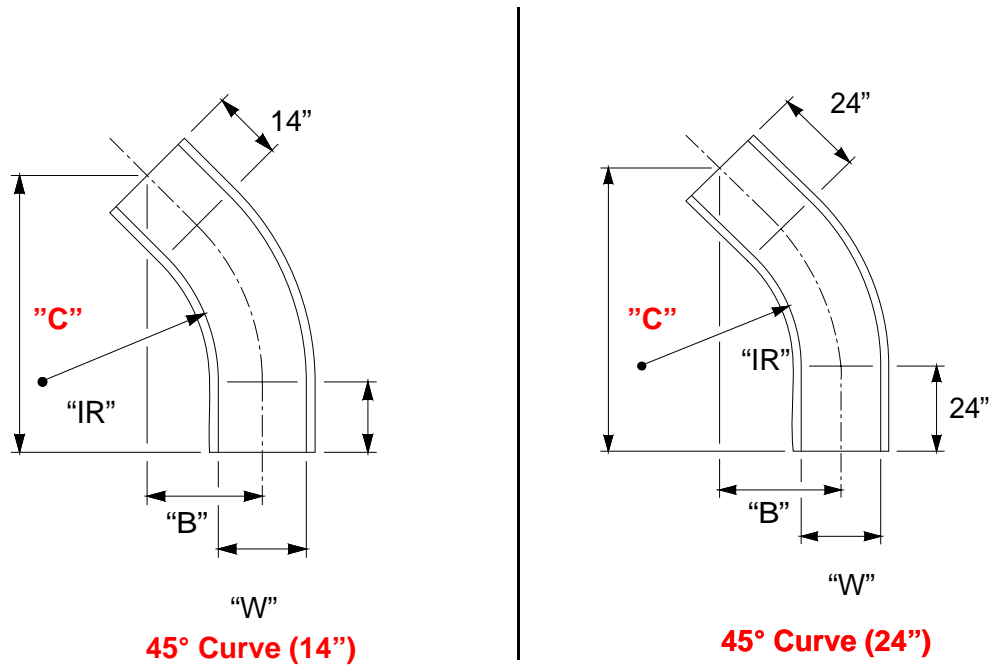


Figure E - 5 Style 7or 7P - 45° Curves (14" and 24")

Table E 3: Frame Dimensions for Style 7or 7P - 45° Curves (14" and 24")

Frame Type 2'-6" IR (3" Centers)					
"W"	IR	B (14")	C (14")	B (24")	C (24")
16"	30	21	50-3/4	28-1/8	67-13/16
22"	30	21-15/16	52-7/8	29	69-15/16
28"	30	22-13/16	55	29-7/8	72-1/16
34"	30	23-11/16	57-1/8	30-3/4	74-3/16
40"	30	24-9/16	59-1/4	31-5/8	76-5/16
Frame Type TTF (2" and 3" Centers)					
16"	30	21	50-3/4	28-1/8	67-13/16
22"	40	24-13/16	59-15/16	31-15/16	77-1/16
28"	48	28-1/16	67-3/4	35-1/8	84-13/16
34"	60	32-7/16	78-3/8	39-1/2	95-7/16
40"	60	33-5/16	80-7/16	40-3/8	97-9/16

Style 8 or 8P - 30° Curve (14" and 24")

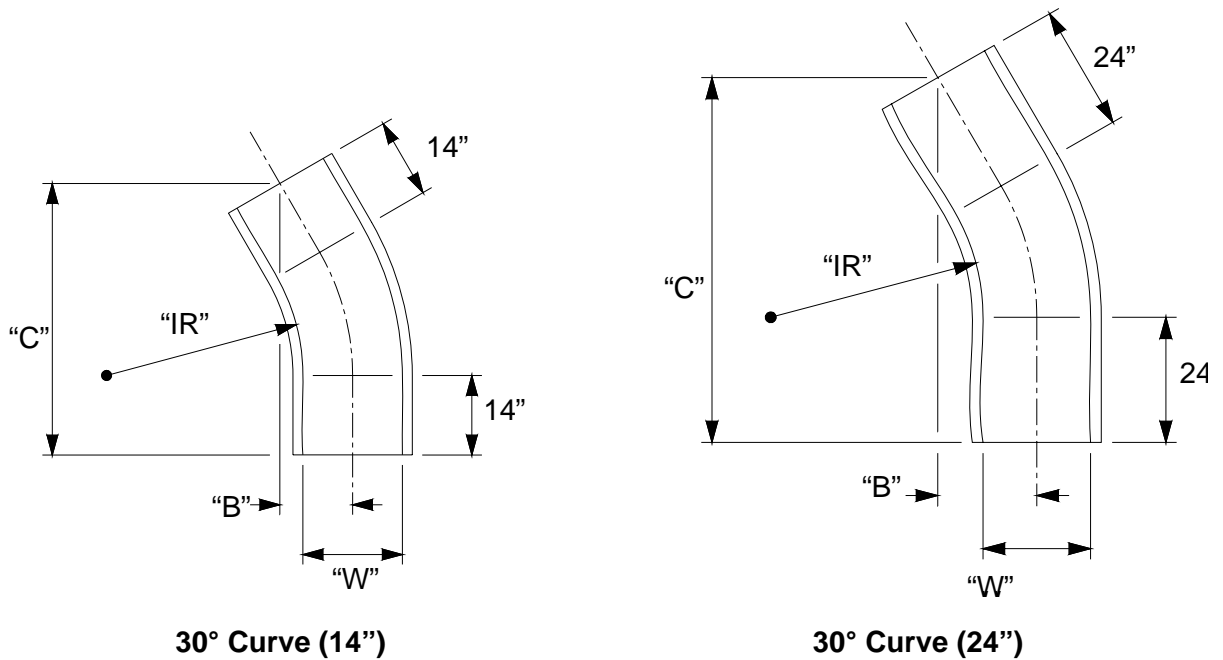


Figure E - 6 Style 8 or 8P - 30° Curves (14" and 24")

Table E 4: Frame Dimensions for Style 8 or 8P - 30° Curves (14" and 24")

Frame Type 2'-6" IR (3" Centers)					
"W"	IR	B (14")	C (14")	B (24")	C (24")
16"	30	12-1/16	45-1/8	17-1/16	63-13/16
22"	30	12-1/2	46-5/8	17-1/2	65-5/16
28"	30	12-7/8	48-1/8	17-7/8	66-13/16
34"	30	13-5/16	49-5/8	18-5/16	68-5/16
40"	30	13-11/16	51-1/8	18-11/16	69-13/16
Frame Type TTF (2" and 3" Centers)					
16"	30	12-1/16	45-1/8	17-1/16	63-13/16
22"	40	13-13/16	51-5/8	18-13/16	70-5/16
28"	48	15-5/16	57-1/8	20-5/16	75-13/16
34"	60	17-5/16	64-5/8	22-5/16	83-5/16
40"	60	17-11/16	66-1/8	22-11/16	84-13/16

Style 9 or 9P - 180° Curve (14" and 24")

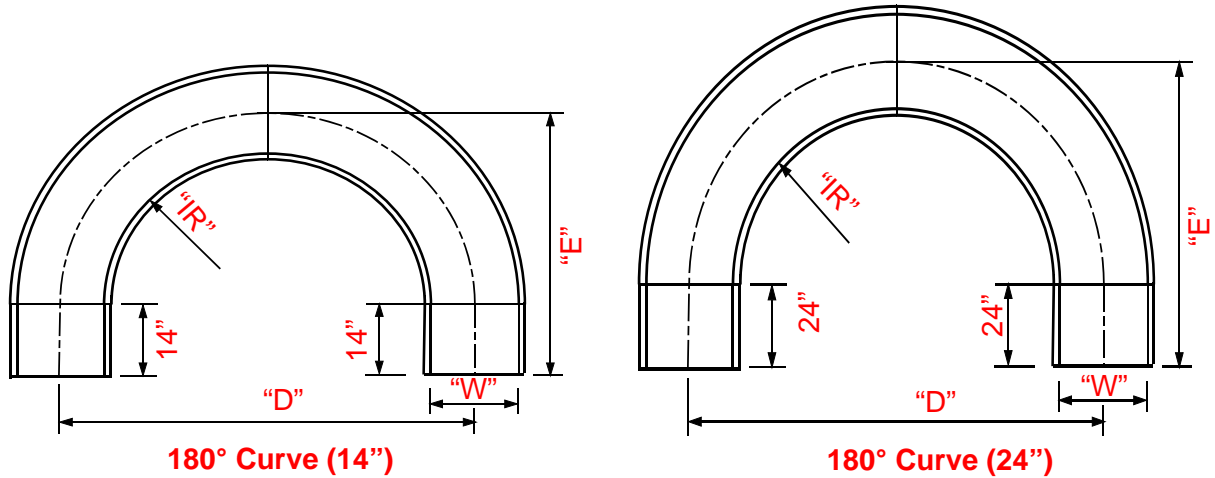


Figure E - 7 Style 9 or 9P - 180° Curves (14" and 24")

Table E 5: Frame Dimensions for Style 9 or 9P - 180° Curves (14" and 24")

Frame Type 2'-6" IR (3" Centers)				
"W"	IR	D	E (14")	E (24")
16"	30	76	52	62
22"	30	82	55	65
28"	30	88	58	68
34"	30	94	61	71
40"	30	100	64	74
Frame Type TTF (2" and 3" Centers)				
16"	30	76	52	62
22"	40	102	65	75
28"	48	124	76	86
34"	60	154	91	101
40"	60	160	94	104

Style 10/11/12/13 - 90°/60°/45°/30° S-Curves

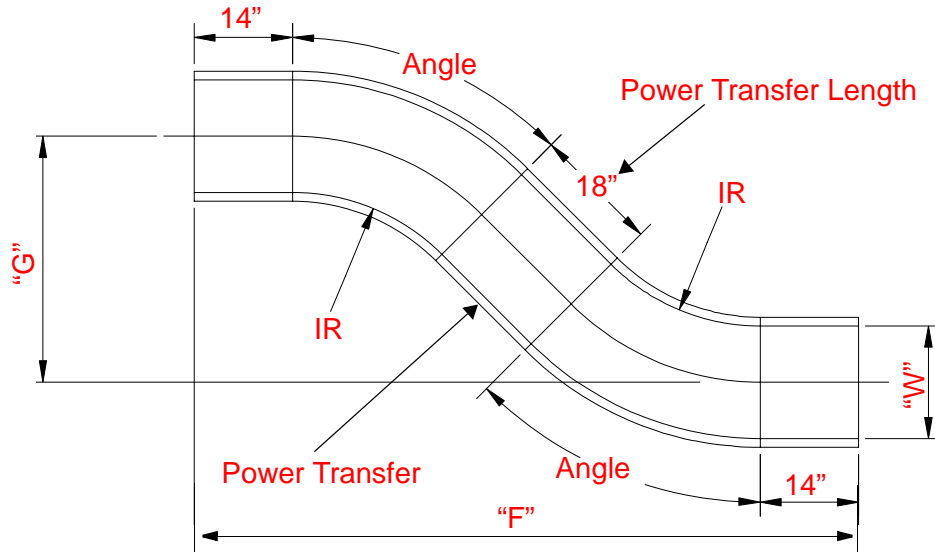


Figure E - 8 Style 10/11/12/13 - 90°/60°/45°/30° S-Curves

Table E 6: Frame Dimensions for Style 10/11/12/13 - 90°/60°/45°/30° S-Curves

Frame Type 2'-6" IR (3" Centers)									
		Style 13 - 30°		Style 12 - 45°		Style 11 - 60°		Style 10 - 90°	
W	IR	F	G	F	G	F	G	F	G
16	30	81-9/16	19-3/16	94-7/16	35	102-13/16	53-9/16	104	94
22	30	84-9/16	20	98-11/16	36-3/4	108	56-9/16	110	100
28	30	87-9/16	20-13/16	102-15/16	38-1/2	113-3/16	59-9/16	116	106
34	30	90-9/16	21-5/8	107-3/16	40-1/4	118-3/8	62-9/16	122	112
40	30	93-9/16	22-3/8	111-7/16	42	123-5/8	65-9/16	128	118
Frame Type TTF (2" and 3" Centers)									
22	40	94-9/16	22-11/16	112-7/8	42-5/8	125-5/16	66-9/16	130	120
28	48	105-9/16	25-5/8	128-7/16	49-1/16	144-3/8	77-9/16	152	142
34	60	120-9/16	29-5/8	149-5/8	57-13/16	170-3/8	92-9/16	182	172
40	60	123-9/16	30-7/16	153-7/8	59-9/16	175-9/16	95-9/16	188	178

Style 14/18 - 30° Straight Junction (14" and 24")

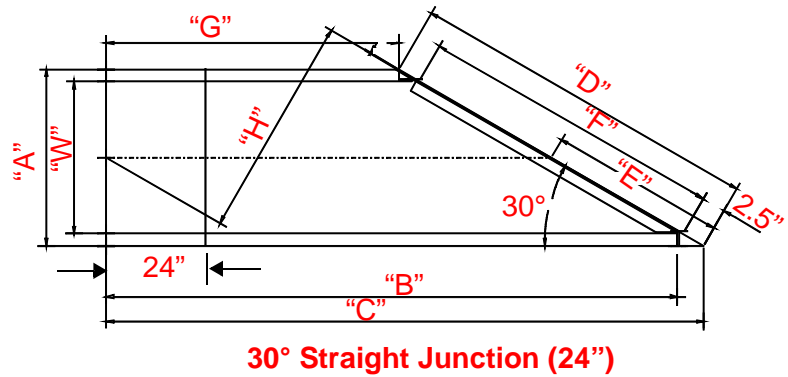
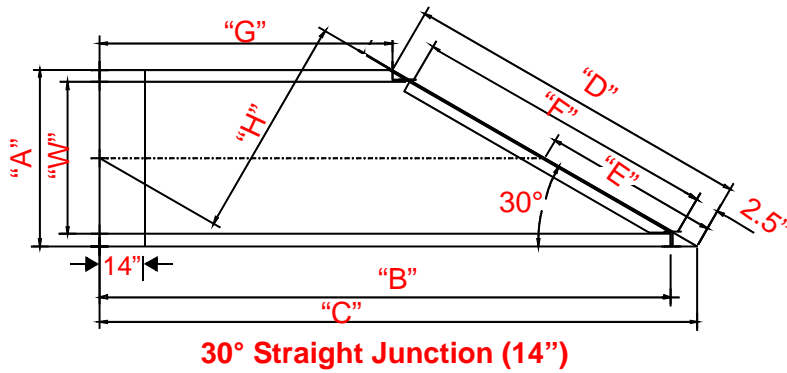
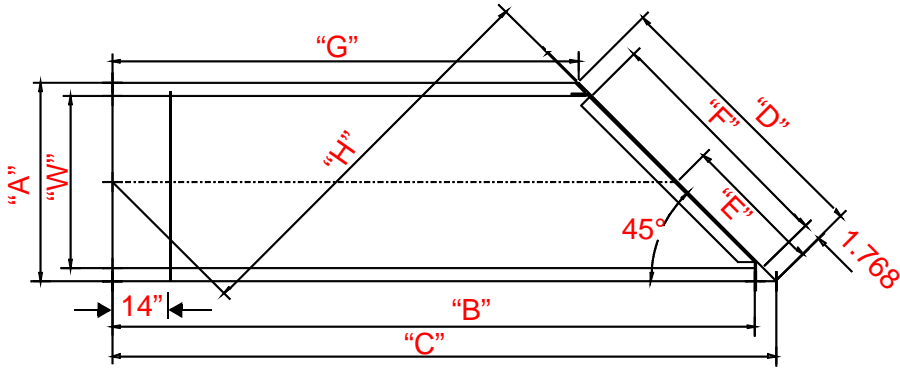


Figure E - 9 Style 14/18 - 30° Straight Junctions (14" and 24")

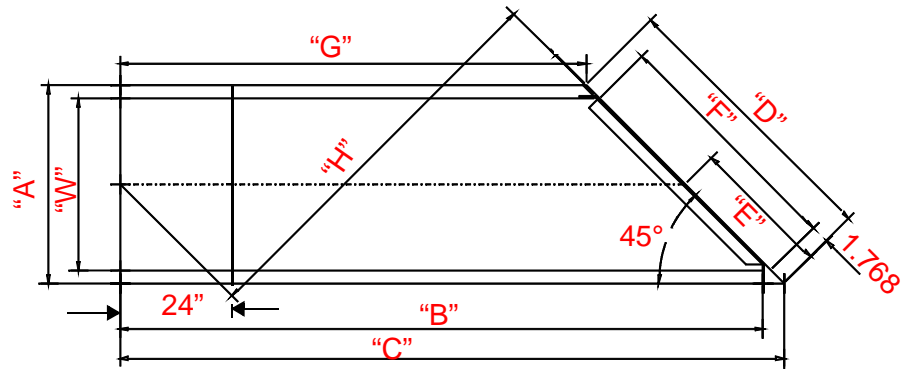
Table E 7: Dimensions for Style 14/18 - 30° Straight Junctions (14" and 24")

Style 14/18 - 30° Straight Junction (2" and 3" Centers)												
"W"	A	B (14")	C (14")	B (24")	C (24")	D	E	F	G (14")	H (14")	G (24")	H (24")
16"	18-1/2	74	76-3/4	84	86-3/4	37	18-1/2	32	44-11/16	30-3/8	54-11/16	35-3/8
22"	24-1/2	74	76-3/4	84	86-3/4	49	24-1/2	44	34-5/16	27-3/4	44-5/16	32-3/4
28"	30-1/2	74	76-3/4	84	86-3/4	61	30-1/2	56	23-15/16	25-3/16	33-15/16	30-3/16
34"	36-1/2	104	106-3/4	114	116-3/4	73	36-1/2	68	43-9/16	37-9/16	53-9/16	42-9/16
40"	42-1/2	104	106-3/4	114	116-3/4	85	42-1/2	80	33-1/8	35	43-1/8	40

Style 14/18 - 45° Straight Junction (14" and 24")



45° Straight Junction (14")



45° Straight Junction (24")

Figure E - 10 Style 14/18 - 45° Straight Junctions (14" and 24")

Table E 8: Dimensions for Style 14/18 - 45° Straight Junctions (14" and 24")

Style 14/18 - 45° Straight Junction (2" and 3" Centers)												
"W"	A	B (14")	C (14")	B (24")	C (24")	D	E	F	G (14")	H (14")	G (24")	H (24")
16"	18-1/2	74	76	84	86	26-3/16	13-1/16	22-5/8	57-1/2	47-3/16	67-1/2	54-1/4
22"	24-1/2	74	76	84	86	34-5/8	17-5/16	31-1/8	51-1/2	45-1/16	61-1/2	52-1/8
28"	30-1/2	74	76	84	86	43-1/8	21-9/16	39-5/8	45-1/2	42-15/16	55-1/2	50
34"	36-1/2	104	106	114	116	51-5/8	25-13/16	48-1/16	69-1/2	62-1/16	79-1/2	69-1/8
40"	42-1/2	104	106	114	116	60-1/8	30-1/16	56-9/16	63-1/2	59-15/16	73-1/2	67

Style 15 - 30° Combination Junction

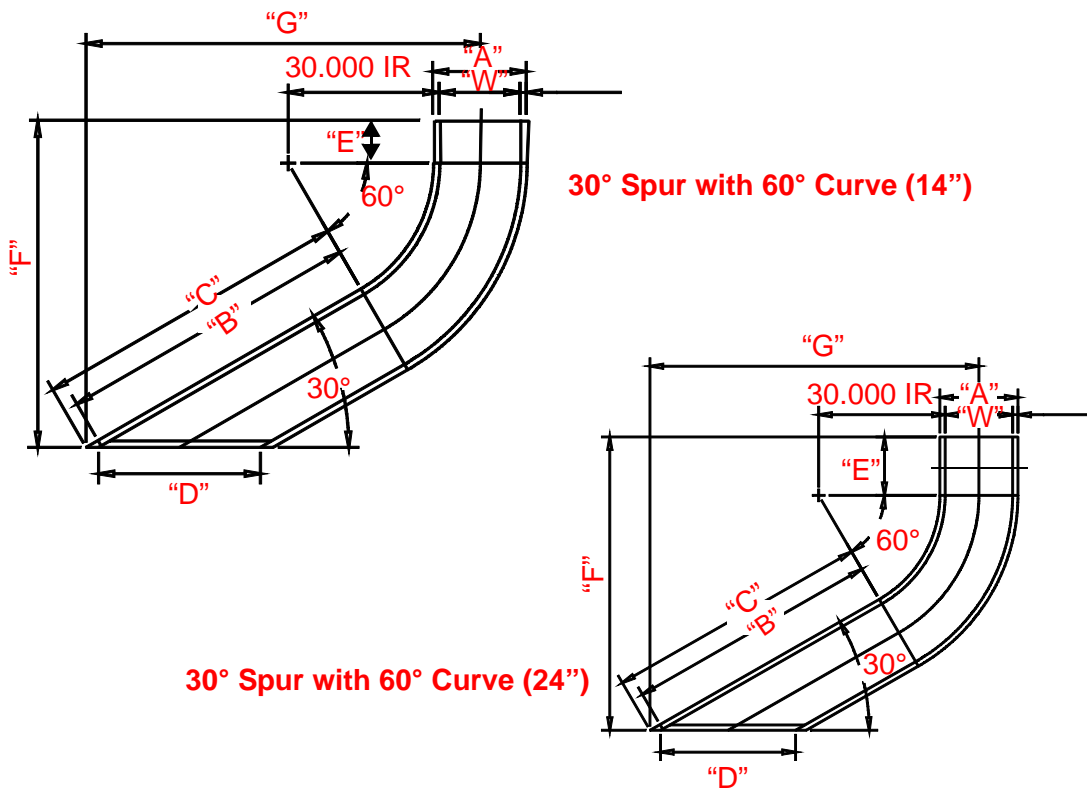


Figure E - 11 Style 15 - 30° Spur with 60° Curve (14" and 24")

Table E 9: Frame Dimensions for Style 15 - 30° Spur with 60° Curve (14" and 24")

Frame Type 2'-6" IR (3" Centers)										
"W"	IR	A	B	C	D	E (14")	E (24")	F (14")	F (24")	G
16"	30	18-1/2	60	62-3/4	32	14	24	70-1/4	80-1/4	78
22"	30	24-1/2	60	62-3/4	44	14	24	70-1/4	80-1/4	81
28"	30	30-1/2	60	62-3/4	56	14	24	70-1/4	80-1/4	84
34"	30	36-1/2	90	92-3/4	68	14	24	85-1/4	95-1/4	113
40"	30	42-1/2	90	92-3/4	80	14	24	85-1/4	95-1/4	116
Frame Type TTF (2" and 3" Centers)										
16"	30	18-1/2	60	62-3/4	32	14	24	70-1/4	80-1/4	78
22"	40	24-1/2	60	62-3/4	44	14	24	78-7/8	88-7/8	86
28"	48	30-1/2	60	62-3/4	56	14	24	85-13/16	95-11/16	93
34"	60	36-1/2	90	92-3/4	68	14	24	111-1/4	121-1/4	128
40"	60	42-1/2	90	902-3/4	80	14	24	111-1/4	121-1/4	131

Style 19 - 45° Combination Junction

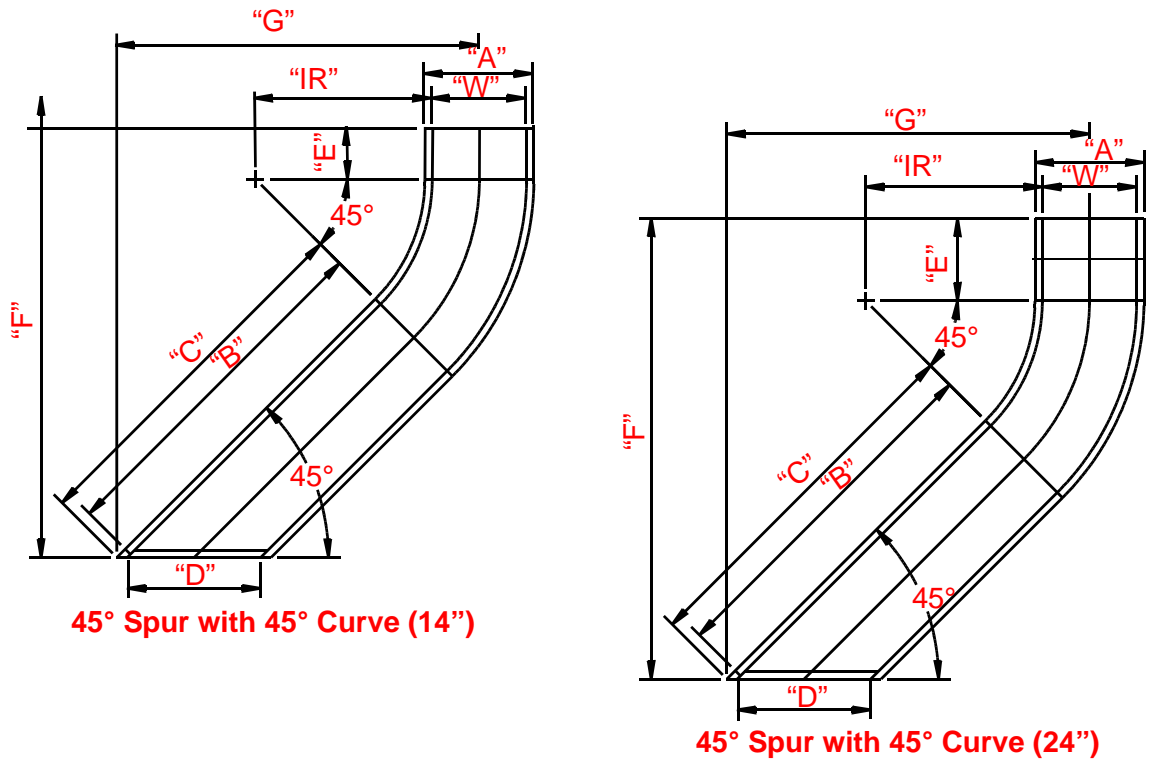


Figure E - 12 Style 19 - 45° Spur with 45° Curve (14" and 24")

Table E 10: Frame Dimensions for Style 19 - 45° Spur with 45° Curve (14" and 24")

Frame Type 2'-6" IR (3" Centers)										
"W"	IR	A	B	C	D	E (14")	F (14")	E (24")	F (24")	G
16"	30	18-1/2	60	62	22-5/8	14	78-3/16	24	88-3/16	61-1/2
22"	30	24-1/2	60	62	31-1/8	14	78-3/16	24	88-3/16	64-1/2
28"	30	30-1/2	60	62	39-5/8	14	78-3/16	24	88-3/16	67-1/2
34"	30	36-1/2	90	92	48-1/16	14	99-3/8	24	109-3/8	91-3/4
40"	30	42-1/2	90	92	56-9/16	14	99-3/8	24	109-3/8	94-3/4
Frame Type TTF (2" and 3" Centers)										
16"	30	18-1/2	60	62	22-5/8	14	78-3/16	24	88-3/16	61-1/2
22"	40	24-1/2	60	62	31	14	85-3/16	24	95-3/16	67-7/16
28"	48	30-1/2	60	62	39-9/16	14	90-7/8	24	100-7/8	72-13/16
34"	60	36-1/2	90	92	48	14	120-9/16	24	130-9/16	100-1/2
40"	60	42-1/2	90	92	56-1/2	14	120-9/16	24	130-9/16	103-1/2

Style 16 - Parallel Junction - 30° Spur with 30° Curve (14" and 24")

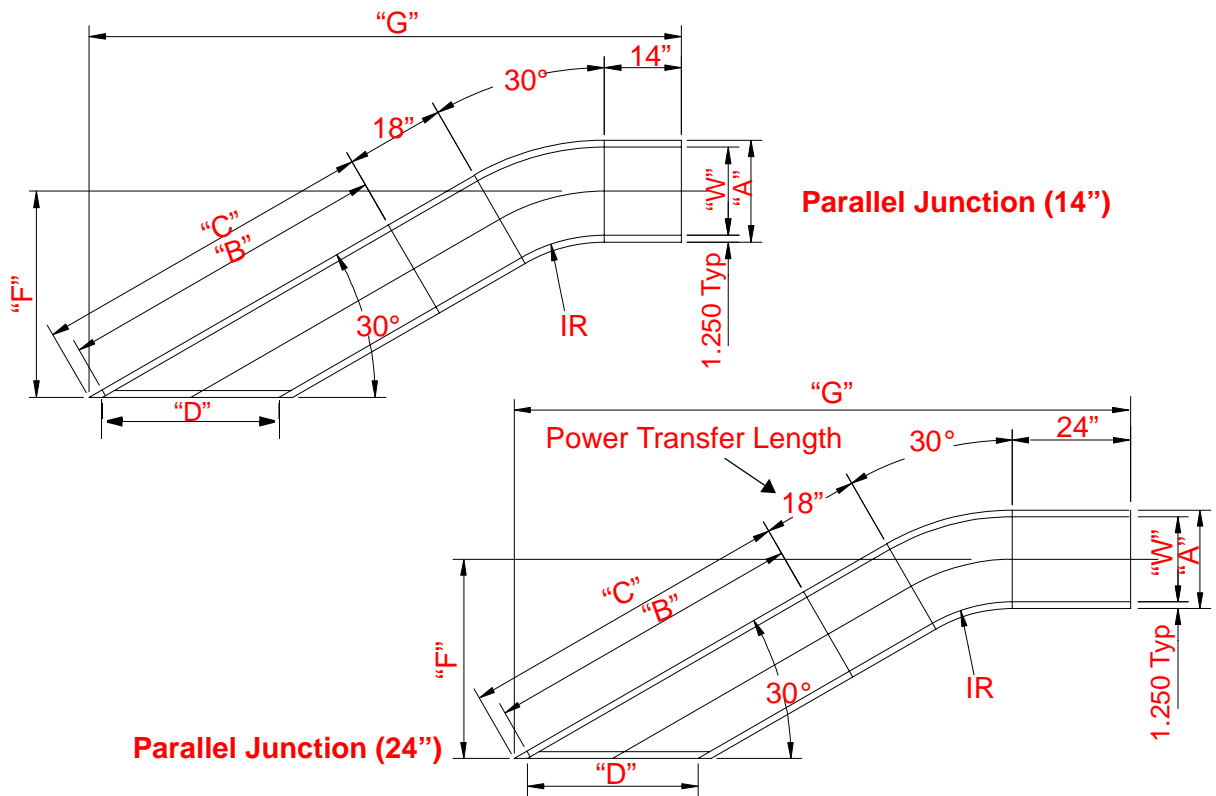


Figure E - 13 Style 16 - Parallel Junction - 30° Spur with 30° Curve (14" and 24")

Table A.1

Table E 11: Frame Dimensions for Style 16 - Parallel Junction - 30° Spur with 30° Curve (14", 24")

Frame Type 2'-6" IR (3" Centers)								
"W"	IR	A	B	C	D	F	G (14")	G (24")
16"	30	18-1/2	60	62-3/4	32	37-7/16	107-9/16	117-9/16
22"	30	24-1/2	60	62-3/4	44	35-1/4	110-9/16	120-9/16
28"	30	30-1/2	60	62-3/4	56	33-1/16	113-9/16	123-9/16
34"	30	36-1/2	90	92-3/4	68	45-7/8	142-9/16	152-9/16
40"	30	42-1/2	90	92-3/4	80	43-11/16	145-9/16	155-9/16
Frame Type TTF (2" and 3" Centers)								
16"	30	18-1/2	60	62-3/4	32	37-7/16	107-9/16	117-9/16
22"	40	24-1/2	60	62-3/4	44	36-9/16	115-9/16	125-9/16
28"	48	30-1/2	60	62-3/4	56	35-7/16	122-9/16	132-9/16
34"	60	36-1/2	90	92-3/4	68	49-7/8	157-9/16	167-9/16
40"	60	42-1/2	90	92-3/4	80	47-11/16	160-9/16	170-9/16

Style 20 - Parallel Junction - 45° Spur with 45° Curve (14" and 24")

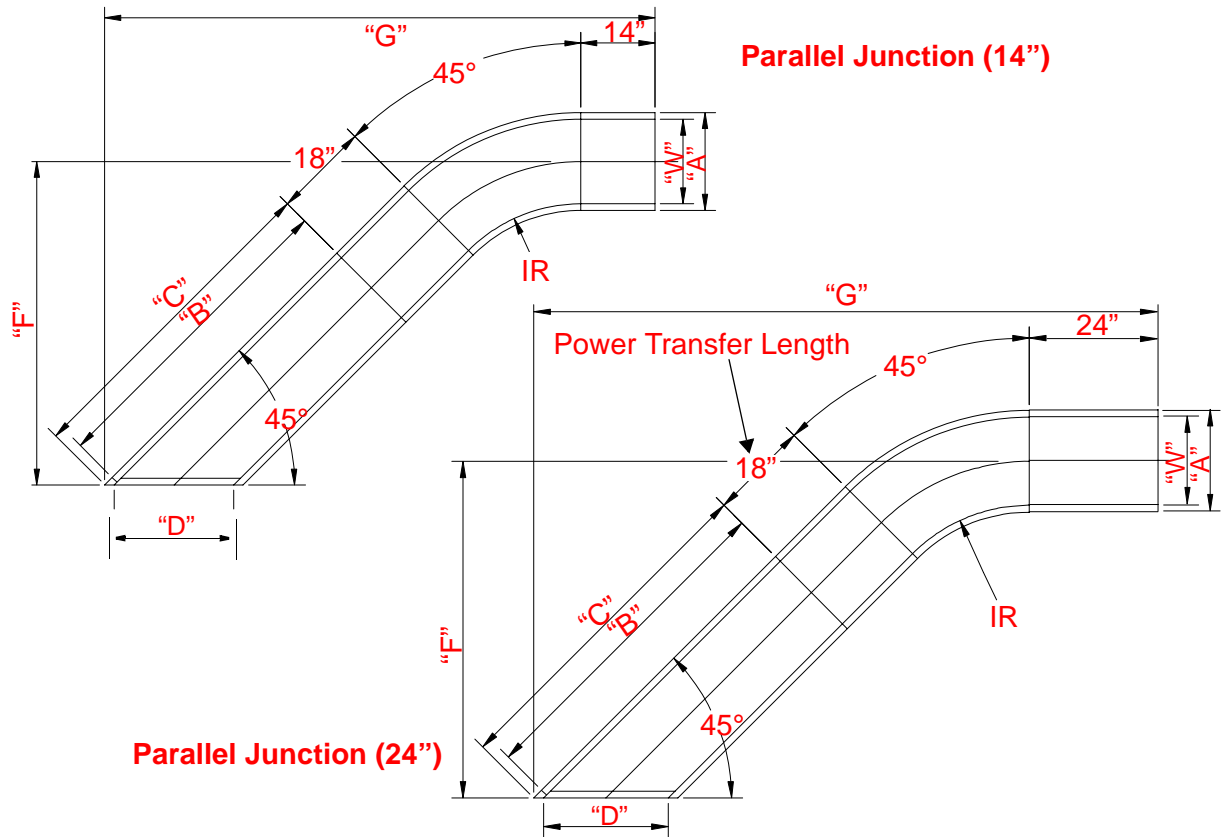


Figure E - 14 Style 20 - Parallel Junction - 45° Spur with 45° Curve (14" and 24")

Table E 12: Frame Dimensions, Style 20 - Parallel Junction - 45° Spur with 45° Curve (14", 24")

Frame Type 2'-6" IR (3" Centers)								
"W"	IR	A	B	C	D	F	G (14")	G (24")
16"	30	18-1/2	60	62	22-5/8	61-3/16	104	114
22"	30	24-1/2	60	62	31-1/8	59-15/16	108-1/4	118-1/4
28"	30	30-1/2	60	62	39-9/16	58-11/16	112-7/16	122-7/16
34"	30	36-1/2	90	92	48-1/16	78-5/8	141-7/8	151-7/8
40"	30	42-1/2	90	92	56-9/16	77-3/8	142-3/16	152-3/16
Frame Type TTF (2" and 3" Centers)								
16"	30	18-1/2	60	62	22-5/8	61-3/16	104	114
22"	40	24-1/2	60	62	31-1/16	63-13/16	115-5/16	125-5/16
28"	48	30-1/2	60	62	39-9/16	63-15/16	125-3/16	135-3/16
34"	60	36-1/2	90	92	48-1/16	87-7/16	159-1/8	169-1/8
40"	60	42-1/2	90	92	56-9/16	86-3/16	163-3/8	173-3/8

Style 17/21 - 90° Curve Junction (14" and 24")

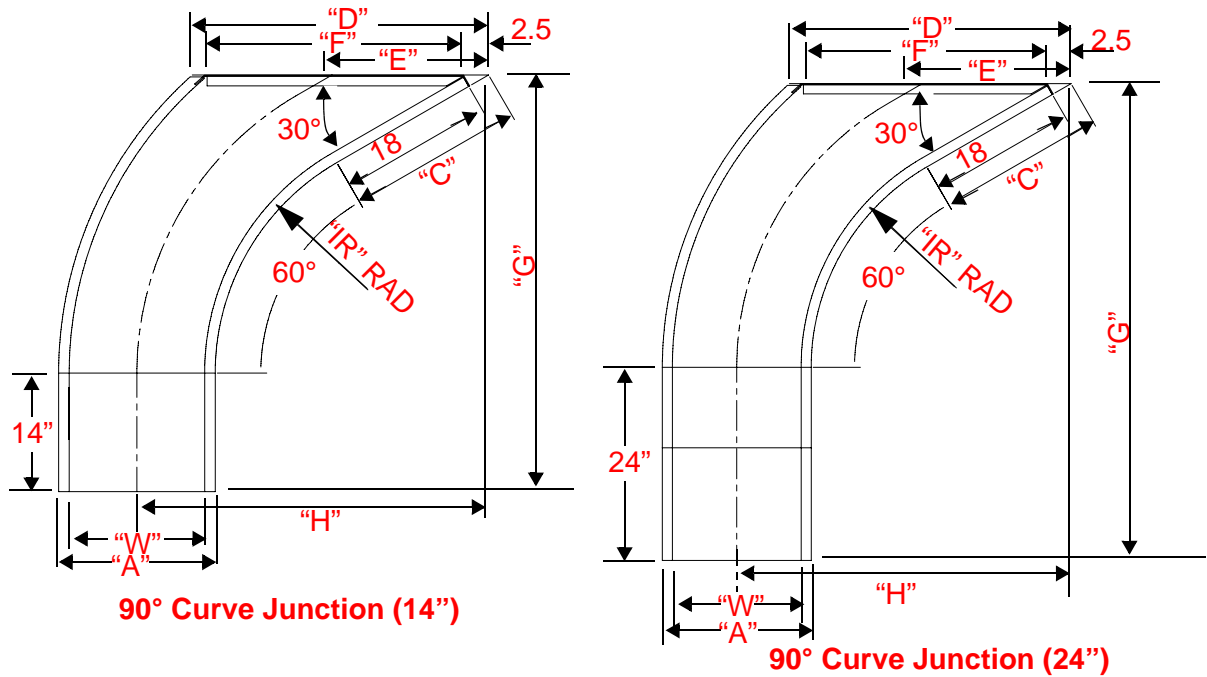


Figure E - 15 Style 17/21 - 90° Curve Junction (14" and 24")

Table E 13: Frame Dimensions for Style 17/21 - 90° Curve Junction (14" and 24")

Frame Type 2'-6" IR (3" Centers)									
"W"	A	IR	C	D	E	F	G (14")	G (24")	H
16"	18-1/2	30	20-11/16	35	18-1/2	30-5/8	49-1/4	59-1/4	41-9/16
22"	24-1/2	30	20-11/16	43-7/16	24-1/2	39-5/16	49-1/4	59-1/4	44-9/16
28"	30-1/2	30	20-11/16	51-3/16	29-7/8	47-1/8	49-1/4	59-1/4	47-9/16
34"	36-1/2	30	20-11/16	58-7/16	34-5/8	54-1/2	49-1/4	59-1/4	50-9/16
40"	42-1/2	30	20-11/16	65-1/2	39	61-9/16	49-1/4	59-1/4	53-9/16
Frame Type TTF (2" and 3" Centers)									
16"	18-1/2	30	20-11/16	35	18-1/2	30-5/8	49-1/4	59-1/4	41-9/16
22"	24-1/2	40	20-11/16	44-1/8	24-1/2	39-7/8	57-15/16	67-15/16	49-5/8
28"	30-1/2	48	20-11/16	52-11/16	30-1/16	48-1/2	64-7/8	74-7/8	56-1/2
34"	36-1/2	60	20-11/16	61-9/16	35-1/4	57-3/8	75-1/4	85-1/4	65-9/16
40"	42-1/2	60	20-11/16	69-3/16	40-1/16	65-1/8	75-1/4	85-1/4	68-9/16

Skew

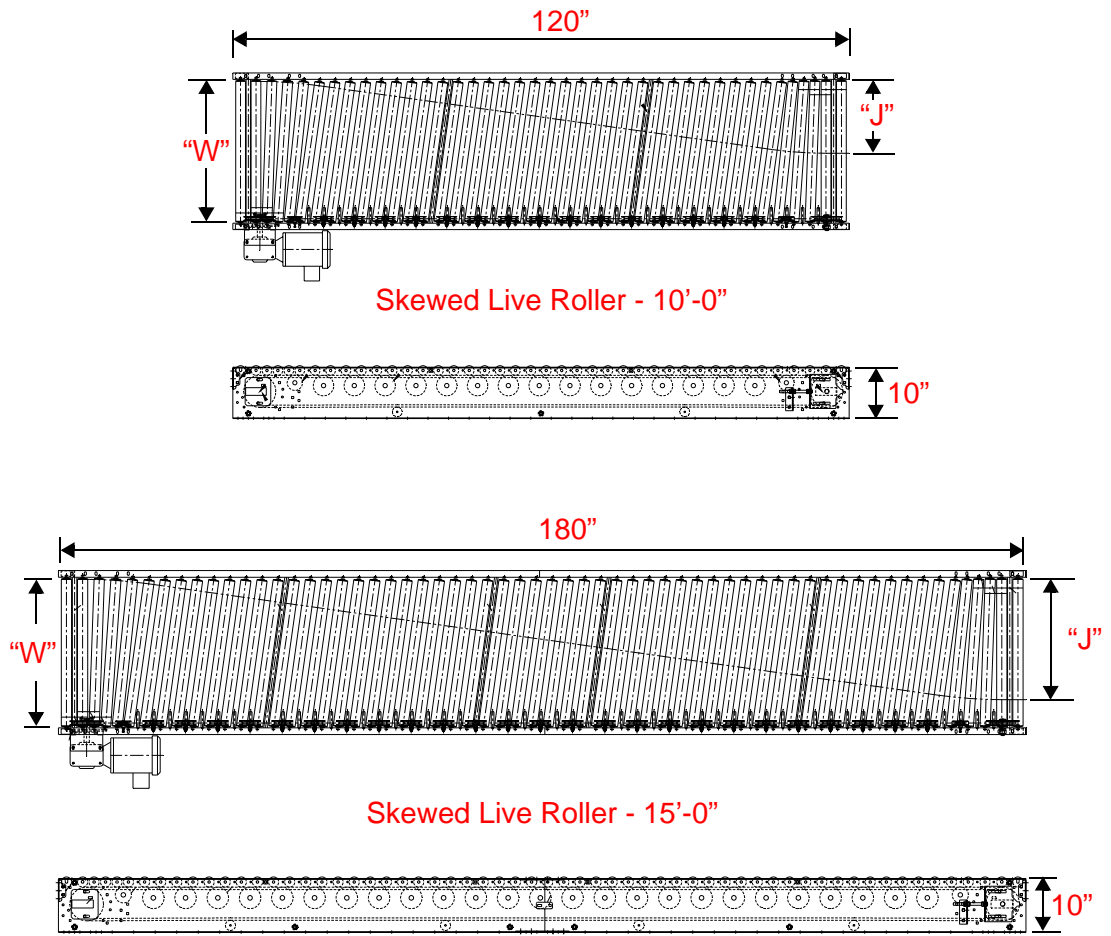


Figure E - 16 Skewed Live Roller - 10'-0, 15'-0" and 20'-0" (Not Shown)

Table E 14: Skew Angles and Offsets

"W"	Angle	Inches of Skew "J"		
		10'-0"	15'-0"	20'-0"
16"	8°	14"	22"	X
22"	8°	14"	22"	X
28"	8°	14"	22"	X
34"	8°	14"	22"	30"
40"	8°	14"	22"	30"

Straight Section Style 01P or 01_

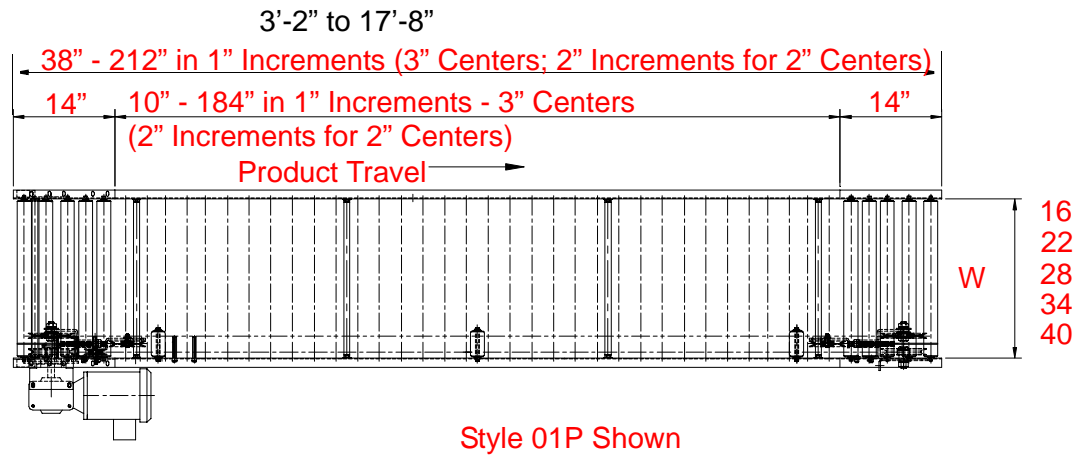


Figure E - 17 Straight Section

Merge, Diverge, and Crossover - Take-Up Section

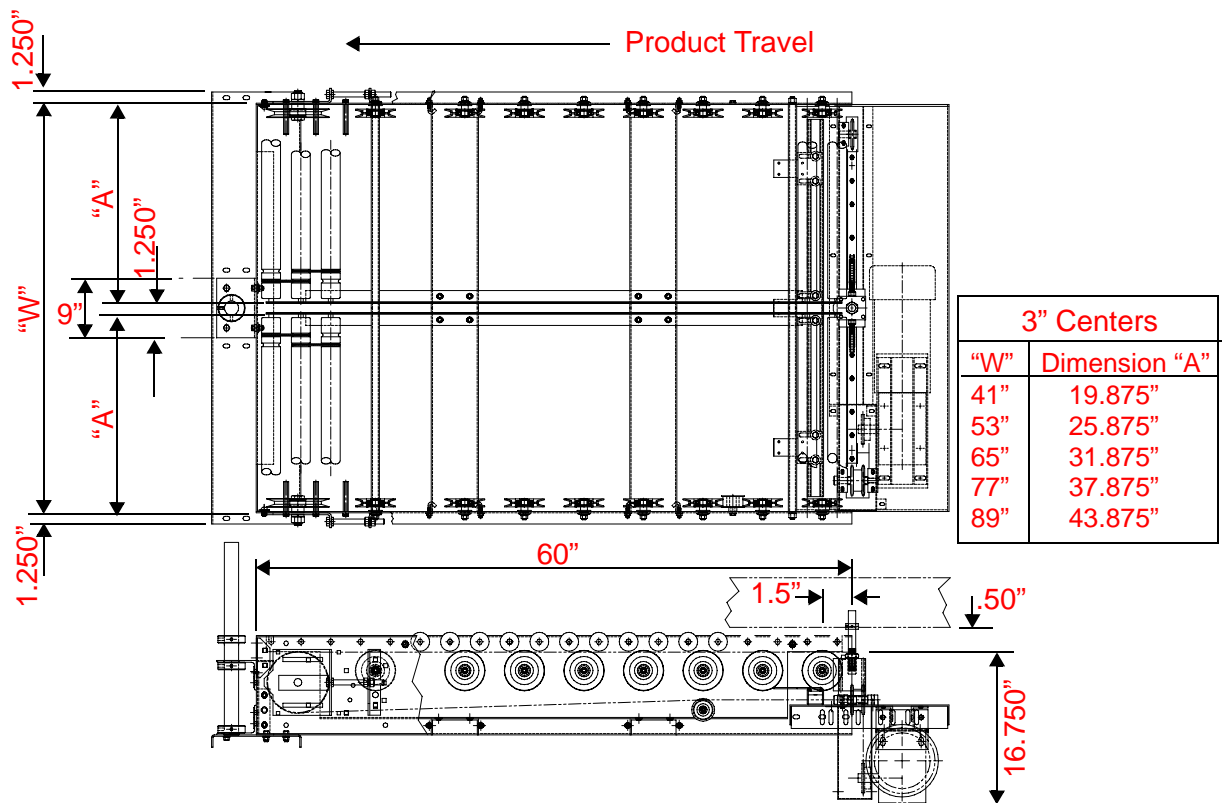


Figure E - 18 Merge, Diverge, and Crossover - Take-Up Section

Merge, Diverge, and Crossover - Intermediate Section

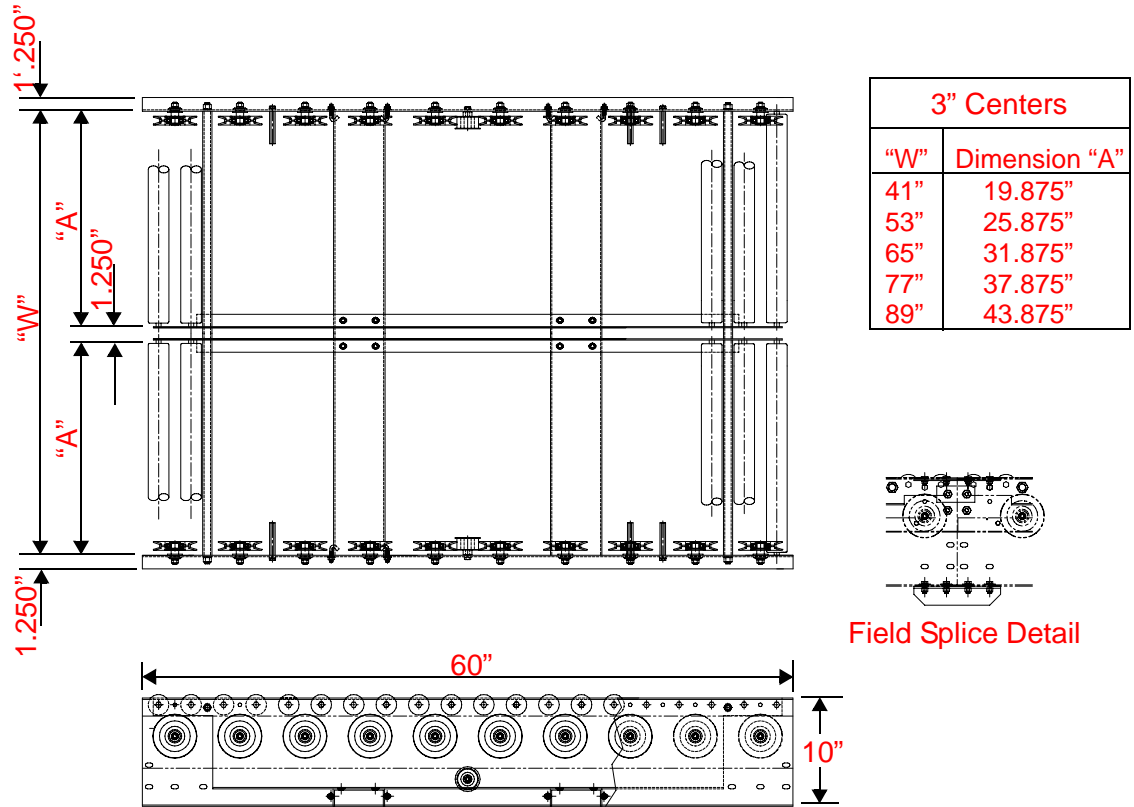


Figure E - 19 Merge, Diverge, and Crossover - Intermediate Section

Merge, Diverge, and Crossover - Drive Section

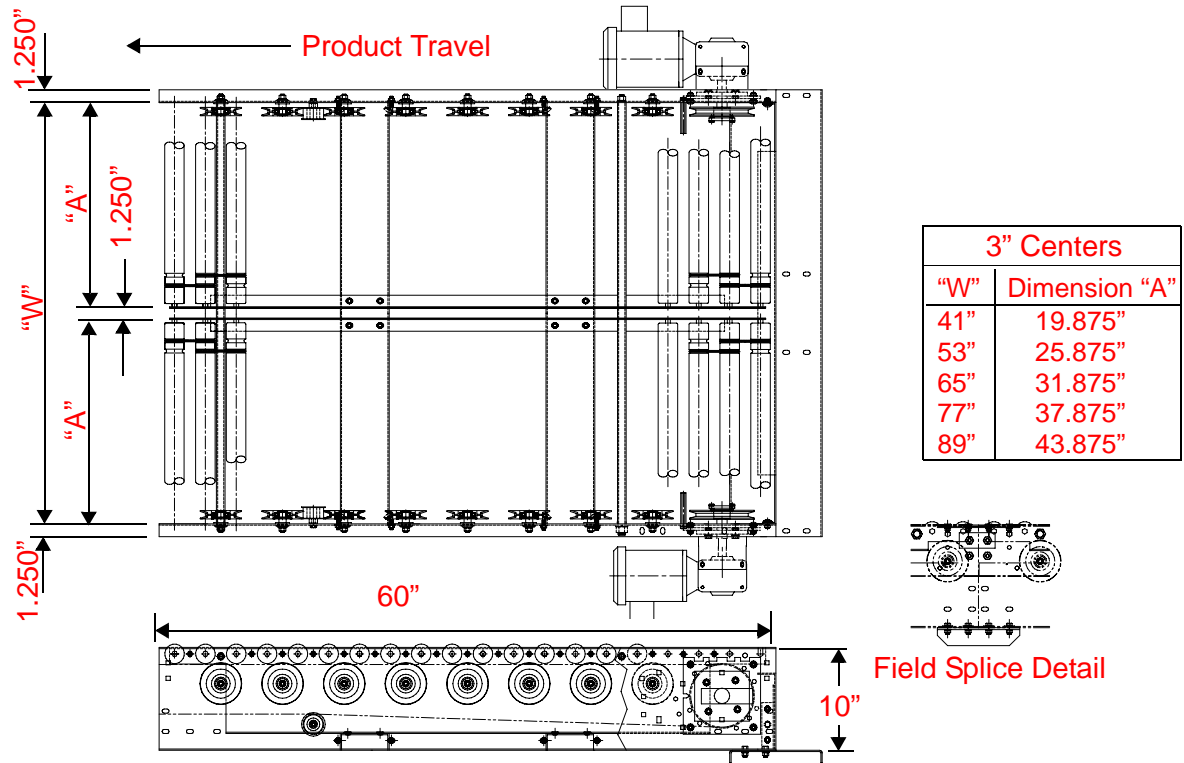


Figure E - 20 Merge, Diverge, and Crossover - Drive Section

Table E 15: Merge, Diverge, and Crossover Drive/Limit Switches

	Motors (Qty.)	Limit Switches (Qty.)
Merge	2	0
Diverge	3	2
Crossover	3	3

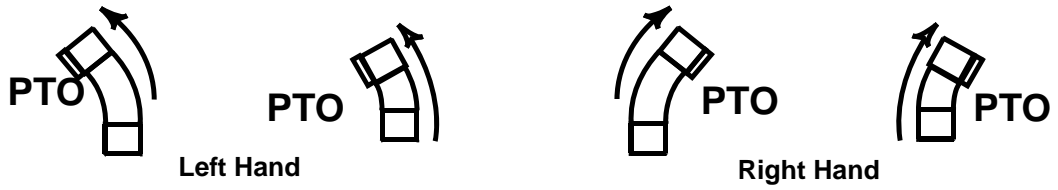
Assembly Designations

The arrangement of a conveyor's components and the power unit location is described by the use of "Right-Hand (RH) or Left-Hand (LH)" assembly designations.

For a curve, the assembly designation is based on the direction it turns (when looking in the direction of travel).

For a "merging" or "diverting" junction, it is based on the side of the main-line conveyor to which the junction is mounted (when looking in the direction of travel).

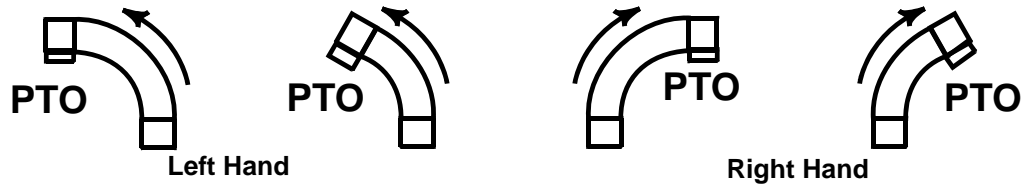
**Power-Unit Assembly
Style 07 - 08 (45° & 30°) End Driven V-Belt Curve**



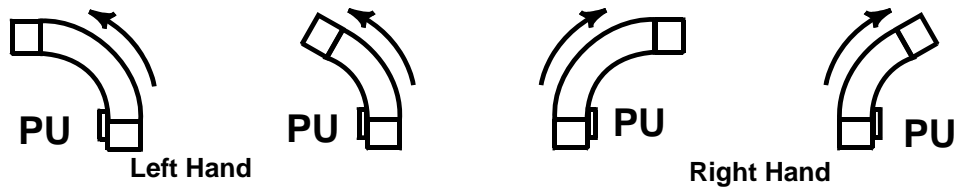
**Power-Unit Assembly
Style 07P - 08P (45° & 30°) End Driven V-Belt Curve**



**Power-Unit Assembly
Style 05 - 06 (90° & 60°) End Driven V-Belt Curve**



**Power-Unit Assembly
Style 05P - 06P (90° & 60°) End Driven V-Belt Curve**



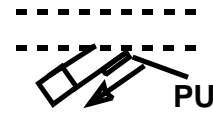
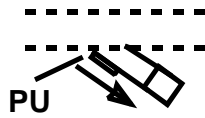
**Power-Unit Assembly
Style 09 (180°) End Driven V-Belt Curve w/o Center**



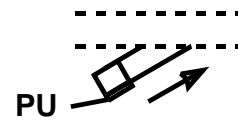
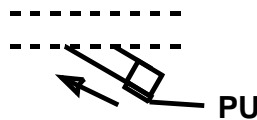
LHM - RHD

RHM - LHD

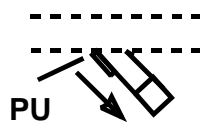
Style 14 - 30° - Straight Spur (Spur End Driven)



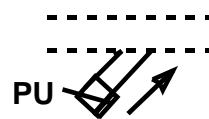
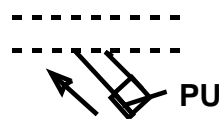
Style 14P - 30° - Straight Spur (End Driven)



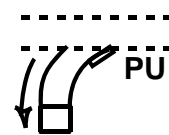
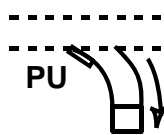
Style 18 - 45° - Straight Spur (Spur End Driven)



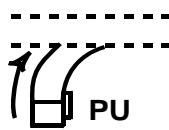
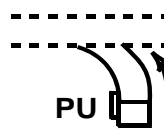
Style 18P - 45° - Straight Spur (End Driven)



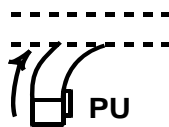
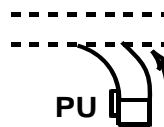
Style 21 - 90° - Spur / Curve (Spur End Driven)



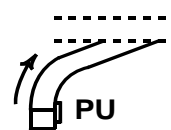
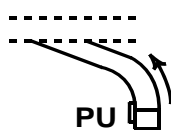
Style 21P - 90° - Spur / Curve (End Driven)



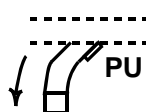
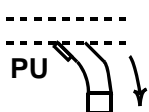
Style 15 - 30° - Straight Spur w/ 60° Curve (Spur Driven)



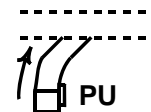
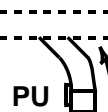
Style 15P - 30° - Straight Spur w/ 60° Curve (End Driven)



Style 19 - 45° - Straight Spur w/ 45° Curve (Spur Driven)



Style 19P - 45° - Straight Spur w/ 45° Curve (Curve Driven)



SECTION F: ACCESSORIES

Traffic Controller

Traffic controllers (see Figure F - 1) are frequently used instead of electrical control methods to provide orderly merging of products from a side line into the product flow on a main or collecting line. Since only one arm can be moved at a time, traffic controllers perform on a first-come-first-served basis without being able to anticipate the effects of their flow control actions.

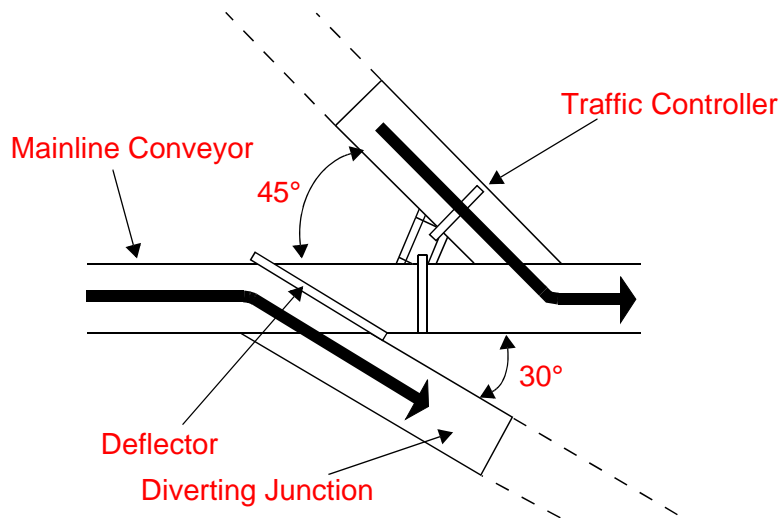


Figure F - 1 Traffic Controller and Case Deflector

Merge Divert Arm

The divert arm for the merge is available as a straight angle or a curved angle (See Figure F - 2). The straight angle arm is shipped automatically unless you specify the curved angle arm. If you specify the curved angle arm, it is available with a UHMW face (DFU) or a wheel face (DFW).

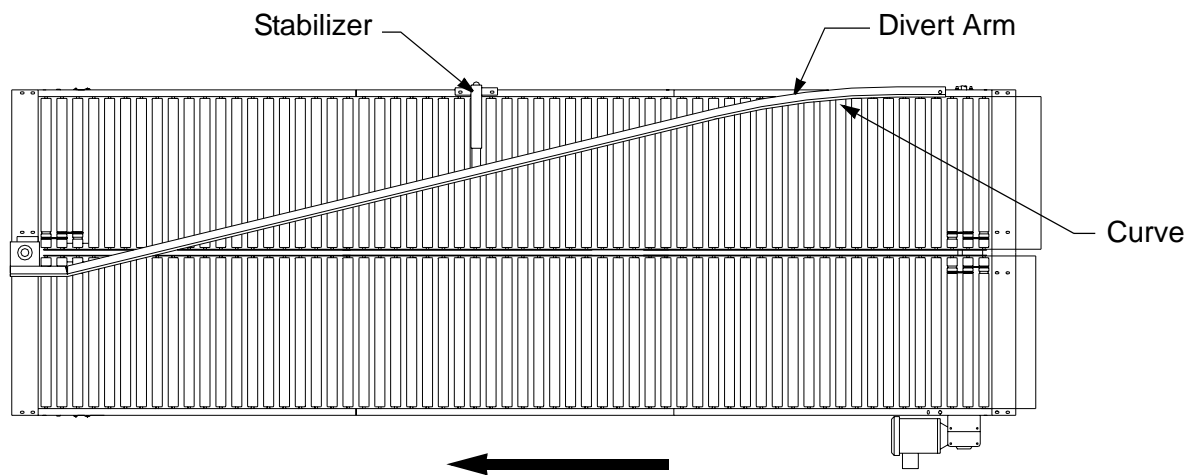


Figure F - 2 Divert Arm, Curved Angle

SECTION G:INSTALLATION PROCEDURES

Accepting Shipment

Immediately upon delivery, check that all equipment received agrees with the bill of lading or carrier's freight bill. Any shipping discrepancy or equipment damage should be clearly noted on the freight bill before signing.

Shortages or Errors

Report any shortages or errors to the Manufacturer's Customer Service in writing within ten days after receipt of shipment.

Lost or Damaged Shipment

Report lost shipments to the Manufacturer's Shipping Department.

If shipping damage is evident upon receipt of the conveyor equipment, note the extent of the damage on the freight bill and immediately contact the transportation carrier to request an inspection. Do not destroy the equipment crating and packing materials until the carrier's agent has examined them. Unless otherwise agreed by the manufacturer, the Purchaser (User) shall be responsible for filing claims with the transportation carrier. A copy of the inspection report along with a copy of the freight bill should be sent to the Manufacturer's traffic department.

Claims and Returns

All equipment furnished in accordance with the Manufacturer's Agreement is not returnable for any reason except where authorized in writing by the Manufacturer. Notification of return must be made to the Manufacturer's Customer Service Department, and if approved, a "Return Authorization Tag" will be sent to the Purchaser (Users). The return tag sealed in the "Return Authorization Envelope" should be securely affixed to the exterior surface on any side of the shipping carton (not top or bottom) or affixed to any smooth flat surface on the equipment, if not boxed.

Send authorized return shipment(s) transportation charges prepaid to the address indicated on the Return Authorization Tag. If initial shipment is refused, the Purchaser (User) shall be liable for all freight charges, extra cost of handling, and other incidental expenses.

Codes and Standards

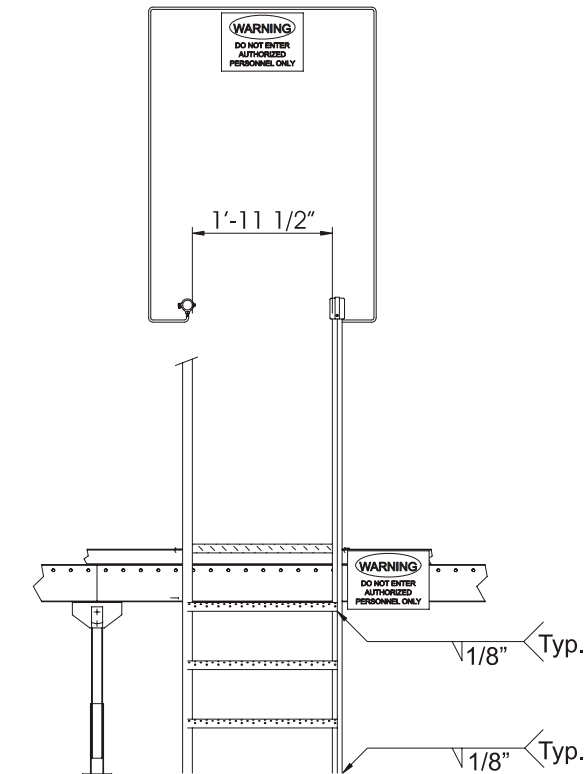
The conveyor equipment is designed and manufactured to comply with the American National Standard Institute's "SAFETY STANDARDS FOR CONVEYORS AND RELATED EQUIPMENT" (ANSI/ASME B20.1) and with the National Electrical Code (ANSI/NFPA70).

The Purchaser/Operator shall be familiar with, and responsible for, compliance with all codes and regulations having jurisdiction regarding the installation, use, and maintenance of this equipment. Appropriate lockout/tagout policy and procedures shall comply with the minimum safety requirements outlined in the American National Standard Institute's current publication (ANSI Z244.1).

Warning Signs

Warning signs and labels posted on or near the conveyor equipment shall not be removed, painted over, or altered at any time. All safety devices, warning lights, and alarms associated with the conveyor system should be regularly tested for proper operation and serviced as needed. If the original safety item(s) become defective or damaged, refer to the conveyor parts list(s) of bill(s)-of-materials for replacement part numbers.

WARNING: For conveyors installed at floor level in an **“Authorized Personnel Access Area Only”**, fixed rollers (3” centers) may be used in conjunction with an emergency pull cord. The area must be apart from normal working areas and access must be marked with a sign, **“Warning - Do Not Enter - Authorized Personnel Only”**. Part Number for ordering Warning Sign is 957305. The illustration below shows the location for installation of the sign.



TO ORDER LADDER SUPPORTS PER CROSSOVER:		
QNTY:	PART DESCRIPTION:	PART DESCRIPTION:
1	957173	X-OVER SIGN FRAME
2	957174	3/8" DIA NYLON LOOP CLAMP (TO ATTACH SIGN TO FRAME)
4	957175	1 1/4" DIA PIPE RING W/BOLT (TO ATTACH SIGN TO LADDERS)
4	957305	SIGN_WARN BY-WS10 SETON M2540

Safety Features

- Do not turn off conveyor power source(s) and affix appropriate lockout/tagout device(s) to operating controls before servicing the equipment. Only trained and qualified personnel who are aware of the safety hazards should perform equipment adjustments or required maintenance while the conveyor is in operation.
- Do observe all warning signs, lights, and alarms associated with the conveyor operation and maintenance, and be alert at all times to automatic operation(s) of adjacent equipment.
- Do use extreme caution near moving conveyor parts to avoid the hazard of hands, hair, and clothing being caught.
- Do not sit on, stand on, walk, ride, or cross (over or under) the conveyor at any time except where suitable catwalks, gates, or bridges are provided for personnel travel.
- Do not attempt to repair any equipment while the conveyor is running, replace any conveyor component without appropriate replacement parts, or modify the conveyor system without prior approval by the manufacturer.
- Do not operate the conveyor until all safety guards are securely in place, all tools and non-product materials are removed from or near the conveying surfaces, and all personnel are in safe positions.
- Do not remove or modify any safety devices provided on or with the conveyor.
- Do not clear jams or reach into any unit before first turning off the equipment power source(s) and affixing appropriate lockout/tagout device(s).

Parts Replacement

To minimize production downtime, selected conveyor spare parts should be stocked for replacement of defective components when required. Refer to the equipment bill(s)-of-materials where quantity requirements or code numbers are not indicated on the conveyor parts list. For added convenience, a list of selected spare parts for standard products is included in this manual (see Section I).

Factory Assistance

Contact Customer Service for installation, operation, or maintenance assistance, or replacement parts.

Pre-Installation Check

General Preparations

Review the conveyor layout drawings to determine the proper location, orientation, and elevations of the conveyor sections. Read all instructions provided in this manual. Make sure that all equipment, hardware, and tools are present to complete the job.

Large Conveyors

Some VBLR conveyors are too large to ship in one piece. The VBLR conveyors can be shipped as “complete” or “broken” units.

“Complete” V-Belt Conveyor

When size and configuration permit, V-Belt conveyors are shipped from the factory fully-assembled. When installed: 1) the belt tension should be checked; and 2) the axles of all carrier rollers should be checked to verify that they have vertical play in their mounting holes. If the roller axles are positioned at the top of the axle mounting hole, refer to the appropriate Equipment Checks in the next section.

“Broken” V-Belt Conveyor

When a V-Belt conveyor’s size and/or configuration makes it impractical to ship and handle as a single assembly, it is manufactured and shipped as two (2) or more sub-assemblies that are connected together at installation to become a complete conveyor.

- Large curves and junctions (single-belt) require that the sub-assemblies be connected and then: 1) the belt be routed and tensioned; and 2) the appropriate adjustments be made for the drive, idler and pressure sheaves. Refer to the appropriate Equipment Checks in the next section.
- For S-curves and junctions (dual-belt), one fully-assembled sub-assembly* (size permitting) with drive/idler sheave(s) and a power transfer unit will be shipped from the factory with the belt properly routed and tensioned and the sheaves properly adjusted; the other sub-assembly(s) will require that; 1) the second belt be routed and tensioned; and 2) the appropriate adjustments be made for the drive, idler and pressure sheaves. Refer to the Equipment Checks in the next section.

(* If a conveyor’s size is such that a “complete” sub-assembly cannot be supplied, then: 1) both belts will need to be routed and tensioned; and 2) the appropriate adjustments be made for the drive, idler and pressure sheaves. Refer to the appropriate Equipment Checks in the next section.

The factory uses tables and calculations to determine how the unit can be shipped, however, as a general guide, the unit must be shipped in sections if either of the following is true:

- The length of a unit, as shown in the following layout figures, exceeds 150”
- The width of a unit, as shown in the following layout figures, exceeds 90”

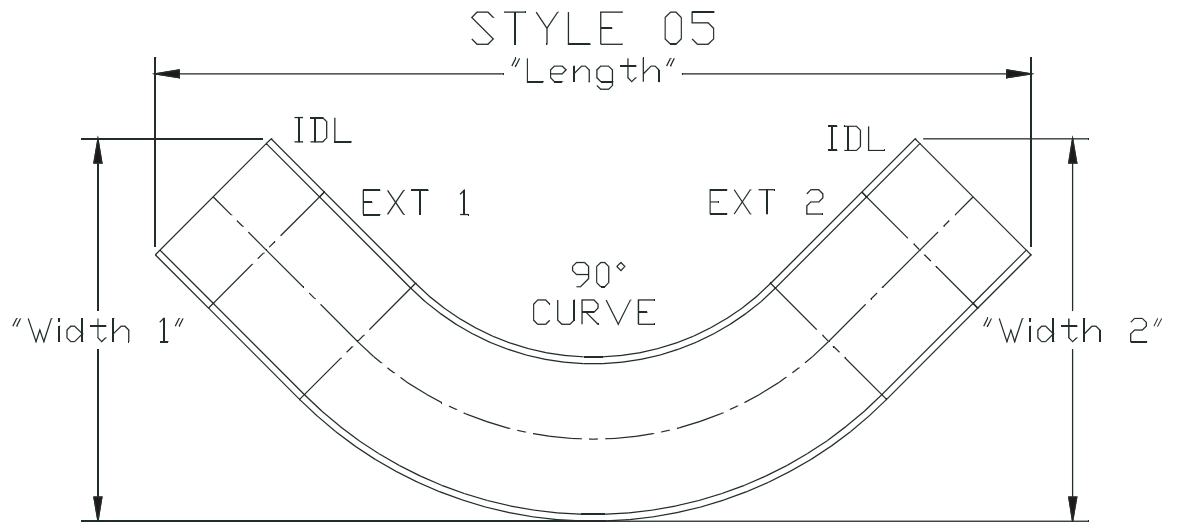


Figure G - 1 Shipping Layout, 90° Curve

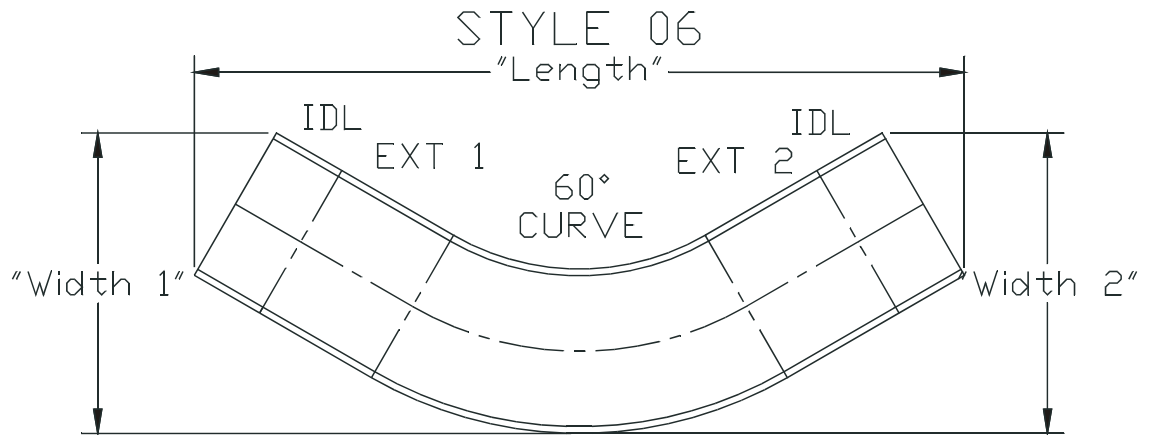


Figure G - 2 Shipping Layout, 60° Curve

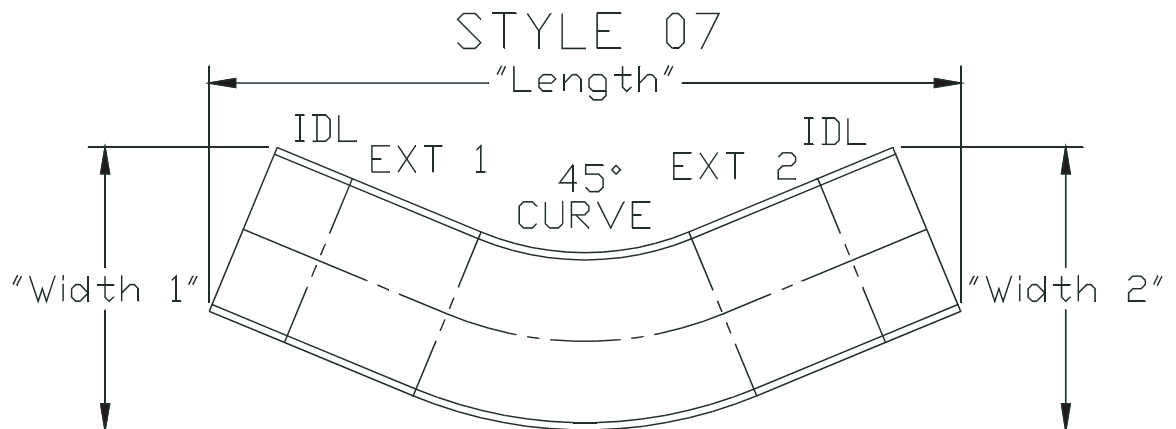


Figure G - 3 Shipping Layout, 45° Curve

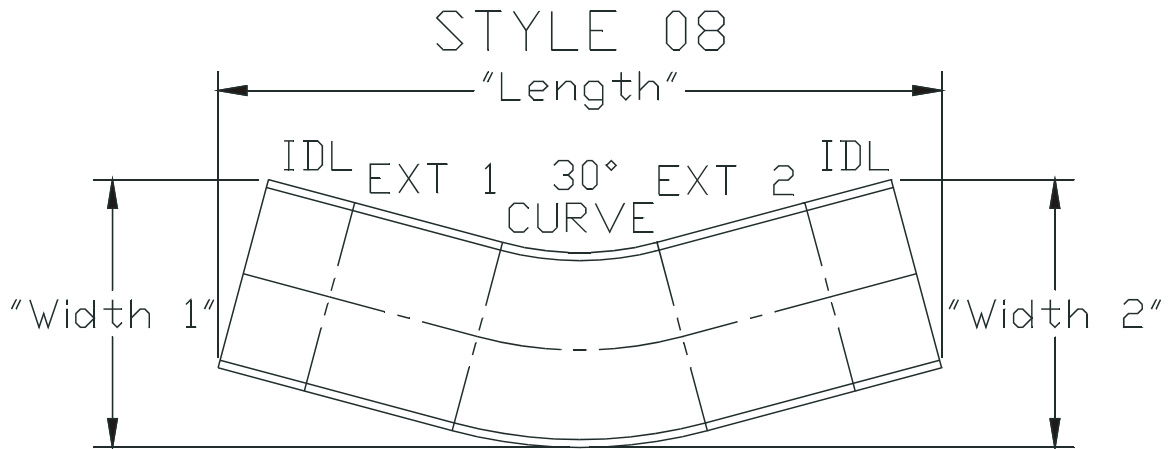


Figure G - 4 Shipping Layout, 30° Curve

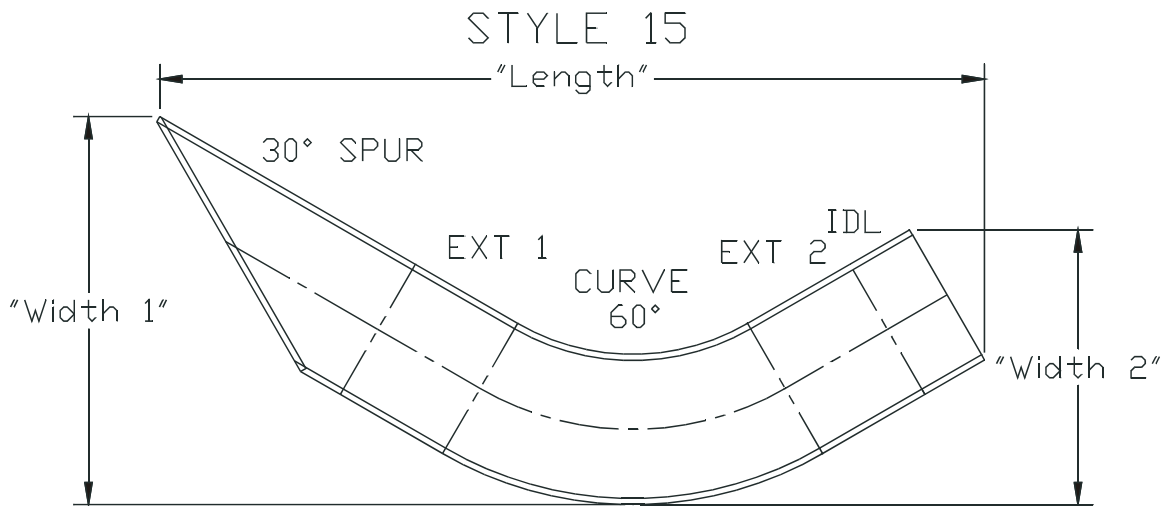


Figure G - 5 Shipping Layout, 60° Curve with Spur

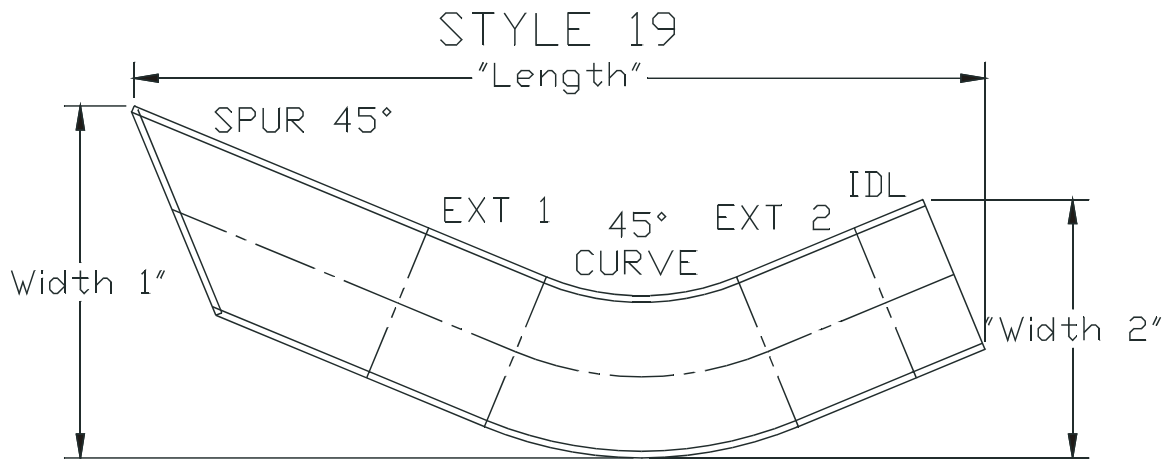


Figure G - 6 Shipping Layout, 45° Curve with Spur

Equipment Checks

Most VBLR units are assembled at the factory. During subsequent handling, the assembly may be jarred out of adjustment. Before each unit is installed, check and adjust the following items as necessary:

Snub Sheave Assemblies

The conveyor's Carrier Rollers are driven by the V-belt which is supported by Snub Sheave assemblies along one side of the frame (inner curve rail). Each sheave is adjustable to provide the appropriate amount of drive to propel the product being conveyed. The assembly provides 7/8" spacing between the frame and the centerline of the sheave and belt.

Snub Sheaves are factory-assembled to the conveyor frame and shipped in their "low" position. These sheaves range in diameter from 2" to 4" and may be flat, single flange, or V-grooved.

All assemblies use the same components. An eccentric spacer, keyed to a stud-type mounting axle between the sheave's precision bearing and the frame rail, has a concentric shoulder that is contained within a 7/8" diameter hole punched in the rail. The end of the axle shaft that extends through the rail is threaded for a 3/8"-16 hex nut and incorporates a hex shaped socket to accept a 3/16" hex key. A notch on the shaft's end surface indicates the position of the sheave. When the notch is in its lowest position (6 O'clock) the sheave is also in its lowest position.

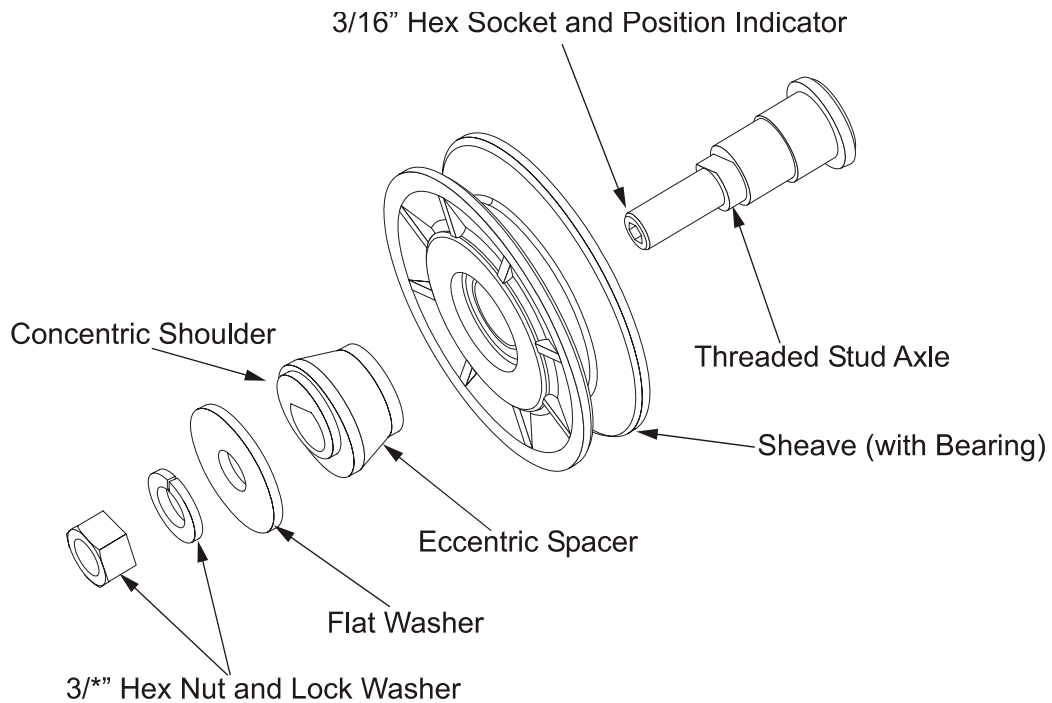


Figure G - 7 Snub Sheave Assembly Components

Snub Sheave Adjustment

V-Belt conveyors are shipped from the factory with their Sheave Assemblies set “low”. Each sheave assembly must be adjusted per the procedures given below prior to system start-up.

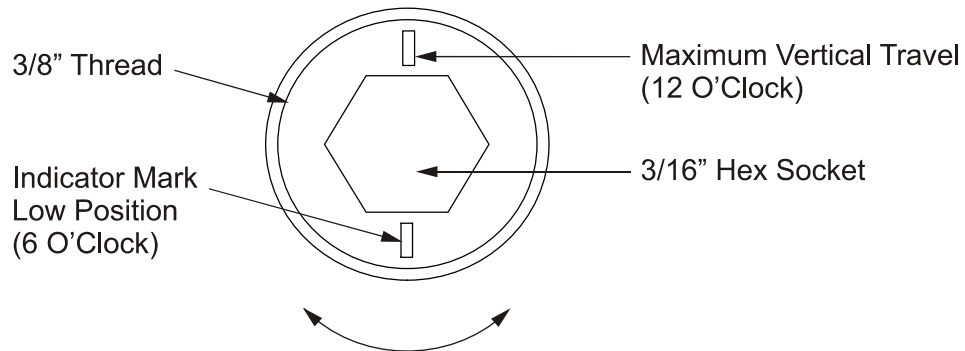


Figure G - 8 End Detail of Stud Axle Shaft and Sheave Position Indicator

1. Insert a 3/16" hex key (allen-wrench) in the the hex-shaped socket in the end of the sheave's axle shaft.
2. Loosen the 3/8" hex nut until the axle shaft can be turned by the hex key.
3. With the position indicator notch factory-set at the “low” position, rotate the axle shaft until the V-belt makes contact with they Carrier Rollers immediately above the sheave.
4. The Carrier Rollers' hex axles may be lifted alightly. **DO NOT** raise the sheave assembly to the point where the axles are ot free to move within the frame's mounting holes.
5. Tighten the 3/8" hex nut and check for free movement of the rollers' hex axles.

End Idler Sheave Adjustment for End Idler Unit - Very Important

The end idler sheave is factory-assembled and shipped in its “low” position. The idler sheave is positioned by the use of an eccentric disk positioned on the 3/4” idler mounting bolt. The eccentric disk engages the rectangular take-up slot in the conveyor side frame. Use the following procedure to properly position the idler sheave:

1. Loosen the 3/4” nut on the idler mounting bolt. (The idler mounting bolt has machined flats on the threaded end and can be turned by using a 9/16” open-end wrench.)
2. Turn the mounting bolt to confirm that the sheave is at its lowest position.
3. Raise the idler until the V-belt makes gentle contact with the roller directly above the sheave.
4. The roller may be lifted slightly, however the conveyor roller hex axle should remain free to move within its mounting hole.
5. While holding the idler mounting bolt at this position, tighten the 3/4” nut.
6. After tightening the nut, check the conveyor roller hex axle (above the idler sheave) for free movement within the mounting holes.
7. Ensure there is minimal tangential force on the idler sheave before power is supplied to the unit. Excessive pressure on this sheave will cause the flanges to break.

Underhung Drive Sheave Height

The drive shaft and sheave assembly is factory-assembled and shipped in its “low” position. It is secured to the side rails by four (4) 3/8” fasteners, two (2) on each side of the conveyor. To properly position the drive sheave:

1. If installed, remove tension from drive chain or timing belt before adjusting the height of sheave.
2. Loosen the two (2) 3/8” fasteners on the side closest to the drive sheave.
3. Raise the assembly until the V-belt makes contact with the roller located directly above the sheave. This roller may be lifted slightly, however the roller’s hex axle should remain free to move within its mounting hole.
4. Hold the assembly in this position and tighten the two (2) fasteners.
5. Loosen the two (2) fasteners on the opposite (non-drive) side.
6. Move the shaft assembly to set the shaft parallel to the conveyor rollers and tighten the fasteners.
7. On PTO driven units it may be necessary to move the shaft horizontally to maintain center distance between drive sprockets.
8. After setting the non-drive side, check the conveyor roller hex axle above the drive sheave for free movement within its mounting hole.

Idler/Drive Sheave Adjustment for S-Curves or Parallel Junctions with Power Transfer Unit

The power transfer shaft and sheave assembly is factory-assembled and shipped in its “low” position. It is secured by four (4) 3/8” fasteners, two (2) on each side of the conveyor. To properly position the drive sheave:

1. Loosen the two (2) 3/8” fasteners which retain the bearing mounting bracket to the angle slips on one side of the conveyor.
2. Raise the assembly until the V-belt makes contact with the roller located directly above the sheave. This roller may be lifted slightly, however the roller’s hex axle should remain free to move within its mounting hole.
3. Hold the assembly in this position and tighten the two (2) fasteners.
4. Repeat the process on the opposite side while keeping the shaft parallel to the carrier rollers.
5. After setting both sides, check the conveyor roller hex axles above the drive sheaves for free movement within their mounting holes.

Side Mount Drive Sheave Height

The drive sheave (mounted directly to the reducer’s output shaft) is factory-assembled and shipped in its “low” position. The reducer’s mounting plate has three slots and one round hole around which the assembly pivots. To properly position the drive sheave:

1. Loosen the four (4) 5/16” fasteners that secure the reducer-mounting plate to the drive unit’s side channel
2. Lower the motor end to rotate the motor-reducer assembly around the single mounting hole and raise the drive sheave (and contained V-belt).
3. Raise the drive sheave until the V-belt makes contact with the roller located directly above the sheave. This roller may be lifted slightly, however the roller’s hex axle should remain free to move within its mounting hole.
4. Hold the drive assembly in this position and tighten the four (4) 5/16” fasteners.

WARNING: For the proper operation of a V-Belt Powered Roller conveyor, it is critical that all V-belt sheaves be properly adjusted. DO NOT over-snub the sheaves (raising them higher than necessary to achieve adequate drive). Doing so may cause premature wear or failure of components within the drive system.

Drive Sheave Vertical Placement

The drive sheave is mounted directly to the gear reducer output shaft with a tapered bushing hub. To achieve the required 7/8" dimension at the drive sheave, the reducer output shaft will be recessed in the hub of the drive sheave by about 3/8". If the frame to the drive sheave centerline dimension is other than 7/8", loosen the tapered bushing bolts and move the hub to achieve the 7/8". Then tighten the bolts to 9 ft.-lbs. of torque.

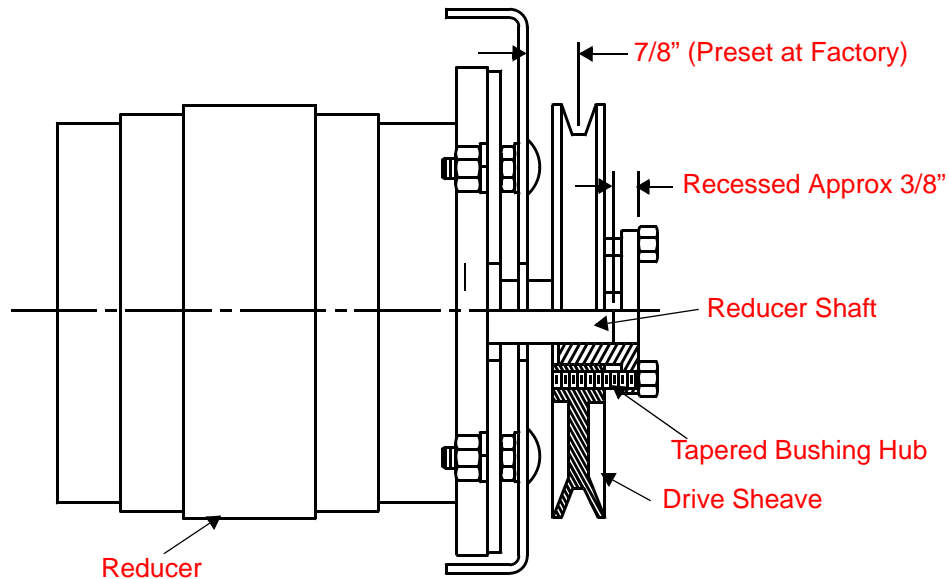


Figure G - 9 Drive Sheave Assembly

Belt Tension Adjustment

The tail sheave is at the terminal end of a curve, opposite the drive end. The centerline of the tail sheave and V-belt must be 7/8" from the side frame. The tail sheave is mounted to a take-up bracket to provide belt tension.

Adjust the take-up pulley so that the belt tension is just tight enough to prevent the belt from slipping on the drive pulley. Excess tension will reduce the life of the belt, lacing, snub rollers, and pulley bearings.

If the belt is under-tensioned, slippage may occur at the drive sheave. On the other hand, if the belt is too tight, the sheave bearings and the belt will wear excessively.

Note: On units equipped with a dually take-up, the belt can be tensioned at either end. Loosen the lock nut, turn the nut next to the tube until the proper belt tension is attained, and retighten the lock nut.

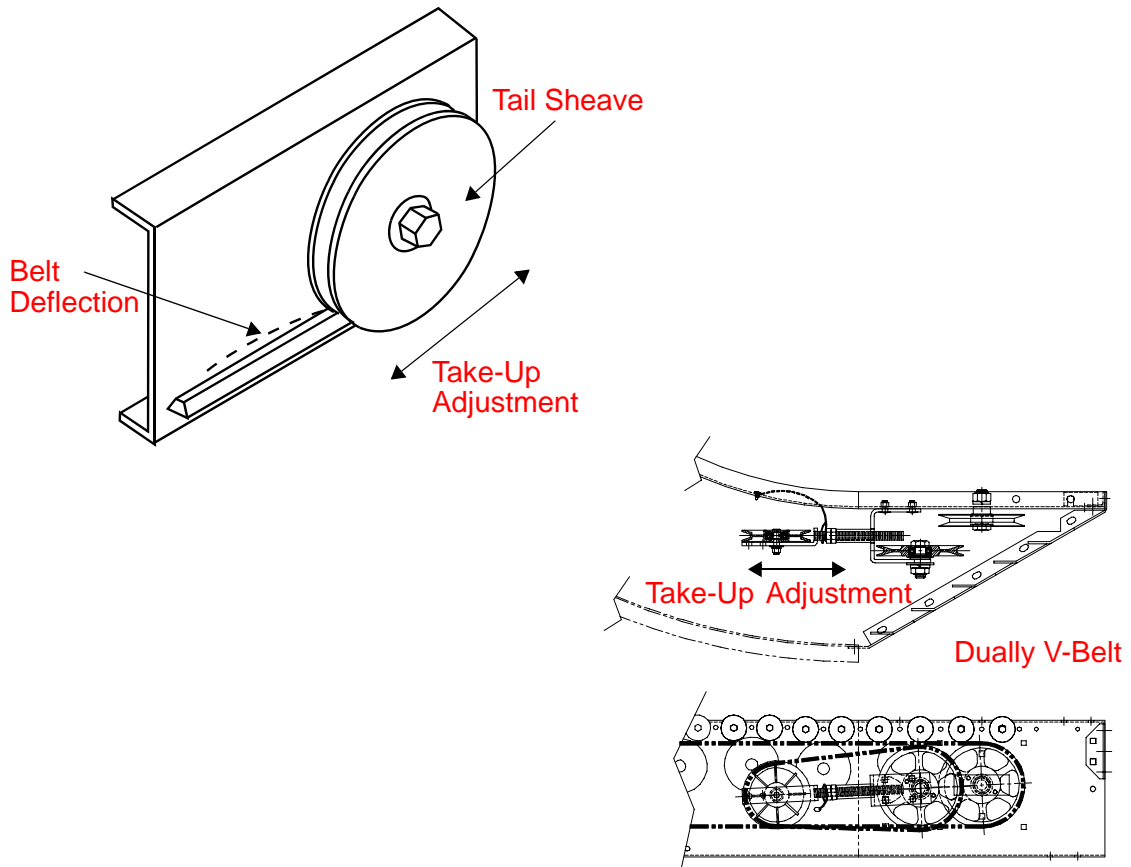


Figure G - 10 – Adjusting Belt Tension

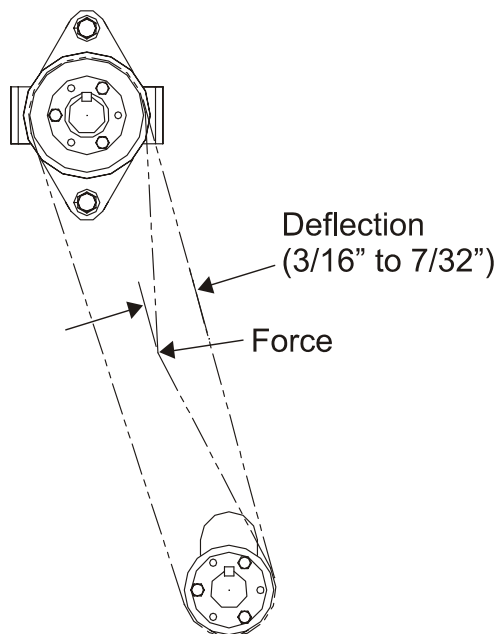


Figure G - 11 Tensioning the Belt on an Under hung Drive

On under hung drives, adjust the drive belt take-up so that the belt teeth mesh securely with the sprocket grooves. Tighten the belt so that it deflects between 3/16" and 7/32".

Return Belt Alignment

As the V-belt leaves the terminal end on the bottom heading toward the center of a curve, the belt will twist 1/4 turn. As the belt goes around the return sheave in the center of the curve, the flat side of the belt will face the outside rail of the curve.

On straight sections, the flat wide side of the return belt should always face downward with no twists.

The return belt must come straight off the bottom of the terminal sheave. At the ends of a curve, the return belt must be parallel to the straight section of the side rail.

The return sheave is mounted at a fixed position on a center spreader cross-brace. If the return belt is not parallel to the straight section of the side rail, consult the factory.

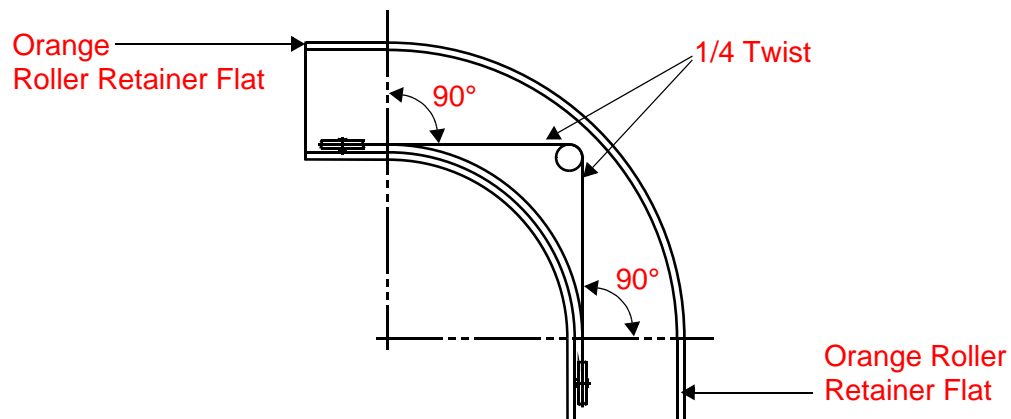


Figure G - 12 Return Belt Alignment - 90° Curve

Note: The roller retainer flat must be removed from conveyors under 8'-0". See label in Figure G - 13. This label appears on the end drive unit.

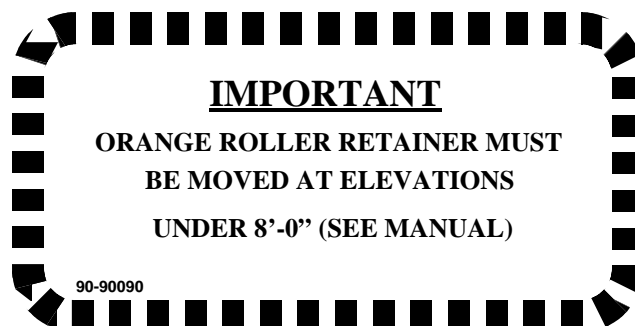


Figure G - 13 Roller Retainer Label

Finger Guards

The finger guards are positioned along the rail adjacent to the drive belt and between each pair of rollers, except where the cross members serve the same purpose. If some finger guards were removed while checking snub assemblies or if they were missing, make sure at this time that all are in place and firmly fastened.

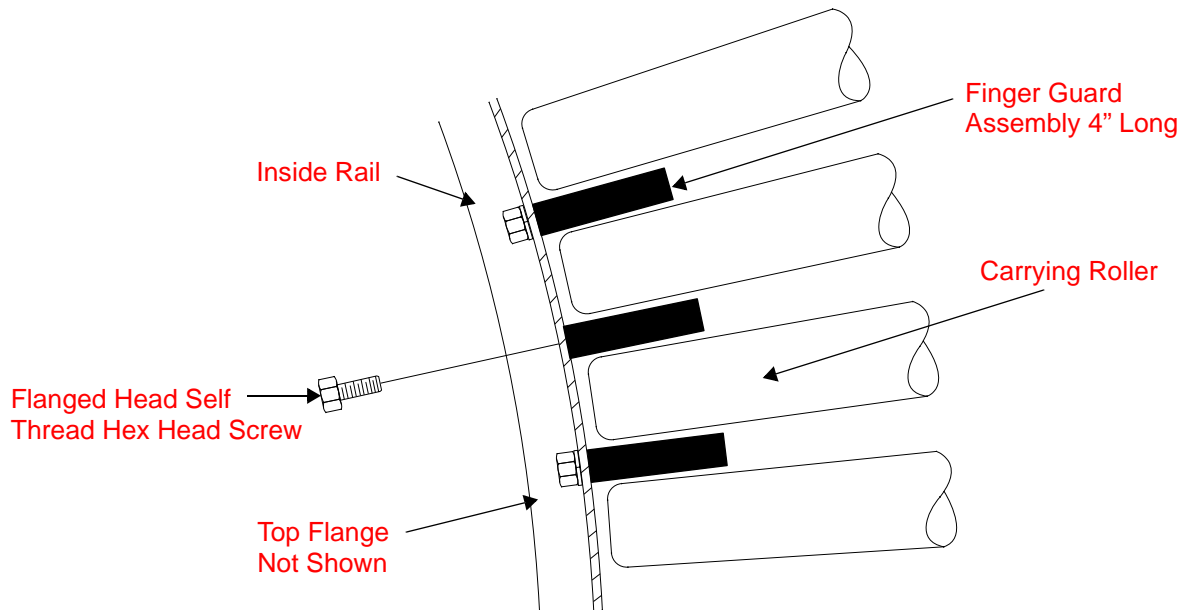


Figure G - 14 Finger Guard Installation

Reducer Preparation

Currently two different types of reducers are supplied, one that has pressure relief vents, and one that is sealed and does not require venting. The maintenance directions received with the equipment will state which reducer was supplied.

If the reducer supplied should have a vent plug, then check to ensure that the vent plug is located in the highest opening in the reducer. If a vent plug type reducer was indicated as being supplied, but was not found, consult the factory.

For vented reducers, check the reducer oil level. If additional oil is necessary, add per the instructions in the vendor literature. Do not add more oil than recommended, since it could cause blowout of the seals and the premature breakdown of the reducer bearings.

Sealed reducers need no preparation.

For additional information, see the vendor data or unit maintenance label or tag.

Soft Start Requirements

Soft starts are required on speeds greater than 350 feet per minute. For push style drives (when the drive is located at the discharge end of the conveyor), soft starts are required for speeds over 250 feet per minute. Acceleration ramp up time should be set to 10 seconds or greater.

PTO Assembly

The PTO assembly must be field completed by mounting and aligning the sprockets, installing the roller chain, and attaching the PTO guard. See Figure G - 15 for instructions.

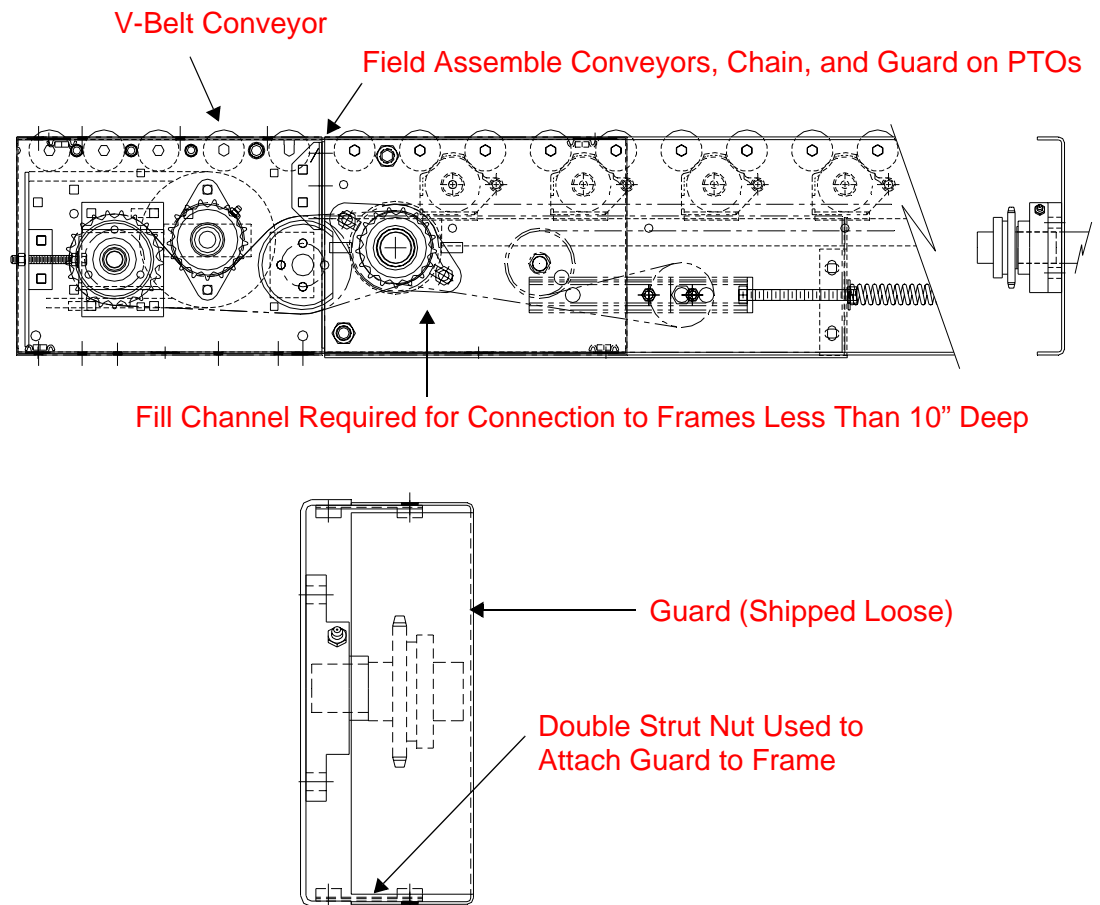


Figure G - 15 PTO Assembly

Curves/Junctions - Support Location Requirements

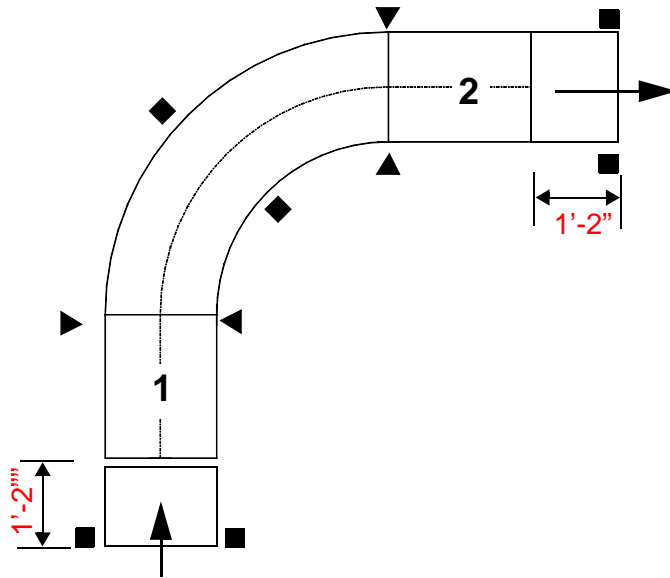


Figure G - 16 Style 5, 90° Curve

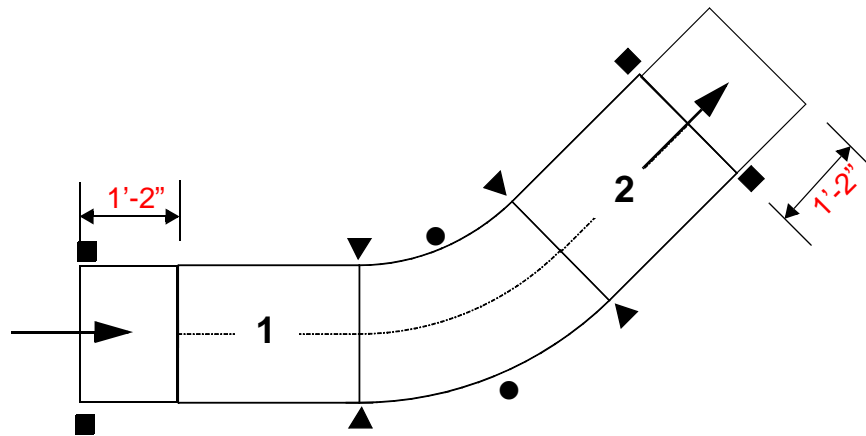


Figure G - 17 Style 6, 60° Curve, Style 7, 45° Curve, and Style 8, 30° Curve

Support Location Legend	
■	Support always required.
▲	Support required only if connecting straight extension section 1 or 2 is 36" or greater.
●	Support required if straight extension section(s) 1 and/or 2 are less than 36".

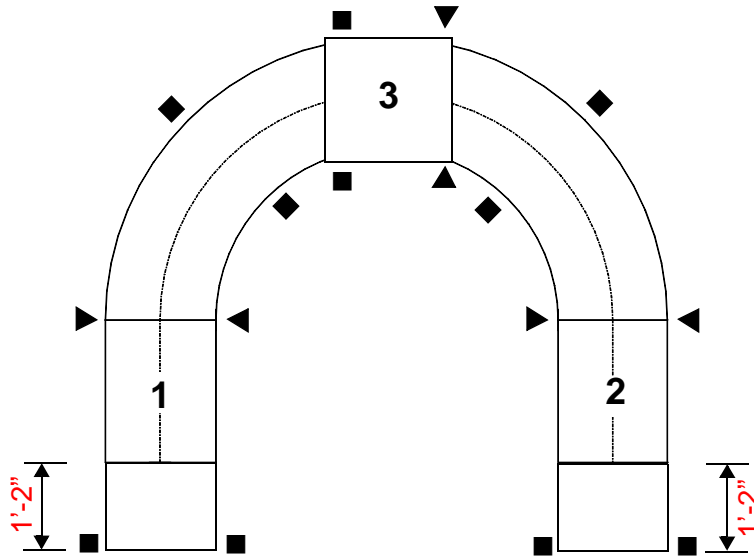


Figure G - 18 Style 9, 180° Curve

Support Location Legend	
■	Support always required.
▶	Support always required only if connecting straight extension (No. 1, 2, or 3) is 36" or greater.

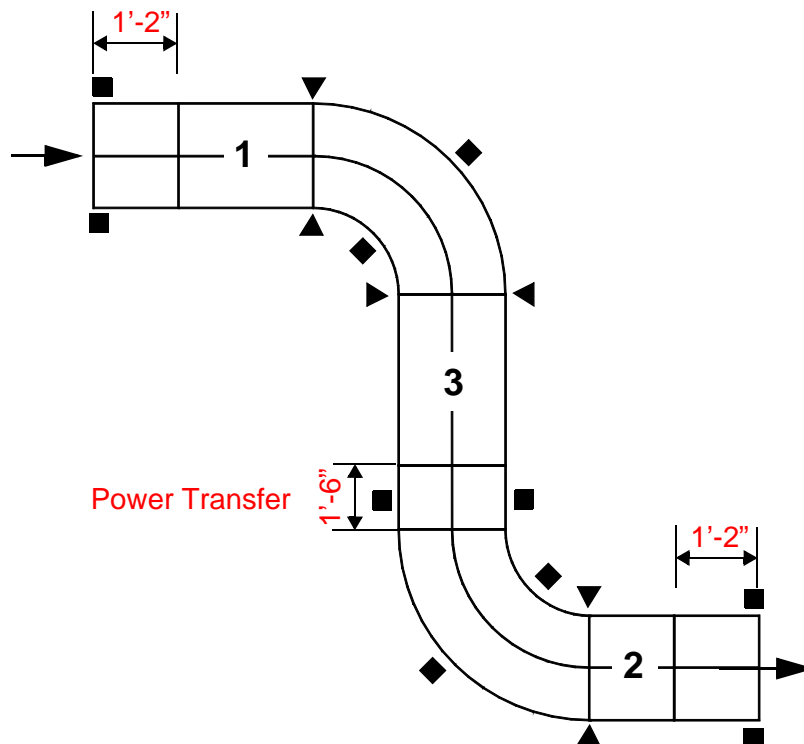


Figure G - 19 Style 10 - 90° S-Curve

Support Location Legend	
■	Support always required.
▲	Support required only if connecting straight extension section (No. 1, 2, or 3) is 36" or greater.
●	Style 11 only. Support required if two adjacent straight extension sections are both between 19" and 36" in length (section no. 3).

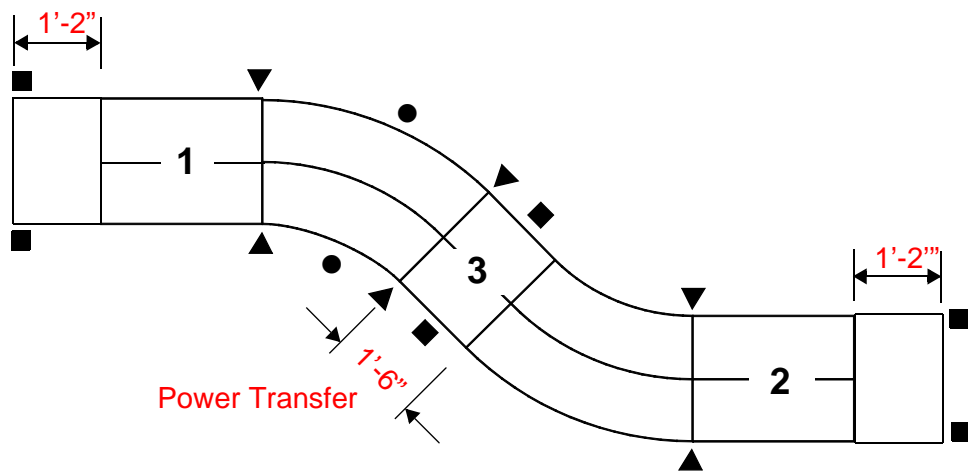


Figure G - 20 Style 11, 60°, Style 12, 45°, and Style 13, 30° S-Curves

Support Location Legend	
■	Support always required.
▲	Support required only if connecting straight extension section (No. 1, 2, or 3) is 36" or greater.
●	Style 11 only. Support required if two adjacent straight extension sections are both between 19" and 36" in length (section no. 3).

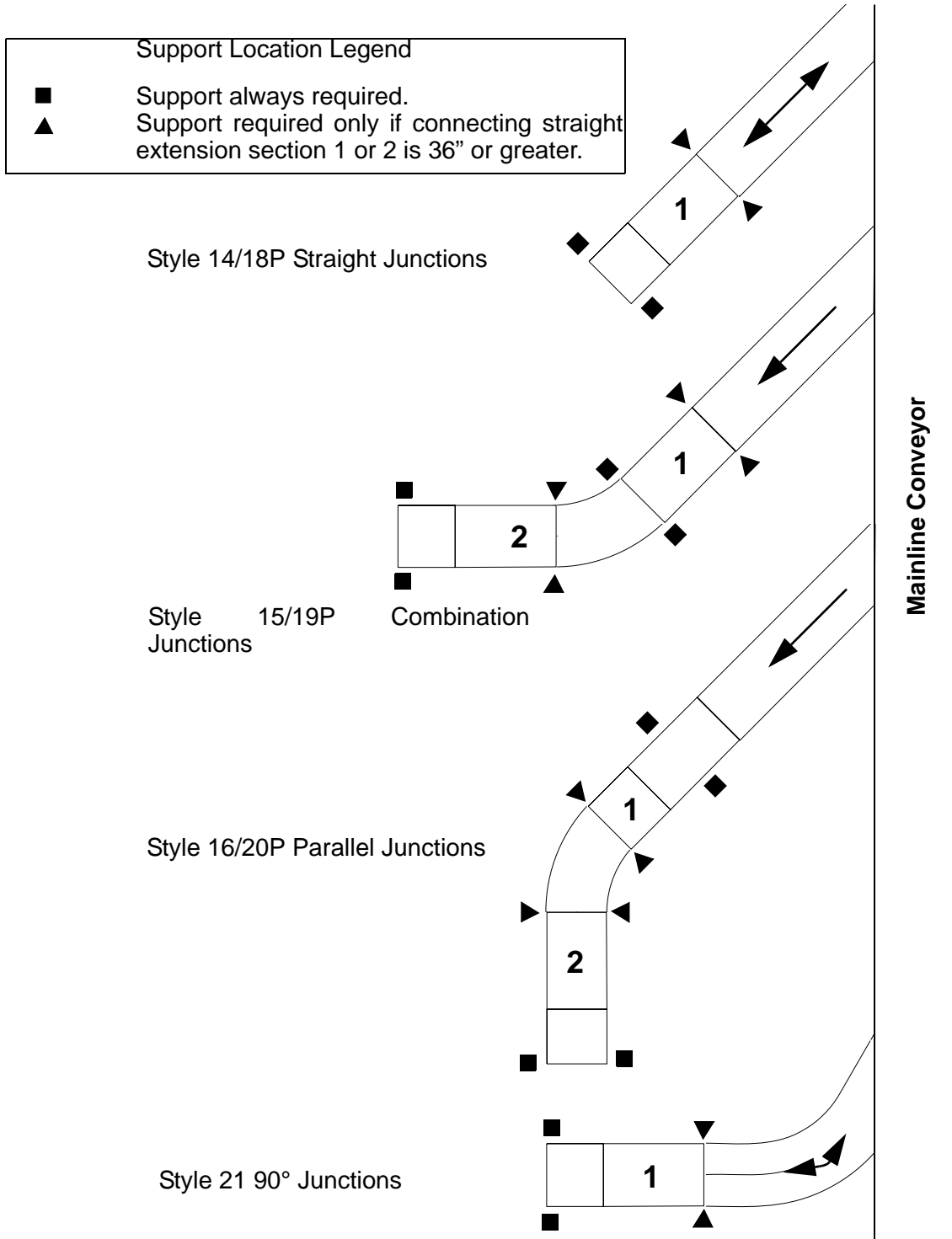


Figure G - 21 Junctions

Assembling the Conveyor

Use the following steps to assemble the conveyor.

1. Snap a chalk line, or use other means, to establish the centerline of the conveyor. According to the layout, arrange the conveyor sections and mounting supports along side the chalk line. Check to be sure that all components are present and are compatible for proper assembly.
 2. Assemble the floor supports or ceiling hangers in their proper locations to receive the first conveyor. Junctions should be supported at each corner and curves at each side of each end and at the midpoint of the outside curved rail.
 3. Starting at one end of the system, progressively position, align, splice, anchor, etc., each of the required conveyor sections or units. Adjust the supports to bring the entire section or curve into level.
 4. Couple the latest section to the preceding mounted section or to an existing conveyor. Coupling should not pull the new or old section out of shape. Use shims for the couplings if necessary.
- Anchor the supports, or terminate the hangers, whichever is specified on the system layout drawings. Typical concrete anchor bolt installation is shown below.

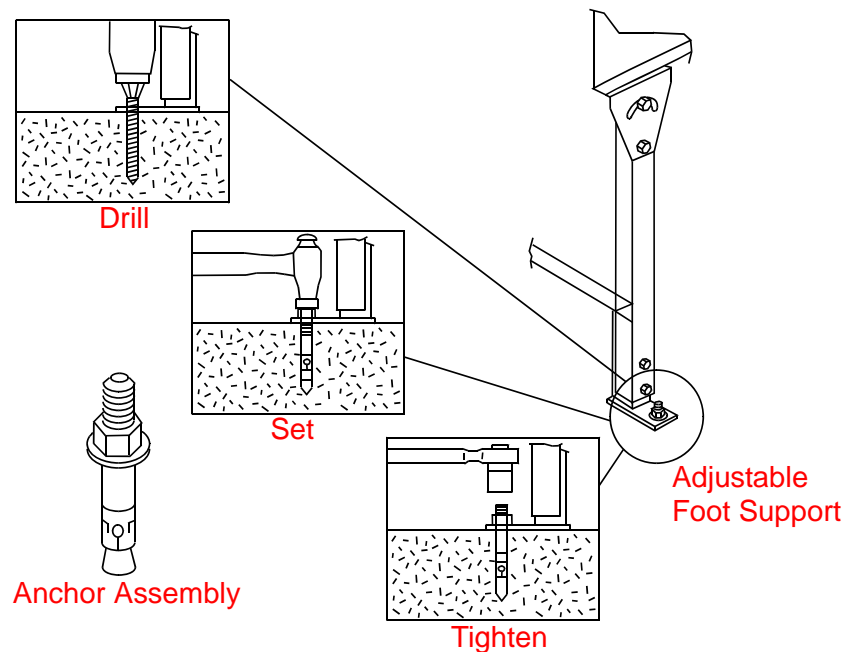


Figure G - 22 Typical Anchor Bolt Installation

- End rollers of all square ends of the VBLR sections are the pop-out type. When coupled to an adjoining conveyor, the pop-out feature is used to prevent a foreign object from getting trapped between the end roller and the moving drive component of the adjoining conveyor.

If the guard rails are to be installed, they must be positioned to permit the pop-out rollers to be released from the VBLR frames.

When a conveyor containing pop-out rollers is installed over 8'-0" above the floor, and it is not accessible to other than maintenance personnel, contain the pop-out rollers by:

- -using hold-down straps
- -providing short chains or cables to hold ejected rollers
- -installing spill guards to catch the rollers and prevent them from being a falling object hazard to workers below.

If the conveyor is accessible to maintenance personnel, signs must be posed to warn against the dangers of pinch points caused by trapped rollers. Also, an emergency pull cord must be provided for stopping the conveyor while clearing jams or performing maintenance.

- Electrical wiring as required should be performed by a licensed electrical contractor.

Each drive motor should have its own starter with overload protection. Each motor should have a locally mounted disconnect switch, lockable in the off condition, which should receive the power from the starter.

Control wiring for photo controls, push buttons, limit switches, or other control devices should be 120 volt and as required by the control drawings and descriptions operation.

Floor Supports

Install the bolts so the nut is on the bottom of the conveyor (see Figure G - 23). The stand head bolts should be left finger tight on the frame while the conveyor is being assembled.

Note: Insure beds are positioned so that the line-shafts are on the proper side.

On the end beds, install one support completely on the frame, so that the center of the upright is 6" from the end.

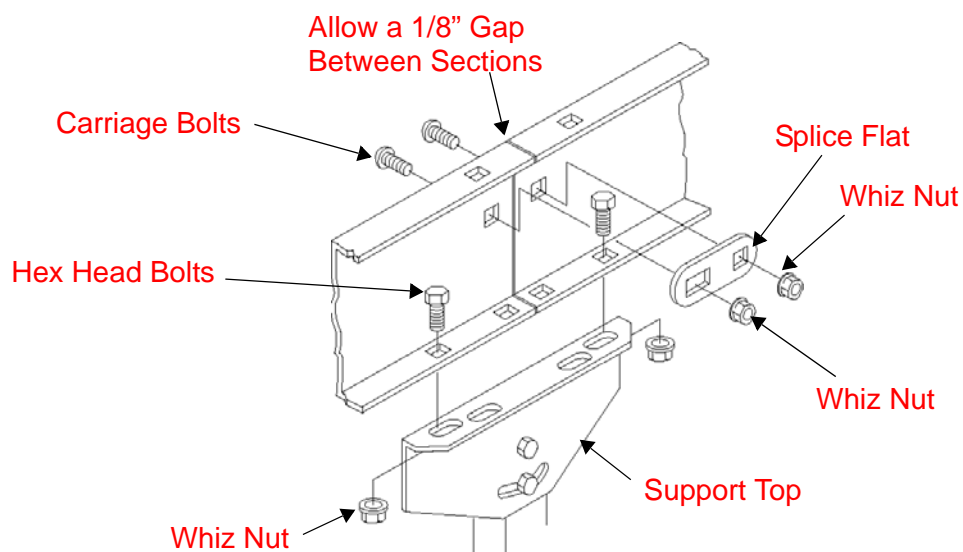


Figure G - 23 Mounting Floor Support

All intermediate supports are installed centered on the joint at the opposite end of the next frame. If a floor support cannot be centered on two adjoining beds, place the support as close as possible to the joint, but not more than two feet from the joint. Bed connectors must then be used at the joint.

Install supports directly to the bottom flange of the bed frames as shown in Figure G - 23.

Adjust the vertical height of the support at this time. Minor adjustments may be necessary for floor irregularity.

Recommended methods for securing are as follows:

1. Concrete or Masonry Floors

- Anchor by drilling into the floor and inserting the suitable bolt anchor.
- Anchor all floor supports with minimum 3/8" diameter bolts, two staggered per floor support.
- Anchor bolts for equipment that is subject to unusual vibration should be minimum 1/2" diameter.

2. Wood Floors

- Anchor using suitable lag bolts. Lag bolt diameters should be the same as the bolt diameters used in concrete or masonry floors, as described above.

Knee Braces

Use knee braces to attain longitudinal stability. The knee brace eliminates stress caused by flow direction, stops, and starts (see Figure G - 24).

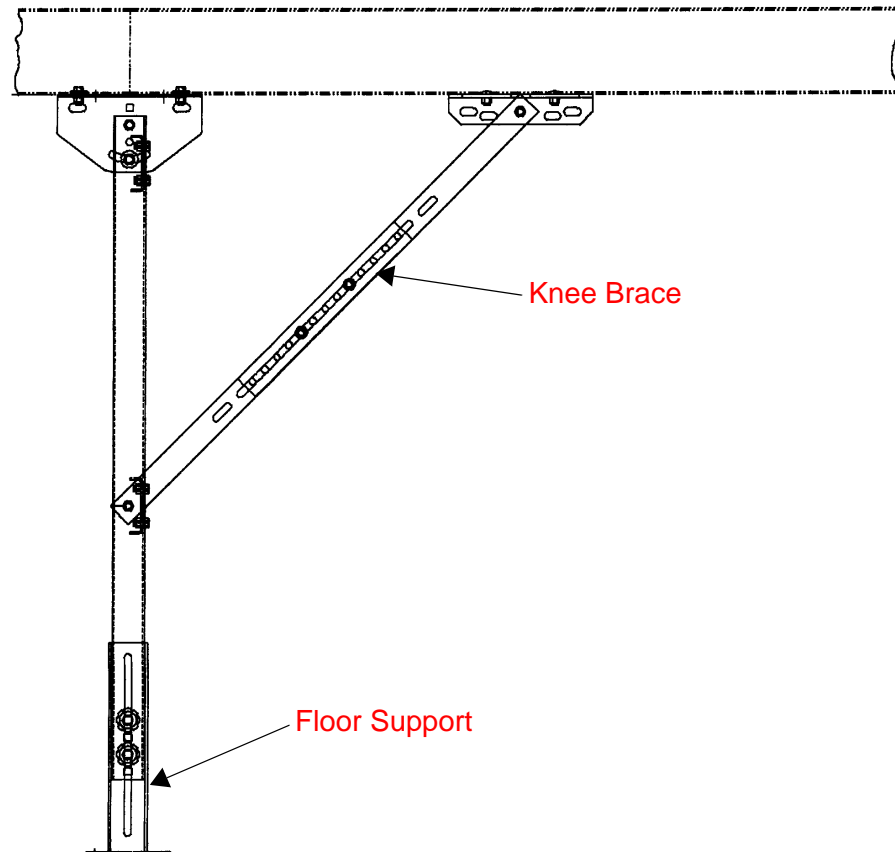


Figure G - 24 Knee Brace

Every support does not require bracing. Use knee braces at:

1. The ends of straight runs.
2. Before case stops.
3. Near the drive.
4. Approximately every 50 feet on a long straight run.

Typically, locate the knee braces on the downstream side of the supports, putting them in tension.

However, starting the conveyor puts opposite stresses of stopping on the legs. Stresses are resisted by installing braces near the drive, back toward the receiving end "upstream".

For the best results, the strap to frame angle should not exceed 45° or be less than 30°. On short supports where a small angle results, the brace strap may be shortened.

End Couplers

End couplers are provided only for the end idler and drive sections (see Figure G - 25).

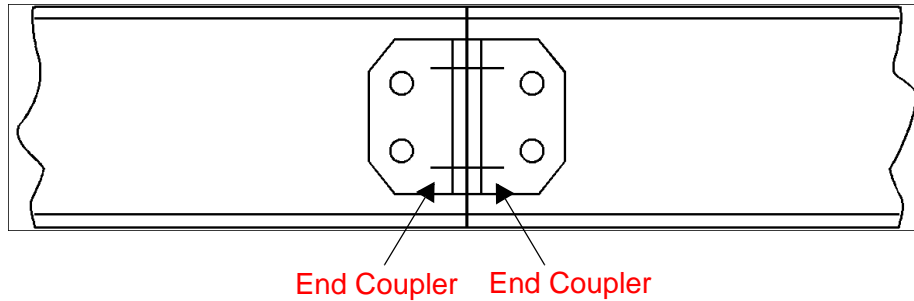


Figure G - 25 End Coupler

Ceiling Mounting Arrangements

Use ceiling hangers to support powered conveyors from the ceiling (see Figure G - 26). The ceiling hangers are required at the joints of intermediate conveyor sections having over 113" from top of roller dimensions.

WARNING: Consult the building architect or a structural engineer regarding ceiling loading or structural limitations of the building and for sizing header steel.

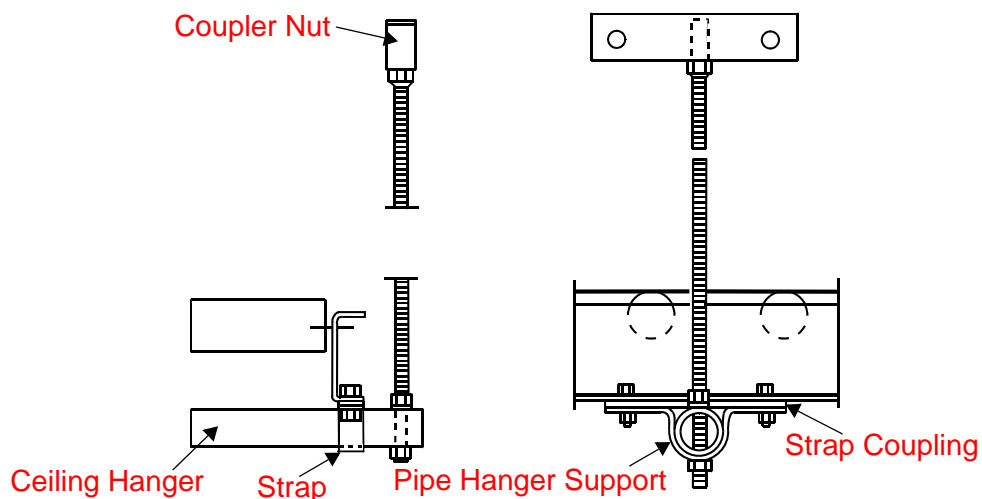


Figure G - 26 Ceiling Mounting Arrangement

Pre-Operation Checkout

Conduct the following inspection to determine if it is ready to respond acceptably to electrical energy before applying electrical power to the VBLR conveyor or system. Lockout and tagout main power to the system before making the following checks.

- Check level and alignment within the conveyor system. Use spirit levels to check levels along the width and length of each curve and junction.
- Check anchoring for tight and secure attachment.
- Check V-belt routing through the sheaves. Check that the V-belt twist is 1/4 turn on either side of the center return sheave on curves and that it does not twist at all on junctions.
- Check V-belt alignment. Make sure that V-belt enters and departs each sheave straight on its centerline.
- Check that all finger guards are in place and securely fastened.
- Check that all guards and safety devices are in place and operating as intended.
- Check all electrical connections and routes to be sure that they meet electrical control specifications.
- Check vent plug presence and location, if required.

Initial Operation

Preliminary operations can be made without some of the mechanical accessories mounted. When all goes well, the accessories can be added for final testing.

Power only one unit at a time so that any potential emergencies can be handled one at a time while performing the following checks.

It is a good practice to have one or more of the future operators of the equipment and the person(s) responsible for their future performance present during the following steps. The experience will help the operators absorb the training.

1. Stand clear of conveyor and jog motors to prove proper rotation. If incorrect, make necessary adjustments.
2. Turn the conveyor on and check the V-belt tracking to assure there is no scraping, wobbling, or side cutting of the belt.
3. Check that the belt is tracking straight into the sheaves.
4. Place a sample of the heaviest product item to be handled onto the conveyor and watch it travel. If it hesitates or stops, see the Troubleshooting section.
5. Observe the heavy package as it travels around a curve. If the package tracks toward either rail, make steering adjustments to one or more of the following as needed:
 - On the outside rail there are three hex holes for every tapered roller axle. These holes are used to assist in steering the product around a curve.
 - If the product moves toward the outside rail, relocate the hex axle to the nearest hex hole forward to help steer the product back toward the inside. Adjust one roller at a time and check after each roller relocation to determine if the product needs any further steering.
 - If the product moves toward the inside rail, relocate the hex axle of one roller to the nearest hex hole backward to help steer the product back toward the outside rail. Again, check after each roller relocation to determine if further adjustment is necessary.
 - Do not move any axle more than one hole in either direction.

-
6. Check the slack of the V-belt for slippage between the V-belt and the drive sheave. Slipping can be corrected by increasing the tension of the belt by taking up the slack with a take-up adjustment.

Operator Training

Conveyor equipment operators should be trained to assure proper, efficient, and safe performance of the conveyor. The owner of the conveyor equipment or system is responsible for training operators in all aspects of correct and safe operation, including what to do in case of emergency.

Training should cover:

- Description of the normal operation of the equipment.
- Statement of the owner's expectations of performance.
- The location of all control sensors, a description of operation, and what to expect when differences occur.
- The location of all safety features and mechanisms, and how to operate them, especially the main and sub-main power shut-off and lockouts and emergency pull-cords.
- A description of all control station(s) and the various elements included as well as a demonstration of the normal sequences of operation. Especially important is the description of a normal start-up sequence and what to expect to see and hear during the initialization.

SECTION H: MAINTENANCE

Recommended service checks and equipment maintenance are outlined below for typical, intermittent-duty conveyor applications. Additional maintenance and servicing schedule adjustments may be required for continuous-duty operation or extreme environmental conditions.

All newly installed equipment should be frequently inspected and serviced as needed during the first 40 hours of operation; thereafter, an appropriate maintenance program should be established and followed (see Table H.1).

Maintaining separate service log sheets on each type of conveyor is recommended for plants operating more than one shift. Each log sheet should show dates, detailed inspection service information, and name or initials of person(s) performing the equipment inspection or service for future reference.

WARNING: Before performing maintenance on a conveyor, make certain that the conveyor's power disconnect is locked in the OPEN position and tagged to prevent accidental or unexpected application of power. Do not perform maintenance while the conveyor is running unless specifically instructed to do so in this manual. It is not necessary to have the conveyor turned ON in order to perform any of the work described in this section. Maintenance must be performed only by qualified personnel who are trained in normal and emergency operations of the conveyor and who are knowledgeable of all safety devices, their locations, and functions.

Before restarting a conveyor:

- Remove all foreign objects from the conveyor.
- Be sure that all guards and safety devices are properly installed and working.
- Make sure that all persons are clear of the conveyor and are aware that the conveyor is about to be restarted.

Table H 1: Scheduled Maintenance

	Components	Item Check									
		Lubrication	Oil Level	Tension	Wear	Alignment	Fasteners	Set Screws	Proper Position	Physical Condition	Operation
Weekly	Belt Return Sheaves									X	X
	Electrical Device								X	X	X
	General Structure						X			X	
	Power Unit - Reducer		X								
	Safety Guards/Devices								X	X	X
	V-Belt			X	X	X				X	
Monthly	Bearings - External						X	X		X	
	Drive Belts/Chains and Sprockets	X		X	X	X	X	X		X	
	Power Unit - Motor						X			X	
	Power Unit - Reducer						X			X	
	Supports and Hangers									X	
	Take-up/Idler Sheave									X	X
Semi Annually 1040 Hrs.	Bearings - External	X									
	Power Unit - Motor	X									
	Power Unit - Reducer	X	X								
	Auxiliary Idler Sheave – PTO with Dually Take-Up & Power Transfer Units							X	X		

Scheduled Maintenance

Intervals indicated for performing maintenance should be considered for an 8 hour per day operation. An application may subject the equipment to conditions that would necessitate more frequent maintenance. This may best be determined by performing maintenance more frequently when the conveyor is first put into operation, and then lengthening the intervals based on experience.

Initial Start-up & Run-In Period

Chain and Sprockets

Check the PTO drive chain tension daily for the first week of operation, then monthly. Refer to the “Chain Maintenance” label on the inside of chain guard.

WARNING: Chain tension must be checked while the conveyor is running with the chain guard removed. When checking, be careful to stay clear of the chain and drive components.

Under Hung Drives

Check belt tension prior to start-up. Adjust as necessary. See “Belt Tension Adjustment” in Section G.

Daily Inspections

General walk-through inspections of the conveyor equipment (listening for unusual noises and carefully observing the system) during daily plant operation is recommended. For continuous duty applications, conduct conveyor inspections once each shift.

Frequently check equipment safety guards, warning signs, lights, and alarms associated with the operation of the conveyor system and keep them in good condition to ensure the safety of all plant personnel. Any unusual conveyor noise, oil leaks, and operational problems should be immediately reported and promptly corrected.

Weekly Inspections

Belting

Check that the V-belt is tracking properly along the entire conveyor length. Make appropriate adjustments of pressure sheaves, etc. If required; check that the belt tension is sufficient to prevent the belt from slipping on the drive sheave under the maximum required load. Remove any buildup of product spillage.

Belt Return Sheaves

Check that all sheaves are in place and tensioned properly against the V-belt. Remove any buildup of dirt and/or product spillage.

General Structure & Operation

Check the conveyor's physical condition, looking for loose fasteners, damaged or wearing components. Listen for unusual noises such as squeaking bearings, chains jumping sprockets, etc.

Check that the conveyed product travels along the length of the conveyor without obstruction or hesitation.

Power Unit Reducer

Check for signs of oil leakage on the floor and/or in the drip pan. If leakage persists or the amount of leakage is significant, repair or replace the unit. Until corrections are made, closely monitor the unit's oil level.

Safety Guards & Devices

Check that the safety guards, warning signs, light, and alarms are in place and in proper working condition. Check that all emergency-stop pull-cords and/or push buttons are functioning properly.

Electrical Devices

Photocells, proximity sensors, limit switches, etc. should be periodically inspected and adjusted as needed. Lenses and reflectors on photoelectric devices should be wiped clean on a daily basis. For additional maintenance provisions, refer to the appropriate vendors instructions provided.

Monthly Maintenance

External Bearings

Check that all mounting bolts, set screws, etc., are securely tightened, and that no lubricant is coming out of the seals. Listen for any unusual noises.

Internal Bearings

Check that the bearings are fully-pressed into the roller tube, and that the lubricant is not coming out the seals. Listen for any unusual noises.

Power Unit Motor

Remove any build-up of dirt/dust around the motor vent openings. Check that all mounting bolts are securely tightened and that the motor lead wires are securely connected.

Power Unit Reducer

Check the oil level while the unit is warm, but not running. If required, add oil through the “fill” hole until the oil begins to run out of the “oil level” hole. All standard reducers are filled by the manufacturer with a synthetic gear lubricant. When replenishing the oil, be sure to use the same brand and type. Do not mix lubricants. For further information, refer to the instruction tag attached to the unit.

To prevent oil leakage, apply Teflon tape or Permatex to the threads of the fill plug and oil level plug before reinstalling. Properly install and tighten the plugs before putting the unit back into operation.

Drive Chain - PTO

Lubricate and check tension per instructions given on the “Chain Maintenance” label located on the inside of the chain guard. Remove any dirt or dried oil with a kerosene soaked rag.

WARNING: Chain tension must be check while the conveyor is running with and/or guards removed. When checking, be careful to stay clear of the chain and drive components.

Drive Sprockets

Check the alignment by placing a straight-edge across the face of both sprockets simultaneously. Also check for wear on the sprocket teeth and side bars of the chain. If loose, tighten the sprocket fasteners.

Belt Tension Adjustment

See “Belt Tension Adjustment” in Section G.

Supports and Hangers

Check that all floor supports and/or ceiling hangers are in good physical condition and have not been damaged. Check that all fasteners are securely tightened and that none are missing.

Semiannual Maintenance

External PTO Bearings

All external bearings have lubed-for-life bearing cartridges, and do not require periodic lubrication.

If desired, the bearings may be re-lubricated using the grease-fitting that is provided in the bearing housing. Once grease is added, the bearing must be re-lubricated every six months with a lithium based ball bearing grease or compatible grease conforming to NLG1 Grade 2 consistency.

While the pulley is rotating, add the grease slowly and sparingly until a slight showing of grease forms around the seals. Do not over lubricate. Too much grease may damage the seals. If a bearing is over greased, remove the fitting to allow the excess grease to escape. Replace the fitting and wipe clean before putting the conveyor back into operation.

Maintenance Procedures

Take-up Sheave Misalignment

Excessive wear or breaking of the V-belt may indicate that the take-up sheave is misaligned. One possible cause of misalignment is incorrect assembly of the take-up sheave washers.

The take-up sheave may be incorrectly assembled with the 3/4" split lock washer mounted outside the take-up assembly. Reposition the 3/4" split lock washer between the sheave spacer and the take-up plate (See Figure H - 1).

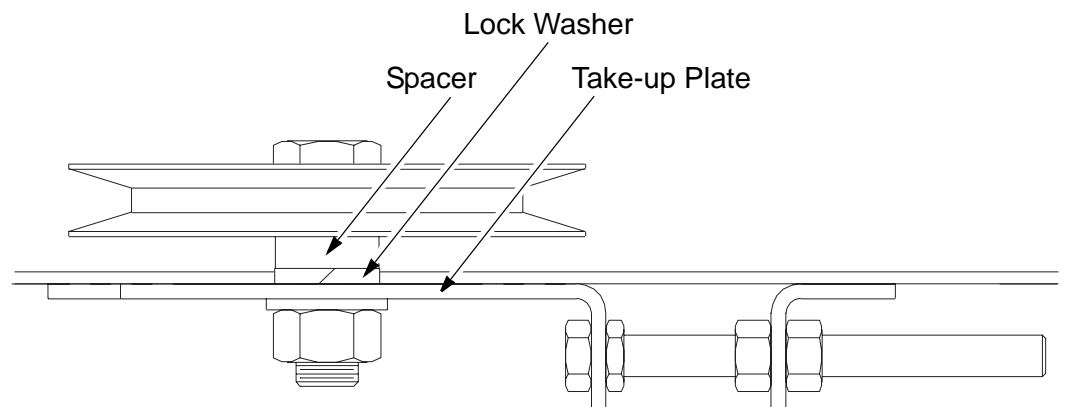


Figure H - 1 Take-up Sheave Assembly

Troubleshooting

Basic troubleshooting provisions are outlined in Table H.2 below. For troubleshooting the specific conveyor system installed, always check the maintenance information.

WARNING: Do not clear jams or reach into any unit before first turning off the equipment power source(s) and making certain that all moving parts are fully stopped. To avoid personal injury or equipment damage, lockout and tagout the conveyor operation control(s) before attempting to correct any malfunction.

Table H 2: Basic Troubleshooting Problems and Solutions

Problem	Cause	Solution
Conveyor does not start.	Electrical power shut off or control circuit not energized	Check that the system control panels are energized.
	System control devices out of adjustment or defective.	Adjust or replace.
	Emergency stop devices activated.	Reset the emergency stop devices.
	Motor overload block open.	Check conveyor drive system and overload sizing before resetting.
Conveyor shuts off.	Photo or other control device actuated or defective.	Conveyor accumulated or control device obstructed.
	Power or component failure at system control center.	Consult vendor manuals.
	Emergency stop actuated.	Correct condition and reset according to control logic.
	Motor overloaded.	Check for cause; also check motor and overload sizes.
Conveyor rollers not turning.	Roller obstruction.	Remove obstruction and inspect roller for damage.
	Roller bearing failure.	Replace roller and bearings.
	Pressure sheaves not adjusted.	Adjust.
Gear reducer unusually noisy.	Mounting bolts loose.	Retighten mounting bolts.
	Unit misaligned or defective.	Realign or replace.
Motor runs hot or overheats.	Overload.	Check for binding or jams.
	High or lower power voltage.	Check motor nameplate for proper voltage and test line voltage.

Problem	Cause	Solution
Excessive wear or breaking of V-belt.	Shock loads or heavy starting loads.	Correct V-belt tension and verify drive components are working properly.
	Frozen sheave or obstruction.	Replace or remove.
	V-belt slips.	Adjust take-up to increase belt tension.
	Sheave out of alignment.	Realign.
Package hesitates or stops.	Insufficient drive on rollers.	Adjust pressure sheaves.
	V-belt slipping on drive sheave.	Adjust take-up to increase belt tension.

SECTION I: PARTS IDENTIFICATION

General Information

The purpose of this section is to identify the critical replacement parts required for a solid preventive maintenance program and to minimize the chances for extended down time.

The following pages illustrate the location of these recommended spare parts as they apply to each particular unit. Keep in mind that these illustrations only apply to the standard product line.

Note: "O" rings are used on the last three rollers on each end of all curves and spurs. The "O" rings are listed in the spare parts list and are not shown on each drawing.

V-Belt Curves

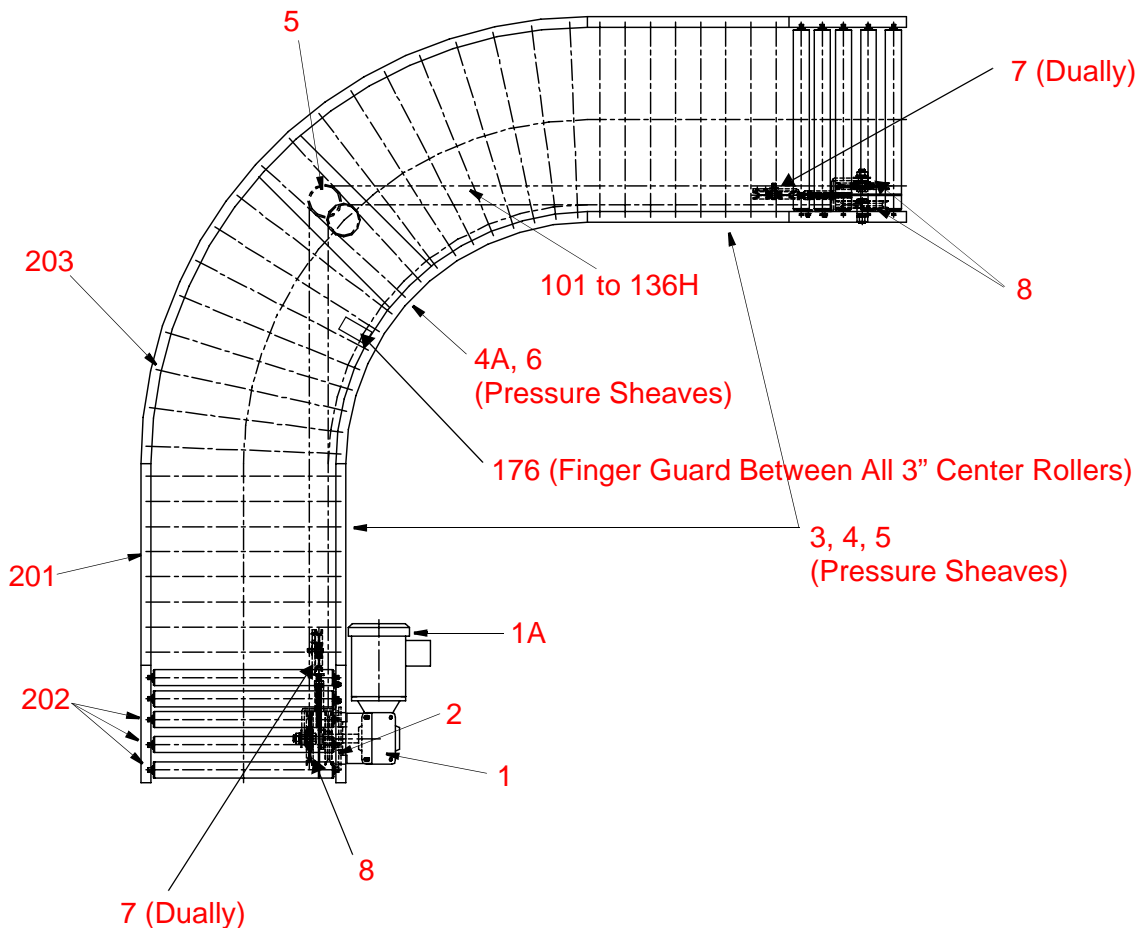


Figure I - 1 Style 5P - 90° Curve (2" and 3" Centers)

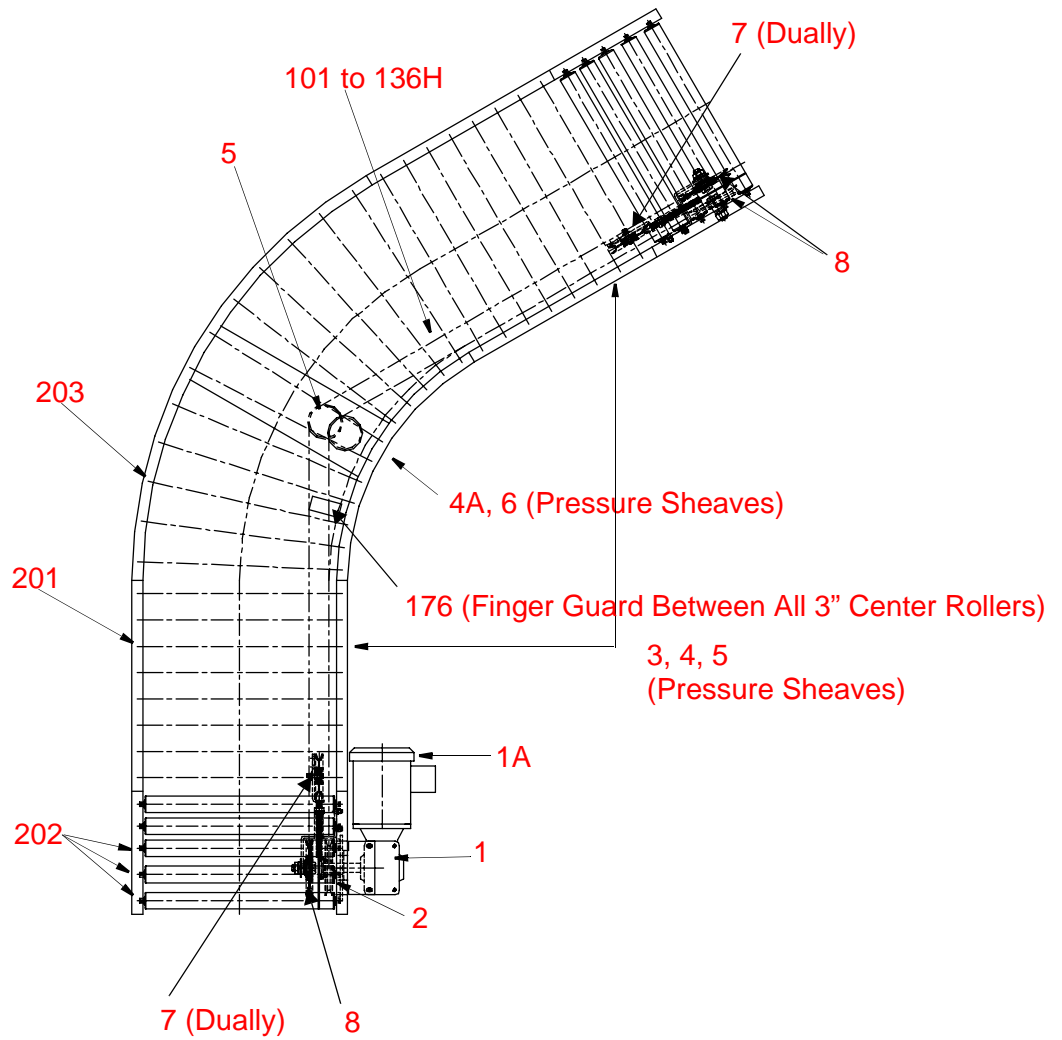


Figure I - 2 Style 6P - 60° Curve (2" and 3" Centers)

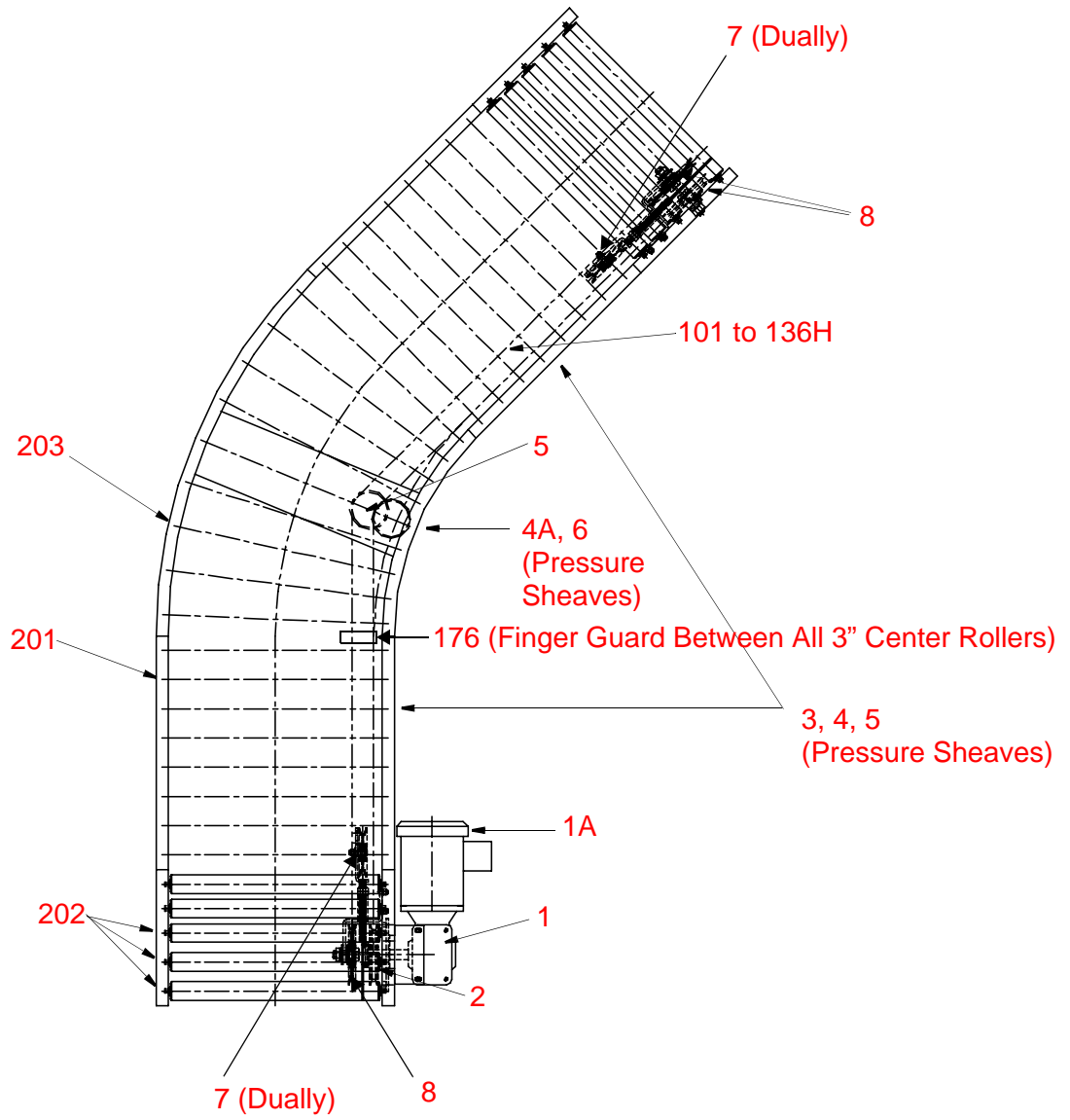


Figure I - 3 Style 7P - 45° Curve (2" and 3" Centers)

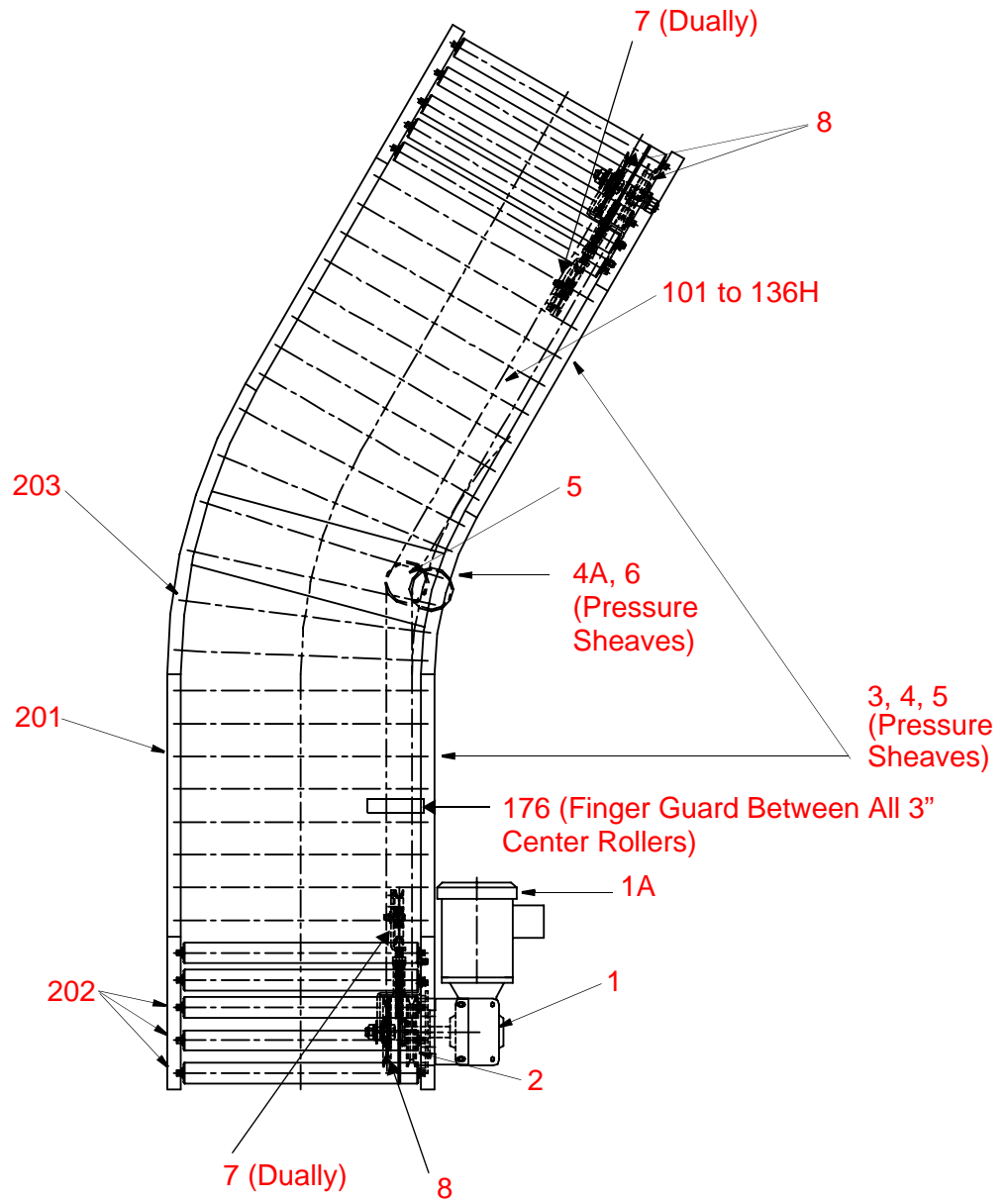


Figure I - 4 Style 8P - 30° Curve (2" and 3" Centers)

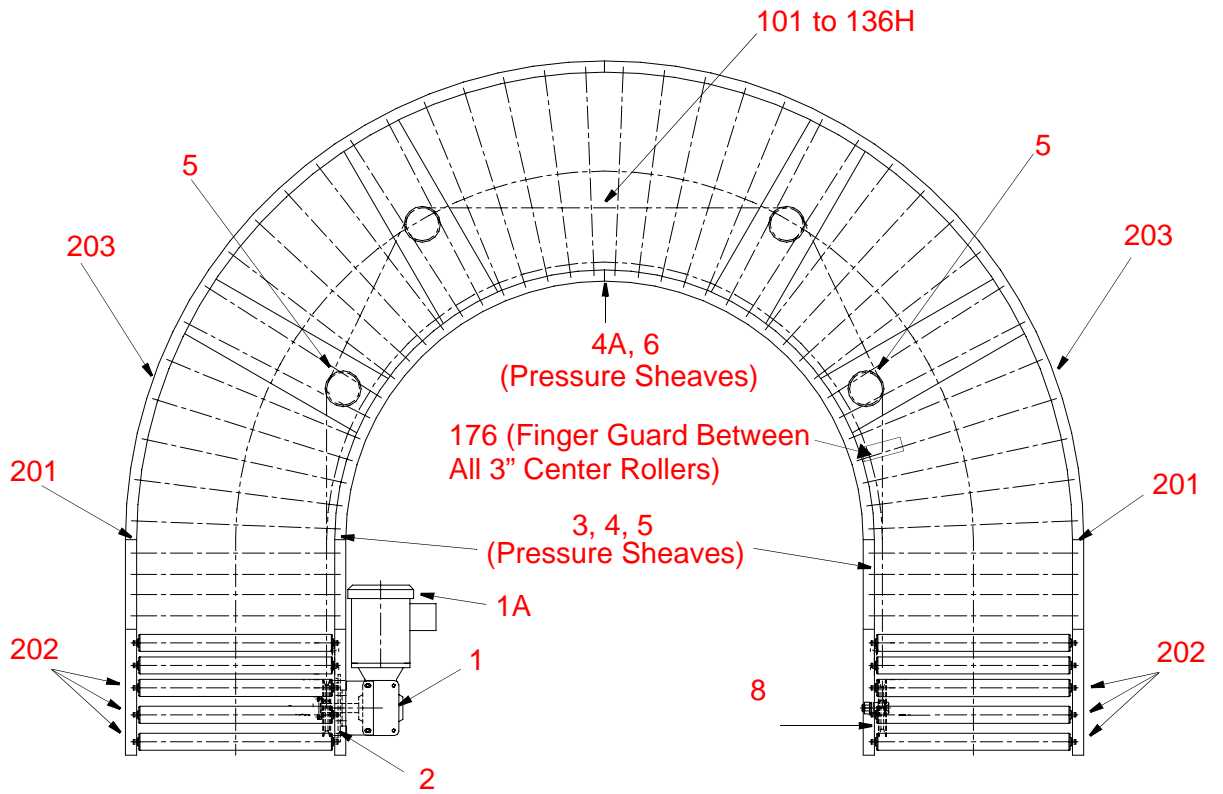


Figure I - 5 Style 9P - 180° Curve (Right Hand Shown) (2" and 3" Centers)

Straight Junctions

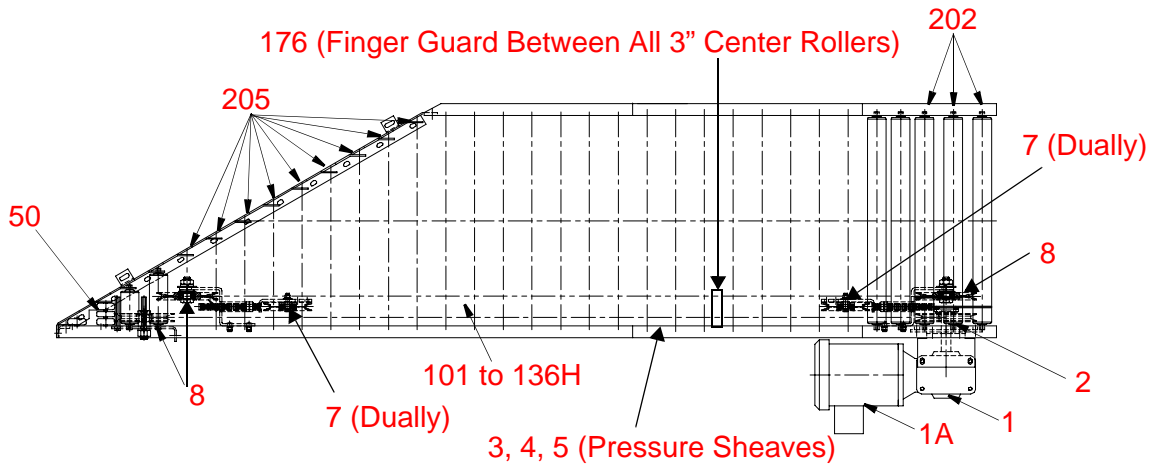


Figure I - 6 Style 14P - 30° Straight Junction (2" and 3" Centers)

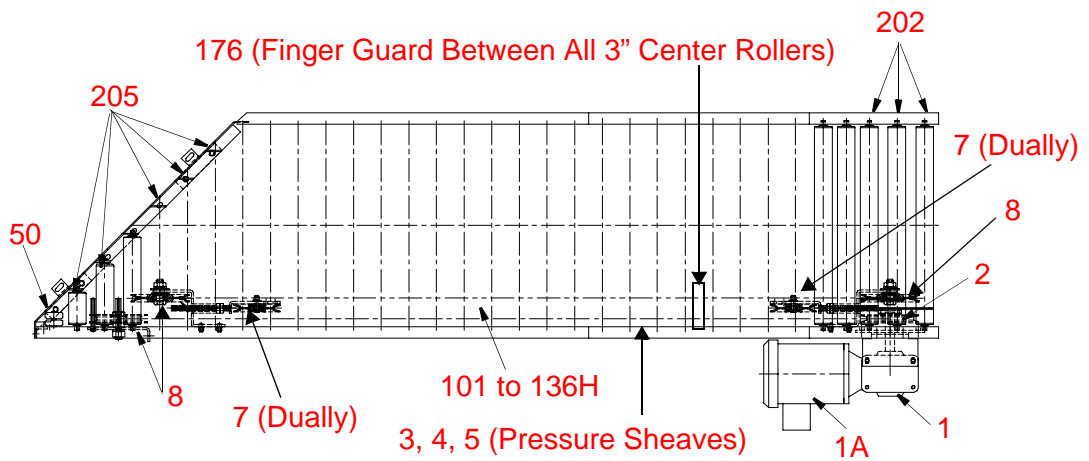


Figure I - 7 Style 18P - 45° Straight Junction (2" and 3" Centers)

Curve Junctions

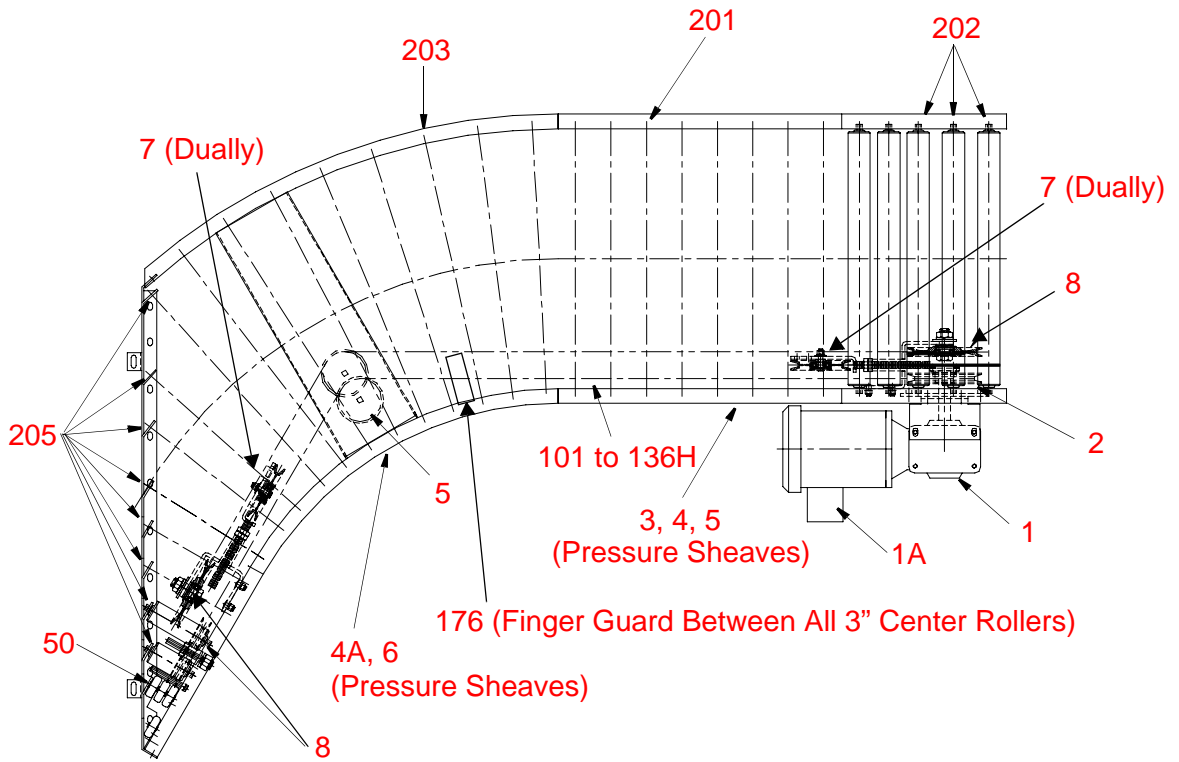


Figure I - 8 Style 21P - 90° Curve Junction (2" and 3" Centers)

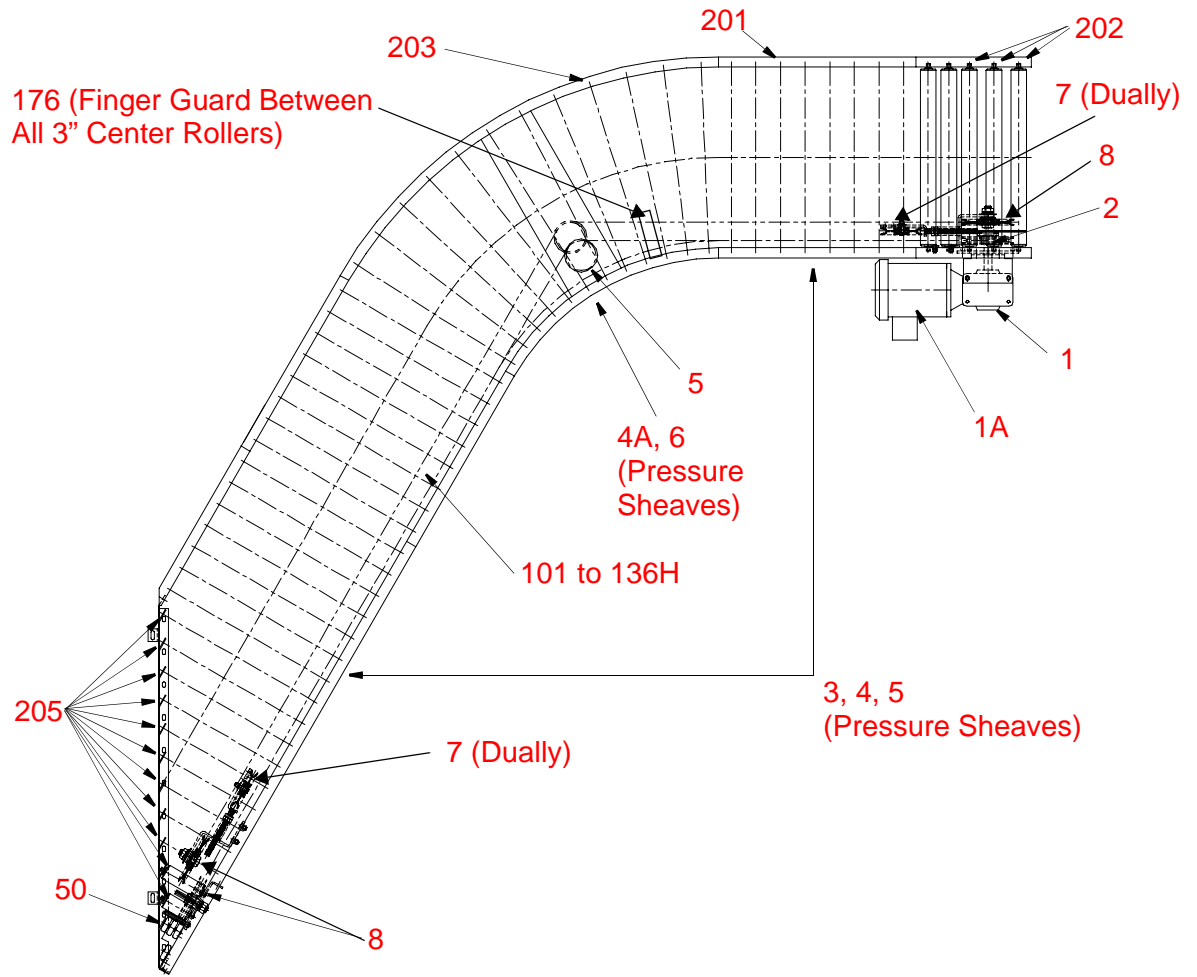


Figure I - 9 Style 15P - 30° Junction with 60° Curve (Left Hand Shown) (2" and 3" Centers)

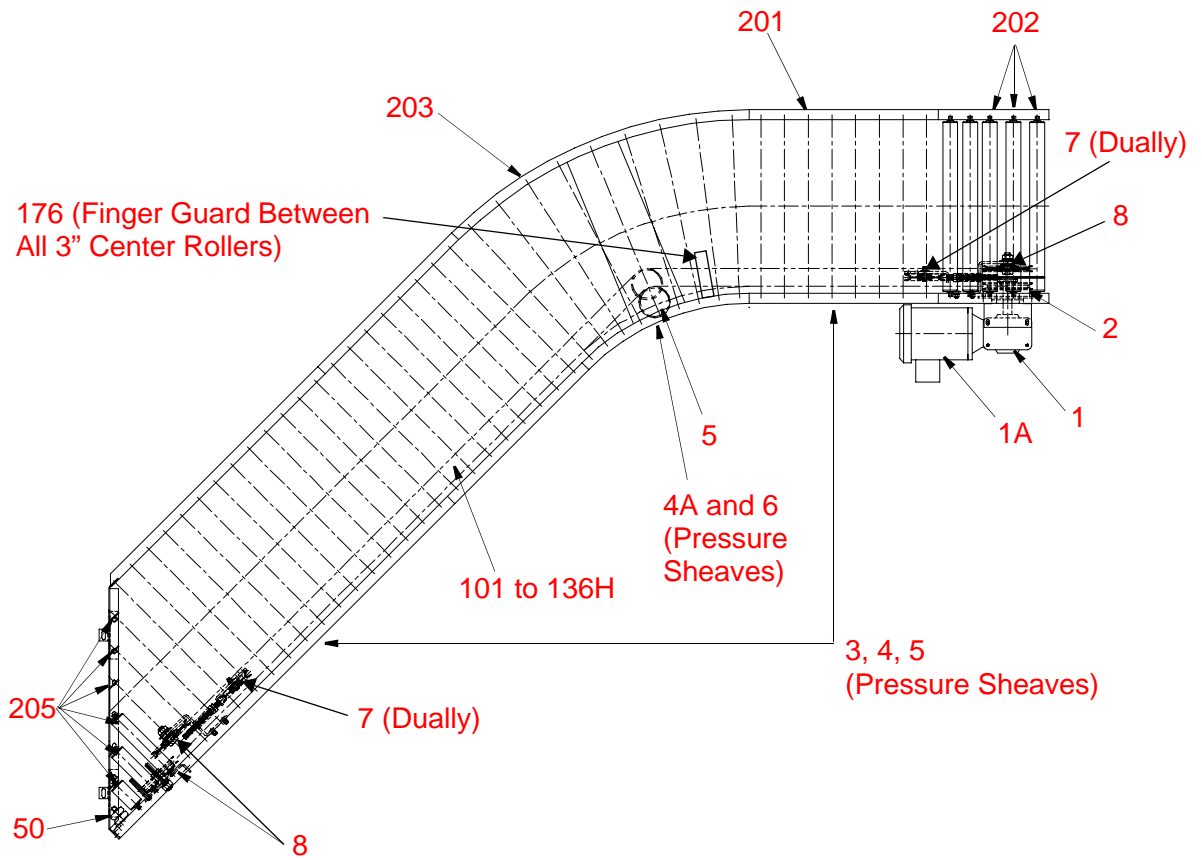


Figure I - 10 Style 19P - 45° Junction with 45° Curve (Left Hand Shown)(2" and 3" Centers)

Skewed Live Roller

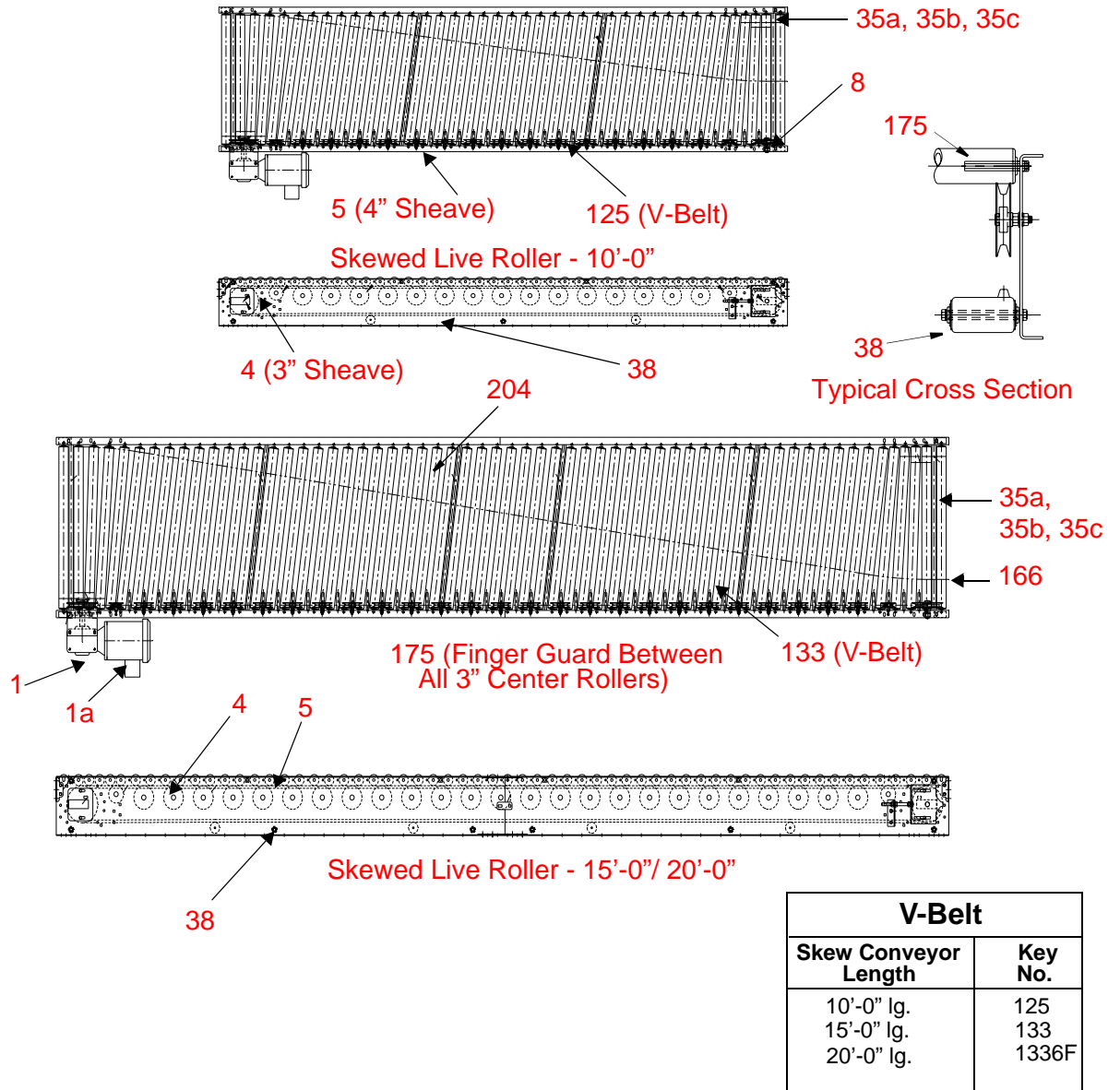


Figure I - 11 Skewed Live Roller (3" Centers Only)

Take-Up - Merge, Diverge, Crossover

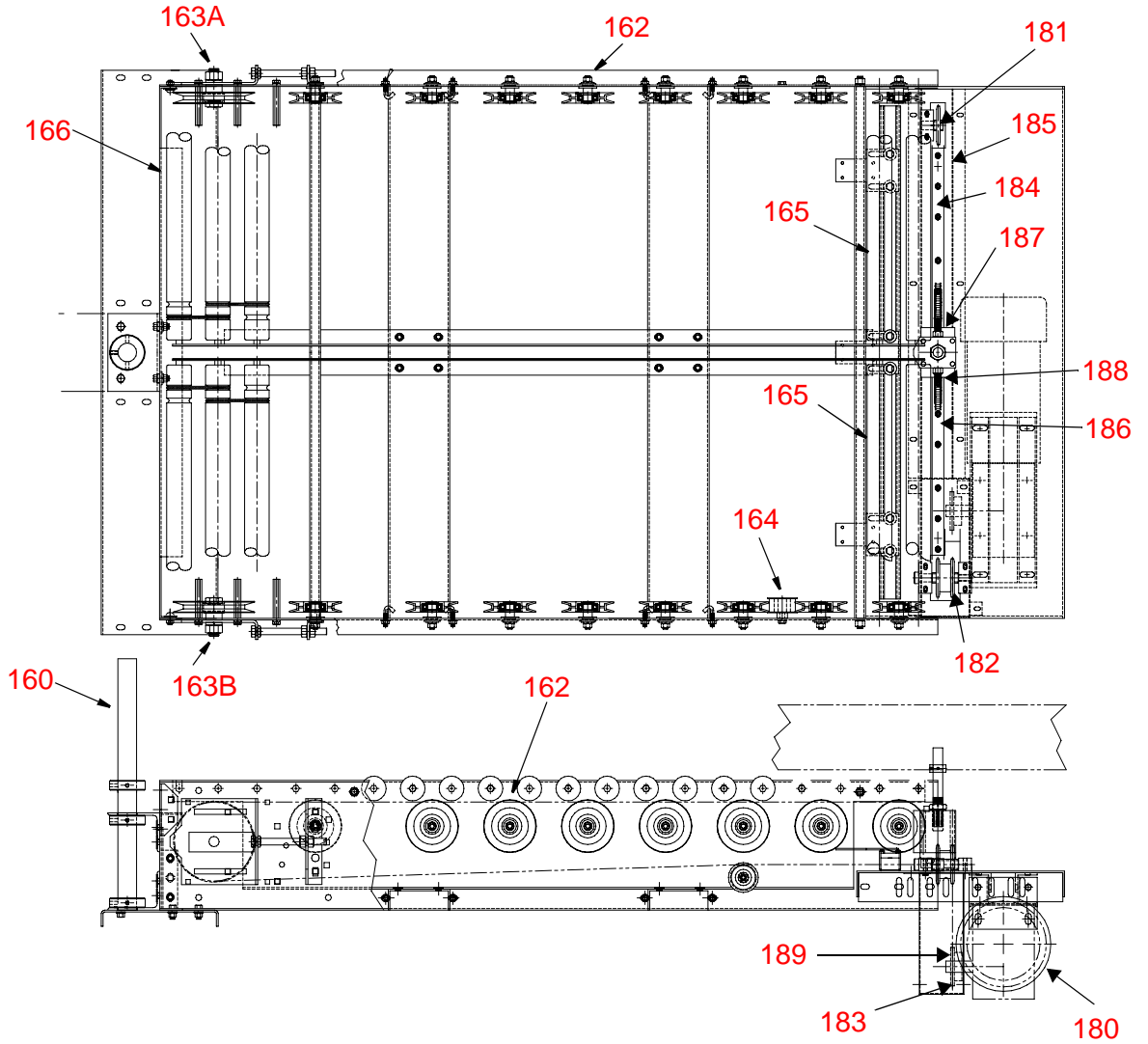


Figure I - 12 Take-Up Section (3" Centers Only)

Intermediate Section - Merge, Diverge, Crossover

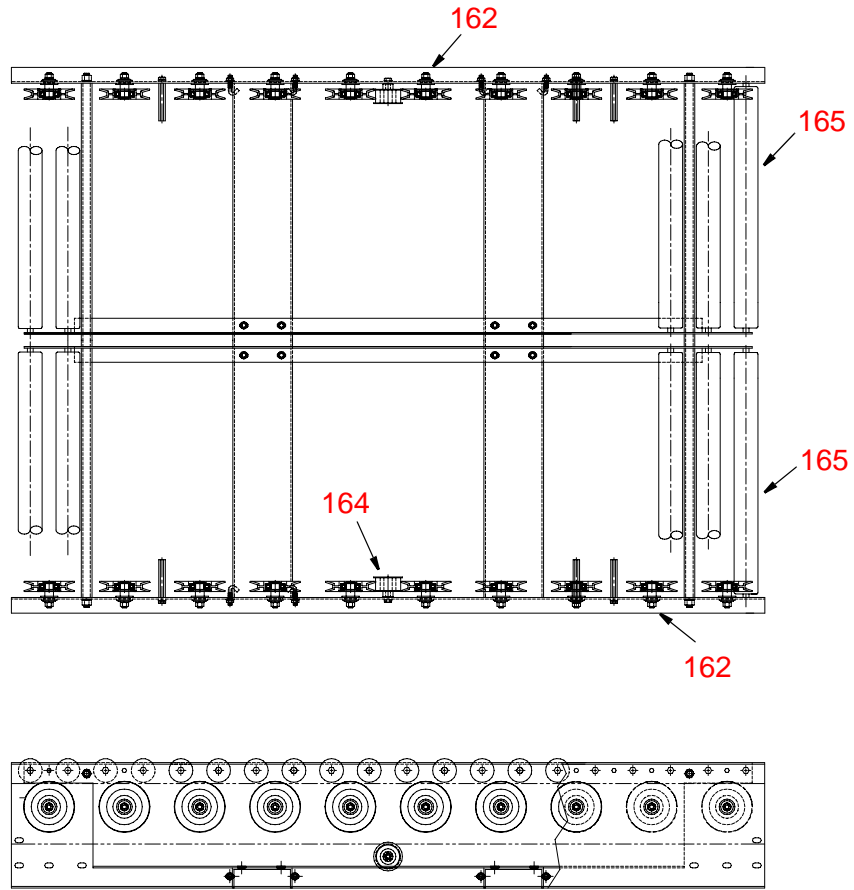
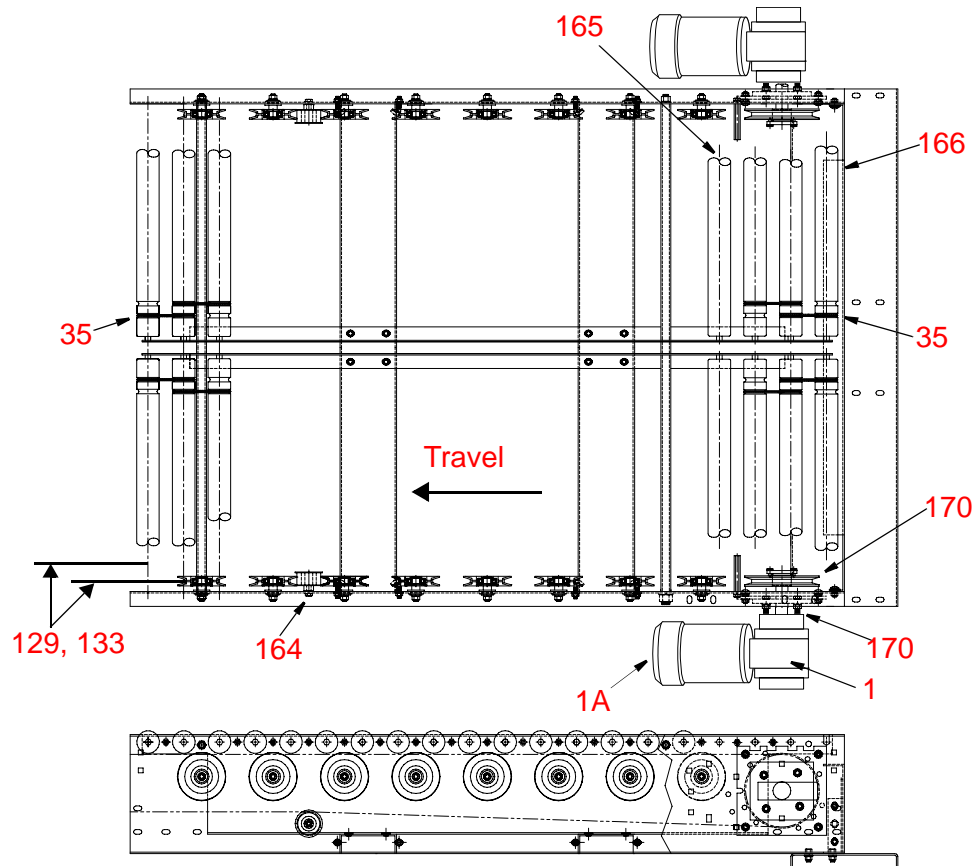


Figure I - 13 Intermediate Section - 5'-0" (3" Centers Only)

Drive Section - Merge, Diverge, Crossover



V-Belt	
Length	Key No.
10'-0" lg.	125
15'-0" lg.	133

Figure I - 14 Drive Section - 5'-0" (3" Centers Only)

Curves with Power Transfer

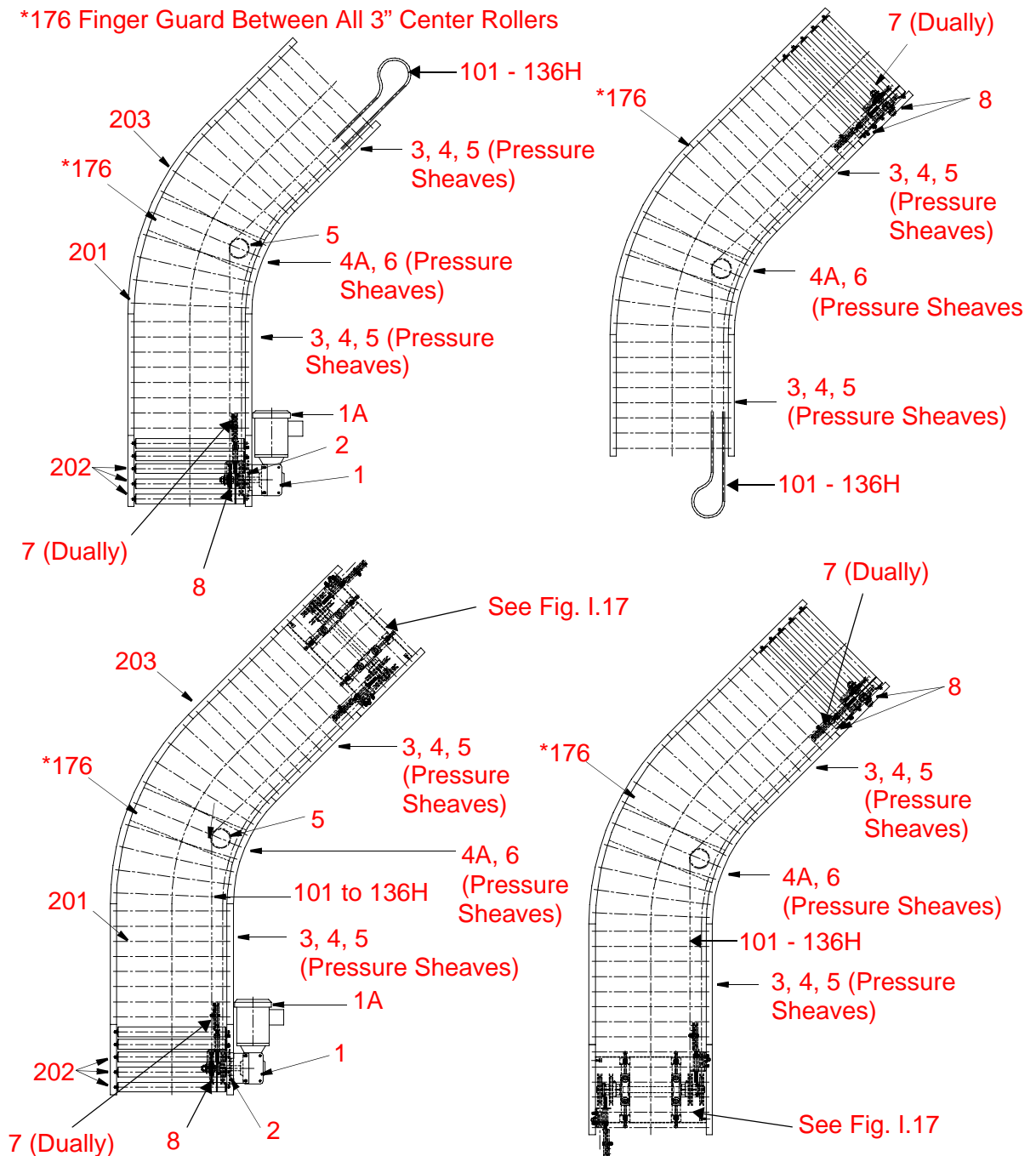


Figure I - 15 Curves with Power Transfer for "S" Turns and Parallel Junctions (2" and 3" Centers)

Dually Take-Up

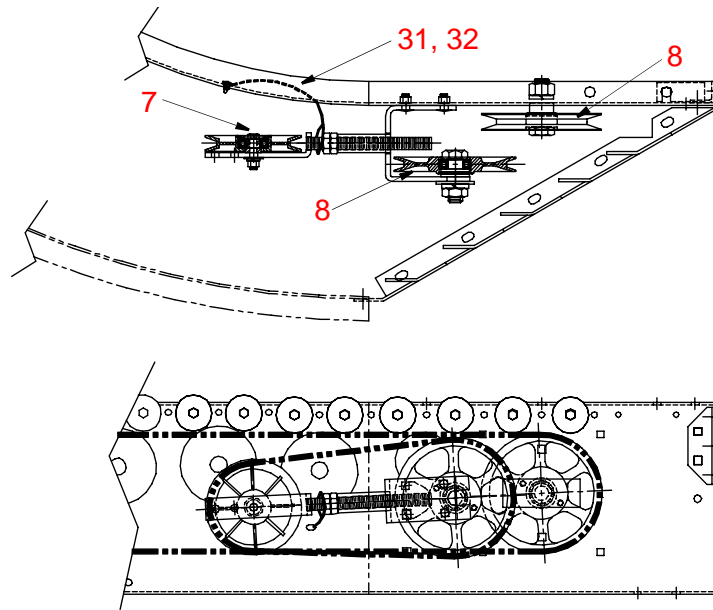


Figure I - 16 Dually Take-Up

Power Transfer

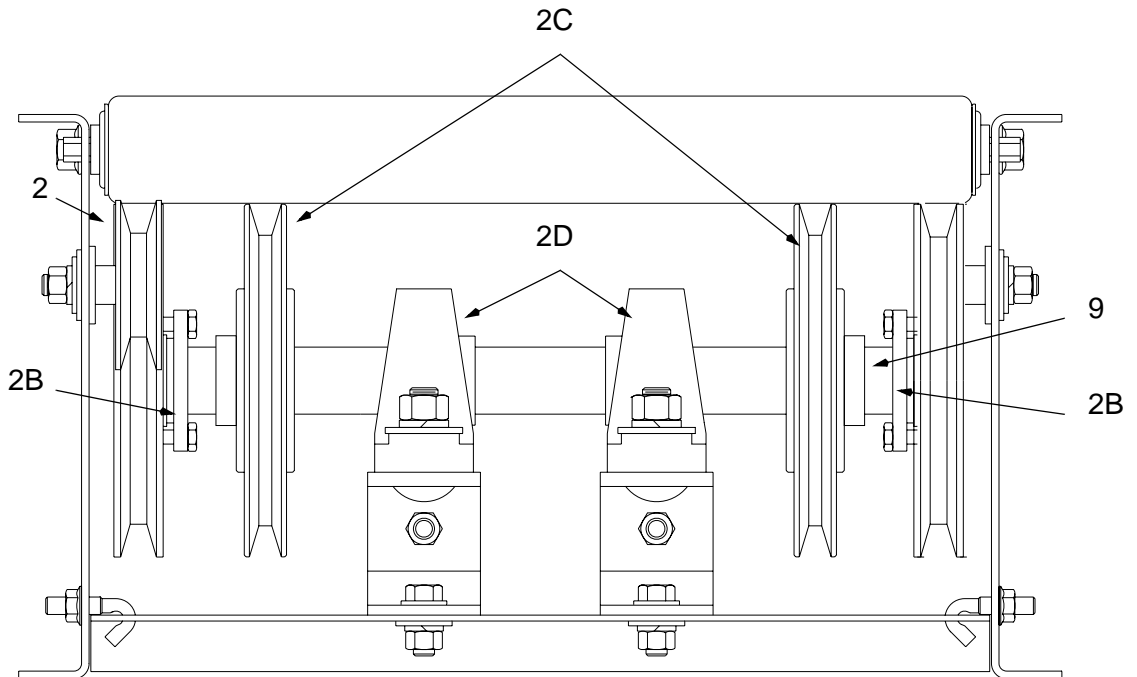


Figure I - 17 Power Transfer

PTOs

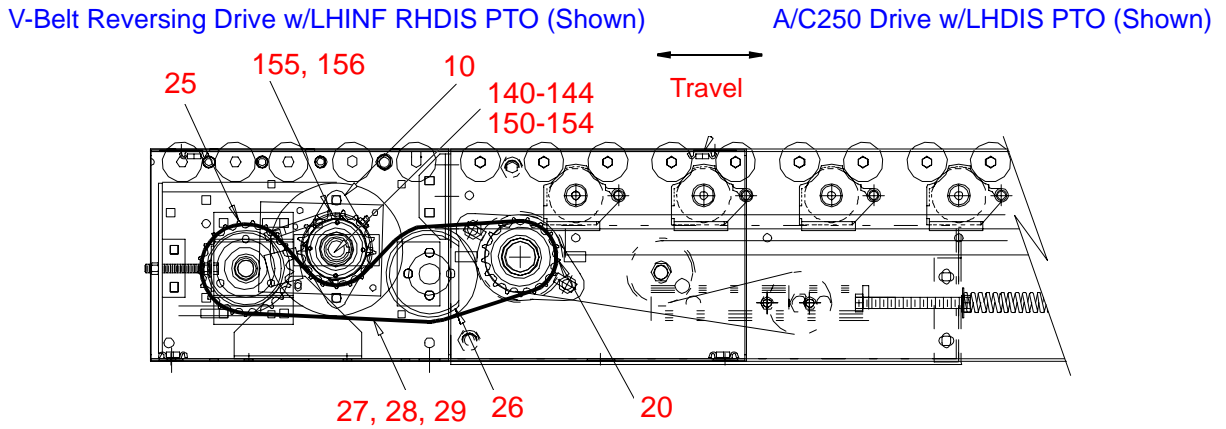


Figure I - 18 V-Belt with Spring Wrap Clutch Driven by ACQ250

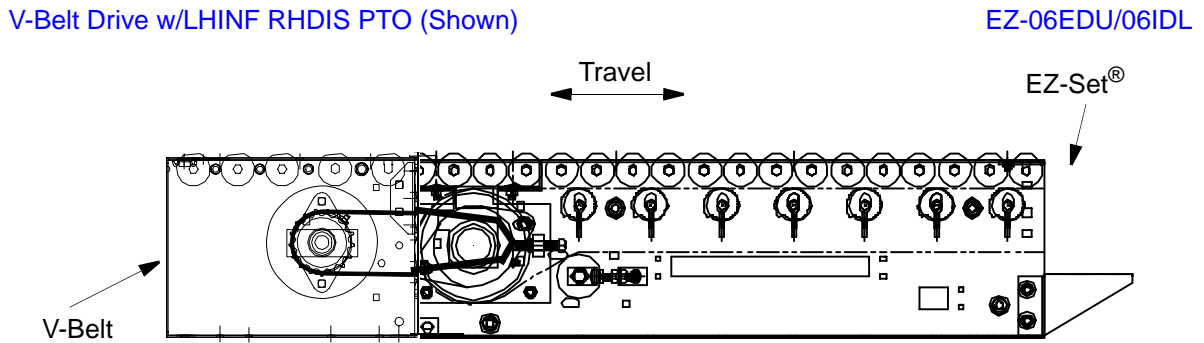


Figure I - 19 V-Belt Driven by EZ-SET®

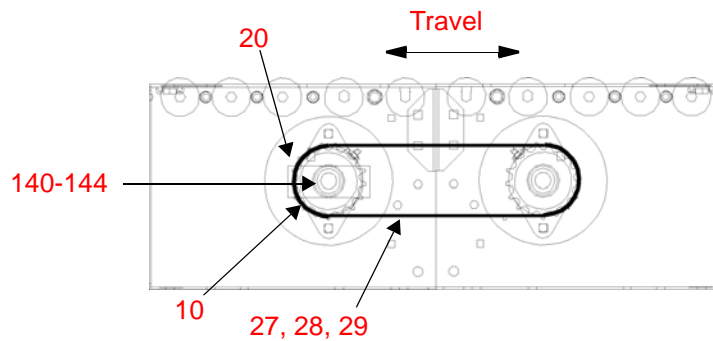


Figure I - 20 V-Belt Drive to V-Belt PTO

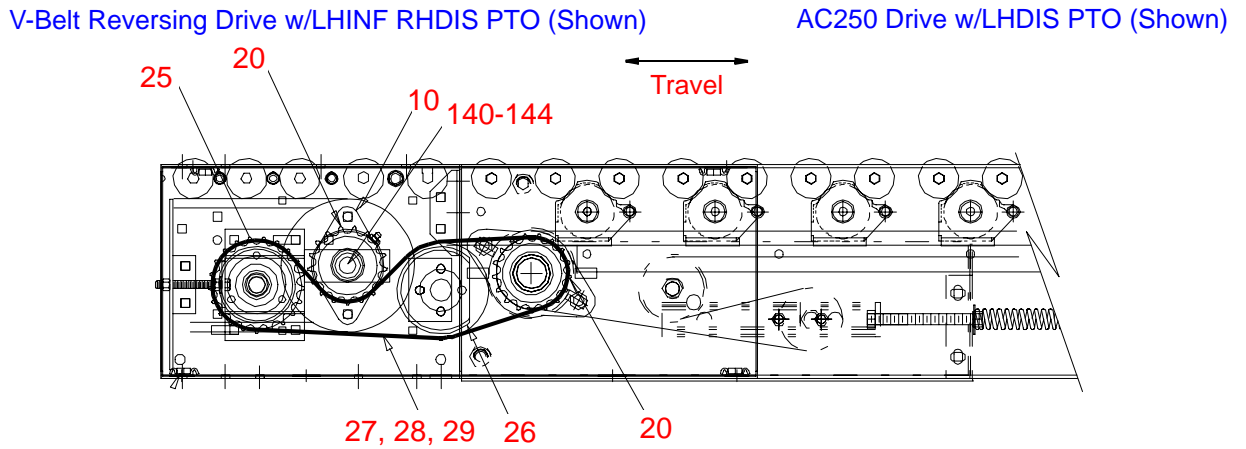


Figure I - 21 V-Belt Driven by ACQ250

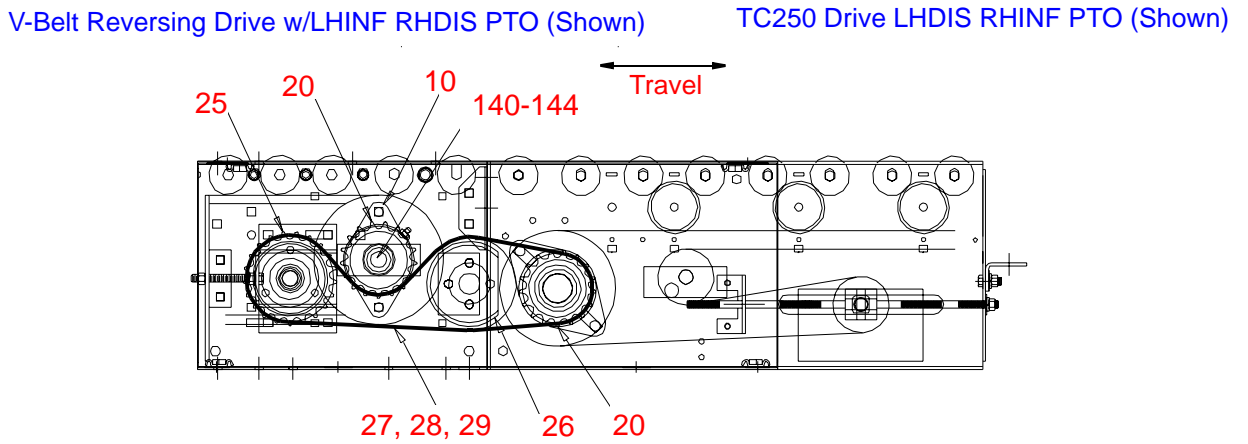


Figure I - 22 V-Belt Driven by TC250

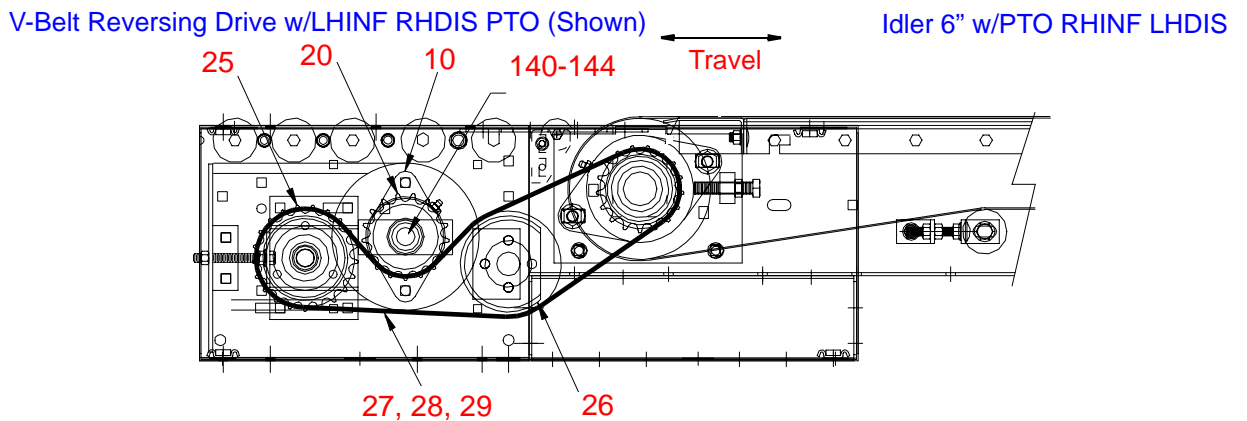


Figure I - 23 V-Belt Driven by Belt 6" Idler

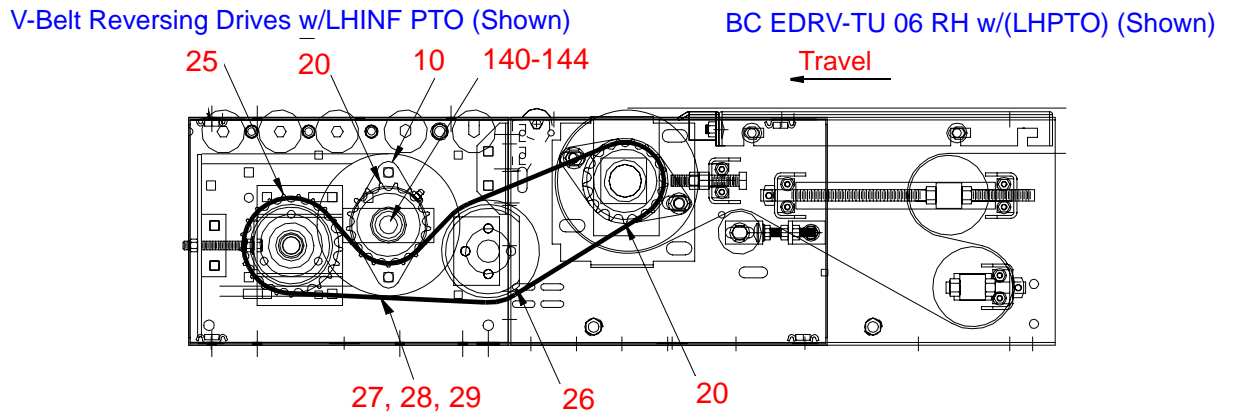


Figure I - 24 V-Belt Driven by Belt EDU Series 600

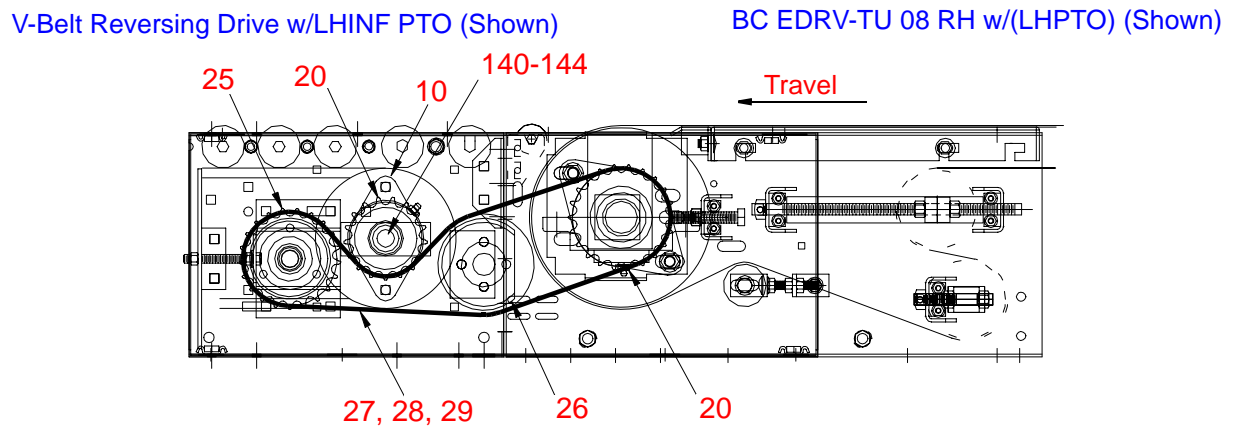


Figure I - 25 V-Belt Driven by Belt EDU Series 800

Parts Not Related To Width

Key No.	Part Description	Part Number
1	Power Unit (Reducer)	See 8700-1
1A	Power Unit (Motor) 230-460V/3Ph/60Hz	See 8700-1
2	Sheave, Drive - BK-67H. 6.1" P.D.	230912
2a	Bushing, "H", 1" Bore (Reducer Shaft)	2108101
2b	Bushing, "H", 1-3/16" Bore (PTO Shaft)	2108102
2c	Sheave, Idler	540072
2d	P-Block, 1-3/16"	400340
V-Belt Sheaves (Curves, Spurs, Skew, Merge/Diverge/Crossover)		
3	2" Diameter Flat Face Sheave Assembly	568610
4	3" Diameter V-Groove Sheave Assembly	568609
4A	3" Diameter Single Flange Sheave Assembly	568606
5	4" Diameter V-Groove Sheave Assembly	568602
6	4" Diameter Single Flange Sheave Assembly	568604
7	5" Diameter V-Groove 2/3/8" ID Bore	540773
8	6" Diameter V-Groove w/3/4" ID Bore	230905
9	PT Shaft 1-3/16" 16" W	692630
	PT Shaft 1-3/16" 22" W	692631
	PT Shaft 1-3/16" 28" W	692632
	PT Shaft 1-3/16" 34" W	692633
	PT Shaft 1-3/16" 40" W	692634

Key No.	Part Description	Part Number
10	Bearing, 2-Bolt Flange, 1-3/16" Bore (PTO)	400985
20	Sprocket - 50BTL17T - BC-IU (Ref. 20a)	1225017
20a	Bushing, #1610, 1-3/16" Bore (VB-PTO Shaft)	2155013
25	50B - 21T Idler Sprocket	745821
26	UHMW Chain Guide	730606
27	Chain - No. RC-50 (Specify Length)	200970
28	Chain Coupler/Straight - RC-50	200040
29	Chain Coupler/Offset - RC-50	200260
31	Take-Up Lanyard	000921
32	Press Lock Rivet	220842
35a	10-Ring - Short 10-1/4" lg.	000002
35b	10-Ring - Short 8-3/4", lg., 22", 34"W	000042
35c	O-Ring - Short 8-11/16" lg., 16", 28", 40" W	000006
36	O-Ring - Long 15-5/8" lg.	000004
38	Guide Roller Assembly	568601
50	Skatewheel, 1-1 5/16" dia., Zinc Coated	340420
101	V-Belt, BP-73	2412073
102	V-Belt, BP-80	2403080
102A	V-Belt, BP-85	2403085
103	V-Belt, BP-90	2403090
103A	V-Belt, BP-101	2403101
104	V-Belt, BP-108	2412108
105	V-Belt, BP-1 12	2403084
106	V-Belt, BP-1 16	2412117
107	V-Belt, BP-120	2403120
108	V-Belt, BP-124	2403124
109	V-Belt, BP-126	2403126
110	V-Belt, BP-128	2403128
111	V-Belt, BP-133	2403133
112	V-Belt, BP-1 36	2403136
113	V-Belt, BP-140	2403140
114	V-Belt , BP-1 44	2403144
115	V-Belt, BP-150	2412150
116	V-Belt, BP-154	2403154
117	V-Belt, BP-158	2403158
118	V-Belt, BP-1 62	2403161
119	V-Belt, BP-173	2403173
120	V-Belt, BP-1 80	2403174

Key No.	Part Description	Part Number
121	V-Belt, BP-191	2412191
122	V-Belt, BP-195	2403195
123	V-Belt, BP-210	2403210
124	V-Belt, BP-225	2412225
125	V-Belt, BP-240	2412240
126	V-Belt, BP-255	2412248
127	V-Belt, BP-270	2403270
128	V-Belt, BP-285	2403275
129	V-Belt, BP-300	2412249
130	V-Belt, BP-315	2402315
131	V-Belt, BP 330	2403330
132	V-Belt, BP 345	2403345
133	V-Belt, BP-360	2403360
134	V-Belt, BP-375	2403375
135	V-Belt, BP-390	2403390
136	V-Belt, BP-405	2403405
136A	V-Belt, BP-420	2403420
136B	V-Belt, BP-430	2403430
136C	V-Belt, BP-445	2403445
136D	V-Belt, BP-460	2403460
136E	V-Belt, BP-470	2403470
136F	V-Belt, BP-480	2403480
136G	V-Belt, BP-490	2403490
136H	V-Belt, BP-500	2403500
140	VB PTO Drive Shaft 1-3/16 x 18" Lg W=16	737620
141	VB PTO Drive Shaft 1-3/16 x 24" Lg W=22	737621
142	VB PTO Drive Shaft 1-3/16 x 30" Lg W=28	737622
143	VB PTO Drive Shaft 1-3/16 x 36" Lg W=30	737623
144	VB PTO Drive Shaft 1-3/16 x 42" Lg W=40	737624
150	VB PTO Drive Shaft 1-3/16 x 21.5" Lg W=16	737511
151	VB PTO Drive Shaft 1-3/16 x 27.5" Lg W=22	737512
152	VB PTO Drive Shaft 1-3/16 x 33.5" Lg W=28	737513
153	VB PTO Drive Shaft 1-3/16 x 39.5" Lg W=30	737514
154	VB PTO Drive Shaft 1-3/16 x 45.5" Lg W=40	737515
155	Clutch Clockwise Wrap Spring #50 (For Right Hand) Assembly	300072
156	Clutch Counterclockwise Wrap Spring #50 (For Left Hand) Assembly	300074
157	Sprocket H50A17 1-3/4" Bore PTO (Use with 155-156)	745823
160	I.D. Shaft 1-7/16 x 19-3/8 CR	690161
163A	Take-Up Assembly (right Hand)	575563
163B	Take-Up Assembly (Left Hand)	575564
164	Guide Roller Assembly	2300432
165	Roller, Carrier, 1.9 w/o Grooves	See Page I-23
166	Roller, Carrier, 1.9 w/2 Grooves	See Page I-23
175	Guard Finger, Plastic 1/2" dia. x 3.125" (Skew Only)	737440
176	Guard Finger, Plastic 1/2" dia. x 4.125"	732507

Key No.	Part Description	Part Number
Merge/Diverge/Crossover Conveyor - Diverter Assembly		Part Number
180A	Reducer RE175ES 60:1 56CLI	810766
180B	Motor 1/2 1800 TE 56C	330601
180C	Brake Kit RE Assembly 3#	330908
181	Sprocket ID HB40A17 x 5/8 BR	742932
182	L/C Divert Drive Sprocket Assembly	730096
183	Torque Limiter Module	743215
184A	SKF LLB 25TA B1 "W" = 53"	736867
184B	SKF LLB 25TA B1 "W" = 65"	736868
184C	SKF LLB 25TA B1 "W" = 77"	736869
184D	SKF LLB 25TA B1 "W" = 89"	736867
185	Chain Guide Flat UHMW	730093
186	Chain RC-40	200551
187	Chain Coupler RC-40	200020
188	Link Offset RC-40	200240
189	Sprocket for Torque Limiter Assembly	743217

Key No.		Conveyor Width "W"					
		16"	22"	28"	34"	40"	
Carrier Rollers - Merge/Diverge/Crossover Conveyor - Figure I-12, I-13, and I-14							
165*	1.9" Dia. Roller, Carrier, w/o Grooves						
	GH Bearings						
	RLR G196 GH P 01 19.88 NC	7496392	-	-	-	-	
	RLR G196 GH P 01 25.88 NC	-	7496487	-	-	-	
	RLR G196 GH P 01 31.88 NC	-	-	7496570	-	-	
	RLR G196 GH P 01 37.88 NC	-	-	-	7496633	-	
	RLR G196 GH P 01 43.88 NC	-	-	-	-	7496668	
	A1 Bearings						
	RLR G196 A1 P 01 19.88 NC	7491748	-	-	-	-	
	RLR G196 A1 P 01 25.88 NC	-	7502215	-	-	-	
	RLR G196 A1 P 01 31.88 NC	-	-	7491750	-	-	
	RLR G196 A1 P 01 37.88 NC	-	-	-	7491751	-	
	RLR G196 A1 P 01 43.88 NC	-	-	-	-	7491752	
	166*	1.9" Dia. Roller, w/2 Grooves					
		GH Bearings					
RLR G196 GH P 01 19.88 NC G2		7496395	-	-	-	-	
RLR G196 GH P 01 25.88 NC G2		-	7496490	-	-	-	
RLR G196 GH P 01 31.88 NC G2		-	-	7496573	-	-	
RLR G196 GH P 01 37.88 NC G2		-	-	-	7496634	-	
RLR G196 GH P 01 43.88 NC G2		-	-	-	-	7496669	
A1 Bearings							
RLR G196 A1 P 01 19.88 NC G2		7491753	-	-	-	-	
RLR G196 A1 P 01 25.88 NC G2		-	7491754	-	-	-	
RLR G196 A1 P 01 31.88 NC G2		-	-	7491755	-	-	
RLR G196 A1 P 01 37.88 NC G2		-	-	-	7491756	-	
RLR G196 A1 P 01 43.88 NC G2		-	-	-	-	7491757	

(*) See Roller Description Explanation on page I-28

Width Related Parts

Key No.	Description	Conveyor width "W" (inch)				
		16"	22"	28"	34"	40"
201*	1.9" Dia roller, Straight Carrier w/Spring-Loaded Axle					
	RLR G196 GH P 01 ____ NC	7017540	7017541	7017542	7017543	7017544
	RLR G196 A1 P 01 ____ NC	7015687	7015688	7015689	7015690	7015691
201**	1.9 Dia Roller, Straight Carrier, Fixed Axle w/Tapped Ends					
	ROLR G196GH-____ TAP AXLE	560860	560861	560862	560863	560864
	ROLR G196AB-____ TAP AXLE	560865	560866	560867	560868	560869
202*	1.9" Dia Roller, Straight Carrier w/Spring-Loaded Axle, (2) Grooves					
	RLR G196 GH P 11 ____ NC G2	7017545	7017546	7017547	7017548	7017549
	RLR G196 A1 P 11 ____ NC G2	7026848	7026849	7026850	7026851	7026852
203	2.5" Dia. Roller, Tapered Carrier w/Axle					
	No. G254, ABEC	502060	502061	502062	502063	502064
204*	1.9" Dia Skewed Carrier Roller w/Spring-Loaded Axle (Roller Width)					
	GH Bearings					
	RLR G196 GH P 01 16.13 NC	7496342	-	-	-	-
	RLR G196 GH P 01 22.13 NC	-	7496443	-	-	-
	RLR G196 GH P 01 28.19 NC	-	-	7496535	-	-
	RLR G196 GH P 01 34.25 NC	-	-	-	7496610	-
	RLR G196 GH P 01 40.31 NC	-	-	-	-	7496664
	A1 Bearings					
	RLR G196 A1 P 01 16.12 NC	7502268	-	-	-	-
	RLR G196 A1 P 01 22.12 NC	-	7502273	-	-	-
	RLR G196 A1 P 01 28.18 NC	-	-	7502280	-	-
	RLR G196 A1 P 01 34.25 NC	-	-	-	7502285	-
	RLR G196 A1 P 01 40.31 NC	-	-	-	-	7502289

(*) See Roller Description Explanation on page. I-28

Key No.	Width	Roller Description*	Bearing Suffix	
			GH	A1
205*	No. G196 - Junction Rollers			
	3-9/16"	RLR G196 __ N 03 03.56 NC	7496171	7501526
	3-7/8"	RLR G196 __ N03 03.88 NC	7496175	7506928
	4"	RLR G196 __ N 03 04.00 NC	7496177	7506975
	4-1/2"	RLR G196 __ N03 04.50 NC	7496184	7501570
	4-3/4"	RLR G196 __ N 03 04.75 NC	7496186	7404865
	5-5/8"	RLR G196 __ N 03 05.63 NC	7496195	7506929
	5-7/8"	RLR G196 __ N 03 05.88 NC	7496197	7501528
	6-1/2"	RLR G196 __ P 01 06.50 NC	7496202	7501572
	7"	RLR G196 __ P 01 07.00 NC	7496209	7506976
	7-1/16"	RLR G196 __ P 01 07.06 NC	7496212	7501530
	7-5/16"	RLR G196 __ P 01 07.31 NC	7496215	7506930
	8-3/16"	RLR G196 __ P 01 08.19 NC	7496225	7501532
	8-1/2"	RLR G196 __ P01 08.50 NC	7496228	6501574
	9-1/16"	RLR G196 __ P 01 09.06 NC	7496232	7502100
	9-3/8"	RLR G196 __ P 01 09.38 NC	7496237	7501534
	10"	RLR G196 __ P 01 10.00 NC	7496241	7506977
	10-1/2"	RLR G196 __ P 01 10.00 NC	7496250	7504787
	10-5/8"	RLR G196 __ P 01 10.63 NC	7496251	7042393
	10-3/4"	RLR G196 __ P 01 10.75 NC	7496253	7506969
	10-13/16"	RLR G196 __ P 01 10.81 NC	7496256	7504800
	10-7/8"	RLR G196 __ P 01 10.88 NC	7496258	7042394
	11-11/16"	RLR G196 __ P 01 11.69 NC	7496266	7501536
	12-1/4"	RLR G196 __ P 01 12.25 NC	7496271	7504788
	12-1/2"	RLR G196 __ P 01 1'2.50 NC	7496272	7506970
	12-3/4"	RLR G196 __ P 01 12.75 NC	7496275	7504892
	12-13/16"	RLR G196 __ P 01 12.81 NC	7496277	7501538
	13"	RLR G196 __ P 01 13.00 NC	7496280	7506978
	13-1/4"	RLR G196 __ P 01 13.25 NC	7496283	7504789
	13-5/16"	RLR G196 __ P 01 13.31 NC	7496285	7042395
	13-5/8"	RLR G196 __ P 01 13.63 NC	7496289	7502205
	14"	RLR G196 __ P 01 14.00 NC	7496293	7504819
	14-1/4"	RLR G196 __ P 01 14.25 NC	7496297	7042276
14-5/16"	RLR G196 __ P 01 14.31 NC	7496300	7501507	
14-1/2"	RLR G196 __ P 01 14.50 NC	7496303	7504820	
14-3/4"	RLR G196 __ P 01 15.13 NC	7496305	7502206	
15-1/8"	RLR G196 __ P 01 15.13 NC	7496317	7504823	
15-5/16"	RLR G196 __ P 01 15.31 NC	7496319	7504893	
15-7/16"	RLR G196 __ P 01 15.31 NC	7496323	7502207	
15-1/2"	RLR G196 __ P 01 15.50 NC	7496325	7504905	
15-3/4"	RLR G196 __ P 01 15.75 NC	7496327	7504790	
15-13/16"	RLR G196 __ P 01 15.81 NC	7496328	7491816	

Key No.	Width	Roller Description*	Bearing Suffix	
			GH	A1
205*	No. G196 - Junction Rollers (continued)			
	16-5/16"	RLR G196 __ P 01 16.31 NC	7496345	7501540
	16-3/8"	RLR G196 __ P 01 16.38 NC	7496345	7501540
	16-1/2"	RLR G196 __ P 01 16.50 NC	7496348	7504791
	17-7/16"	RLR G196 __ P 01 17.44 NC	7496355	7504792
	17-5/8"	RLR G196 __ P 01 17.63 NC	7496358	7502209
	17-3/4"	RLR G196 __ P 01 17.75 NC	7496360	7506966
	17-7/8"	RLR G196 __ P 01 17.88 NC	7496362	7506927
	18"	RLR G196 __ P 01 18.00 NC	7496363	7504895
	18-1/2"	RLR G196 __ P 01 18.50 NC	7496367	7501576
	18-5/8"	RLR G196 __ P 01 18.63 NC	7496368	7501542
	18-11/16"	RLR G196 __ P 01 18.69 NC	7496369	7502211
	19"	RLR G196 __ P 01 19.00 NC	7496377	7506971
	19-1/4"	RLR G196 __ P 01 19.25 NC	7496381	7504908
	19-7/16"	RLR G196 __ P 01 19.44 NC	7496383	7502102
	19-3/4"	RLR G196 __ P 01 19.75 NC	7496389	7504896
	20"	RLR G196 __ P 01 20.00 NC	7496396	7504827
	20-1/16"	RLR G196 __ P 01 20.06 NC	7496399	7502212
	20-3/16"	RLR G196 __ P 01 20.19 NC	7496153	7501908
	20-15/16"	RLR G196 __ P 01 20.31 NC	7496403	7502238
	20-1/2"	RLR G196 __ P 01 20.50 NC	7496405	7504828
	20-15/16"	RLR G196 __ P 01 20.94 NC	7496411	7504794
	21-1/8"	RLR G196 __ P 01 21.13 NC	7496420	7506884
	21-3/16"	RLR G196 __ P 01 21.19 NC	7496422	7502103
	21-5/8"	RLR G196 __ P 01 21.63 NC	7496427	7502213
	21-13/16"	RLR G196 __ P 01 21.81 NC	7496429	7491817
	22-1/16"	RLR G196 __ P 01 22.06 NC	7496442	7501544
	22-1/2"	RLR G196 __ P 01 22.50 NC	7496450	7504999
	22-15/16"	RLR G196 __ P 01 22.94 NC	7496455	7502104
	23"	RLR G196 __ P 01 23.00 NC	7496457	7504833
	23-1/4"	RLR G196 __ P 01 23.25 NC	7496459	7501546
	23-3/4"	RLR G196 __ P 01 23.75 NC	7496462	7502214
	24-3/8"	RLR G196 __ P 01 24.38 NC	7496467	7504796
	24-1/2"	RLR G196 __ P 01 24.50 NC	7496468	7504912
	24-5/8"	RLR G196 __ P 01 24.63 NC	7496470	7502105
	25"	RLR G196 __ P 01 25.00 NC	7496478	7506979
	25-1/8"	RLR G196 __ P 01 25.13 NC	7497499	7497498
	25-1/2"	RLR G196 __ P 01 25.50 NC	7496481	7501548
	25-7/8"	RLR G196 __ P 01 25.88 NC	7496487	7502215
	26"	RLR G196 __ P 01 26.00 NC	7496491	7504836
	26-3/16"	RLR G196 __ P 01 26.19 NC	7496495	7502216
	26-3/8"	RLR G196 __ P 01 26.38 NC	7496502	7042388

Key No.	Width	Roller Description*	Bearing Suffix	
			GH	A1
205*	No. G196 - Junction Rollers (continued)			
	26-1/2"	RLR G196 __ P 01 26.50 NC	7496504	7501579
	26-11/16"	RLR G196 __ P 01 26.69 NC	7496505	7501550
	26-15/16"	RLR G196 __ P 01 26.94 NC	7496508	7502217
	27-13/16"	RLR G196 __ P 01 27.81 NC	7496521	7491818
	28-1/8"	RLR G196 __ P 01 28.13 NC	7496534	7504797
	28-3/16"	RLR G196 __ P 01 28.19 NC	7496535	7502280
	28-1/2"	RLR G196 __ P 01 28.50 NC	7496539	7501581
	29"	RLR G196 __ P 01 29.00 NC	7496543	7501552
	29-1/4"	RLR G196 __ P 01 29.25 NC	7496544	7504842
	29-13/16"	RLR G196 __ P 01 29.81 NC	7496548	7042389
	30-1/8"	RLR G196 __ P 01 30.13 NC	7496551	7501554
	30-1/2"	RLR G196 __ P 01 30.50 NC	7496554	7504917
	31"	RLR G196 __ P 01 31.00 NC	7496560	7506973
	31-5/16"	RLR G196 __ P 01 31.31 NC	7496563	7501556
	31-9/16"	RLR G196 __ P 01 31.56 NC	7496566	7042390
	31-3/4"	RLR G196 __ P 01 31.75 NC	7496568	7502218
	32-7/16"	RLR G196 __ P 01 32.44 NC	7496581	7501558
	32-1/2"	RLR G196 __ P 01 32.50 NC	7496582	7501584
	33"	RLR G196 __ P 01 33.00 NC	7496588	7504849
	33-5/16"	RLR G196 __ P 01 33.31 NC	7496597	7502109
	33-5/8"	RLR G196 __ P 01 33.63 NC	7496598	7501560
	34-3/8"	RLR G196 __ P 01 34.38 NC	7496612	7504851
	34-1/2"	RLR G196 __ P 01 34.50 NC	7496614	7501587
	34-3/4"	RLR G196 __ P 01 34.75 NC	7496615	7501562
	35-1/16"	RLR G196 __ P 01 35.06 NC	7496616	7502110
	35-15/16"	RLR G196 __ P 01 35.94 NC	7496617	7502219
	36-1/2"	RLR G196 __ P 01 36.50 NC	7496623	7501588
	36-3/4"	RLR G196 __ P 01 36.75 NC	7496624	7042391
	37"	RLR G196 __ P 01 37.00 NC	7496627	7506974
37-1/16"	RLR G196 __ P 01 37.06 NC	7496629	7501564	
38-1/4"	RLR G196 __ P 01 38.25 NC	7496638	7501566	
38-1/2"	RLR G196 __ P 01 38.50 NC	7496642	7042392	
39-3/8"	RLR G196 __ P 01 39.38 NC	7496654	7501568	

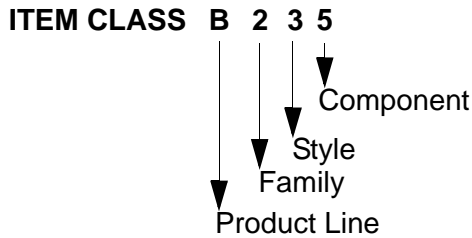
* See Roller Description Explanation on pg I-28

(Example) RLR G196 GH P 01 . . . NC G2

- G2 = (If Required) Two (2) Grooves (A=3", B=2")
- NC = No Cover
- . . . = Conveyor Width "W"
- 01 = Spring-Loaded Axle; Fixed Roller w/o Grooves
- 05 = Non Spring-Loaded Axle, Threaded End, Roller w/o Grooves
- 11 = Spring-Loaded Axle, Roller w/2 Grooves
- P = Plain Steel Axle
- N = NO Axle (W = 6.00 or less)
- A1 = (Bearing Type) ABEC Precision Bearing
- GH = (Bearing Type) Greased, Commercial Bearing
- 196 = (Roller Tube) 1.90" dia x 16 gage (.065" wall)
- G = Roller Tube Material/Finish) Galvanized Steel
- RLR = Roller

SECTION J: PRODUCT INDEX

Straight



- | | |
|--------------------|---------------------|
| (F1) INFDRV W/ROLR | (F6) MOTOR |
| (F2) INTERMEDIATE | (F7) NON-REQUIRED |
| (F3) DISID W/ROLR | (F8) BELT |
| (F4) PU RH | (F9) DUALLY TAKE-UP |
| (F5) PU LH | |

DESCRIPTION	DWG. NO.	16" W	22" W	28" W	34" W	40" W
V/B 01P HORIZ W__38" - 128"	18970 D	826686	826687	826688	826689	826690
V/B 01P HORIZ W__129" - 212"	18970 D	826691	826692	826693	826694	826695

Curves and Junctions (Straight) - Close Centers 2"

DESCRIPTION	DWG. NO.	16" W	22" W	28" W	34" W	40" W
V/B 01P HORIZ 2C W__38" - 128"	18970 D	826696	826697	826698	826699	826700
V/B 01P HORIZ 2C W__130" - 212"	18970 D	826701	826702	826703	826704	826705

See available extension lengths in back of this section.

Skew

ITEM CLASS B 2 3 6

(F1) INFDRV
 (F2) ROLLERS
 (F3) DISID

(F4) PU RH
 (F5) PU LH
 (F6) MOTOR

DESCRIPTION	DWG. NO.	16" W	22" W	28" W	34" W	40" W
VBS 01P RH SKEW 10-0/___	19694 D	826706	826707	826708	826709	826710
VBS 01P LH SKEW 10-0/___	19694 D	826711	826712	826713	826714	826715
VBS 01P RH SKEW 15-0/___	19695 D	NA	826716	826717	826718	826719
VBS 01P LH SKEW 15-0/___	19695 D	NA	826720	826721	826722	826723

(F1) INFID
 (F2) ROLLERS
 (F3) DISPTO

DESCRIPTION	DWG. NO.	16" W	22" W	28" W	34" W	40" W
VBS 01_ RH SKEW 10-0/___	19694 D	826018	826019	826020	826021	826022
VBS 01_ LH SKEW 10-0/___	19694 D	826023	826024	826025	826026	826027
VBS 01_ RH SKEW 15-0/___	19695 D	NA	826028	826029	826030	826031
VBS 01_ LH SKEW 15-0/___	19695 D	NA	826032	826033	826034	826035

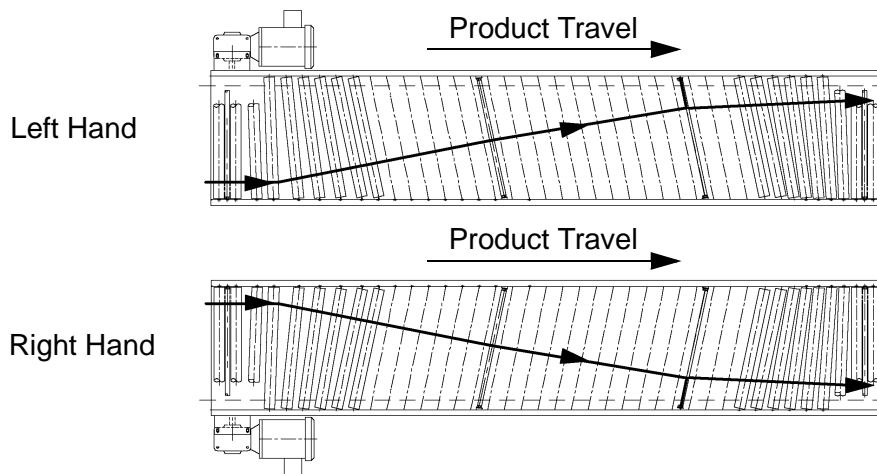


Figure J - 1 Skew

20'-0" Skew

ITEM CLASS B 2 3 6

(F1) INFDRV
(F2) ROLLERS
(F3) PU RH

(F4) PU LH
(F5) MOTOR

DESCRIPTION	DWG. NO.	34" W	40" W
VBS 01P RH SKEW 7-6 INF	19880 D	825980	825981
VBS 01P LH SKEW 7-6 INF	19880 D	825982	825983

(F1) ROLLERS

(F2) DISID

DESCRIPTION	DWG. NO.	34" W	40" W
VBS 01P RH SKEW 7-6 DIS	19881 D	825984	825985
VBS 01P LH SKEW 7-6 DIS	19881 D	825986	825987

(F1) INFID

(F2) ROLLERS

DESCRIPTION	DWG. NO.	34" W	40" W
VBS 01_ RH SKEW 7-6 INF	19880 D	825988	825989
VBS 01_ LH SKEW 7-6 INF	19880 D	825990	825991

(F1) ROLLERS

(F2) DISPTO

DESCRIPTION	DWG. NO.	34" W	40" W
VBS 01_ RH SKEW 7-6 DIS	19881 D	825992	825993
VBS 01_ LH SKEW 7-6 DIS	19881 D	825994	825995

(F1) ROLLERS

DESCRIPTION	DWG. NO.	34" W	40" W
VBS 01_ RH SKEW 5-0 INT	19882 D	825996	825997
VBS 01_ LH SKEW 5-0 INT	19882 D	825998	825999

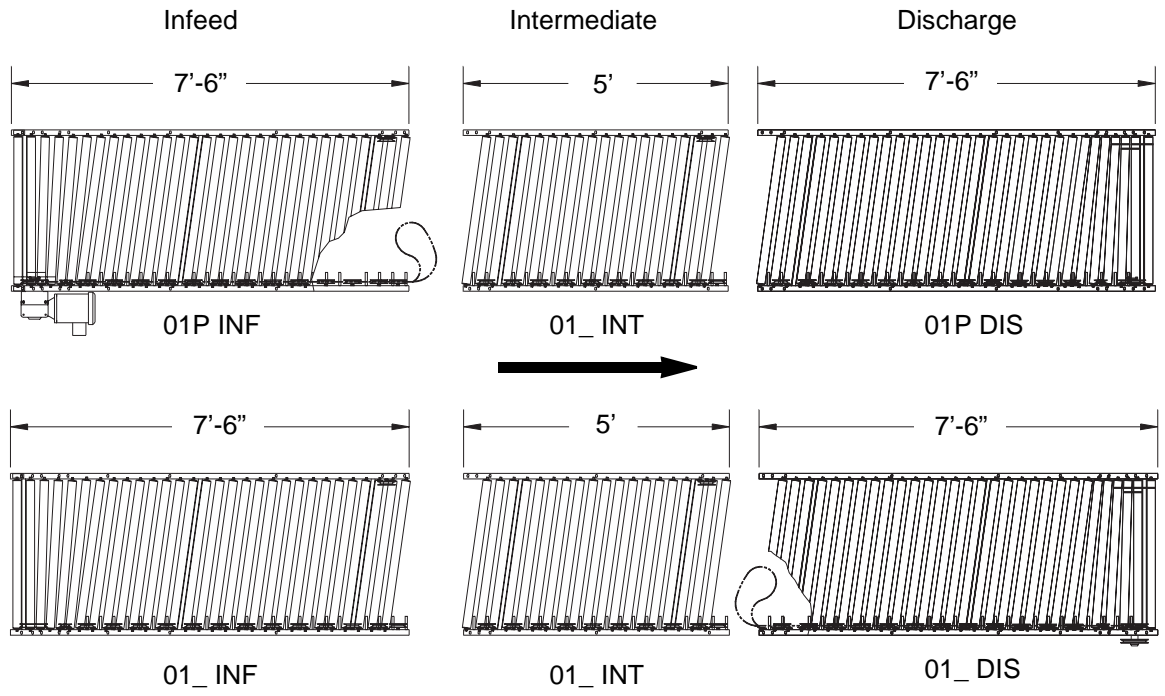


Figure J - 2 Skew, 20'-0"

Merge, Diverge, and Crossover

ITEM CLASS B 2 3 8

(F1) ROLLERS (F4) PU LH
 (F2) GROOVED ROLLERS (F5) MOTOR
 (F3) PU RH (F6) BELT

DESCRIPTION	DWG. NO.	41" W	53" W	65" W	77" W	89" W
VBM DU 5'-0"	19481 D	826726	826727	826728	826729	826730

VBM DU is used for merge, diverge, and crossover.

(F1) ROLLERS

DESCRIPTION	DWG. NO.	41" W	53" W	65" W	77" W	89" W
VBM IS 5'-0"	19482 D	N/A	824027	824028	824029	824030

VBM IS is used for merge, diverge, and crossover.

(F1) ROLLERS

(F2) GROOVED ROLLERS

DESCRIPTION	DWG. NO.	41" W	53" W	65" W	77" W	89" W
VBM TU 5'-0"	19483 D	824031	824032	824033	824034	824035

(F1) ROLLERS (F3) PRD & PRC DIV ARM
 (F2) GROOVED ROLLERS (F4) HAND ASSY

DESCRIPTION	DWG. NO.	41" W	53" W	65" W	77" W	89" W
VBD TU 5'-0"	19483 D	824036	824037	824038	824039	824040

(F1) ROLLERS

(F2) GROOVED ROLLERS

(F3) PRD & PRC DIV ARM

DESCRIPTION	DWG. NO.	41" W	53" W	65" W	77" W	89" W
VBC TU 5'-0"	19483 D	824041	824042	824043	824044	824045

DESCRIPTION	DWG. NO.	10'-0" W	15'-0" W
L/C DEFLECTOR ARM FIXED	22025D	730100	730101
L/C DEFLECTOR ARM AUTOMATIC	19194 D	730102	730103

CSPS	DESCRIPTION	DWG. NO.	41" W	53" W	65" W	77" W	89" W
DFU	L/C DEF ARM 10-0 18"LEADIN	19876 D	381432	381433	381434	381440	381441
DFU	L/C DEF ARM 15-0 18"LEADIN	19877 D	N/A	381452	381453	381454	381455

CSPS	DESCRIPTION	DWG. NO.	
DFW	L/C DEFL ARM 10'FIXED WHEEL	48285 D	730100MA
DFW	L/C DEFL ARM FIXED 15-0 WHEEL	39439 D	730101MA

Curves And Junctions (Curves With Extensions) – 2’-6”IR

ITEM CLASS B 2 3 2

- | | |
|--------------------|---------------------|
| (F1) INFDRV W/ROLR | (F6) PU RH |
| (F2) EXT W/ROLR | (F7) PU LH |
| (F3) CRV 2-6 IR | (F8) MOTOR |
| (F4) EXT W/ROLR* | (F9) BELT |
| (F5) DISID W/ROLR | (F10) DUALY TAKE-UP |

DESCRIPTION	DWG. NO.	16”W	22”W	28”W	34”W	40” W
V/B 08P 30 DEG CRV 2-6 IR W__	19406 D	826731	826732	826733	826734	826735
V/B 07P 45 DEG CRV 2-6 IR W__	19406 D	826736	826737	826738	826739	826740
V/B 06P 60 DEG CRV 2-6 IR W__	19406 D	826741	826742	826743	826744	826745
V/B 05P 90 DEG CRV 2-6 IR W__	19406 D	826746	826747	826748	826749	826750

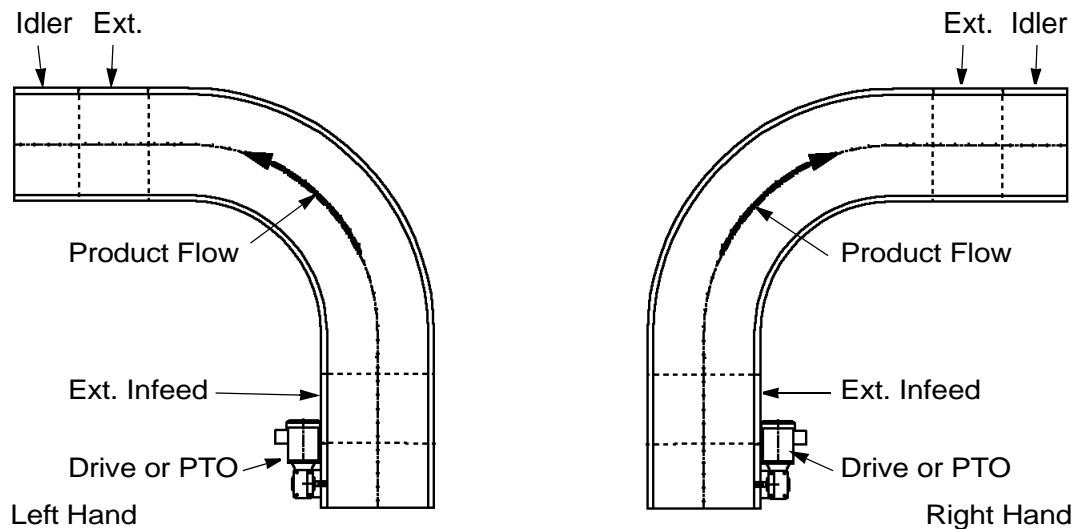


Figure J - 3 Curves and Junctions (Curves with Extensions) - 2’-6”

*See available extension lengths in back of this section.

Curves And Junctions (Curves With Extensions) – 2'-6" IR (Cont'd.)

ITEM CLASS B 2 3 8

- | | |
|-------------------|---------------------|
| (F1) INFID W/ROLR | (F5) DISPTO W/ROLR |
| (F2) EXT W/ROLR* | (F6) NON-REQUIRED |
| (F3) CRV 2-6 IR | (F7) BELT |
| (F4) EXT W/ROLRS* | (F8) DUALLY TAKE-UP |

Styles 5 through 8 for Discharge PTO Only.

DESCRIPTION	DWG. NO.	16" W	22" W	28" W	34" W	40" W
V/B 08 30 DEG CRV 2-6 IR W__	19406 D	822180	822181	822182	822183	822184
V/B 07 45 DEG CRV 2-6 IR W__	19406 D	822185	822186	822187	822188	822189
V/B 06 60 DEG CRV 2-6 IR W__	19406 D	822190	822191	822192	822193	822194
V/B 05 90 DEG CRV 2-6 IR W__	19406 D	822195	822196	822197	822198	822199

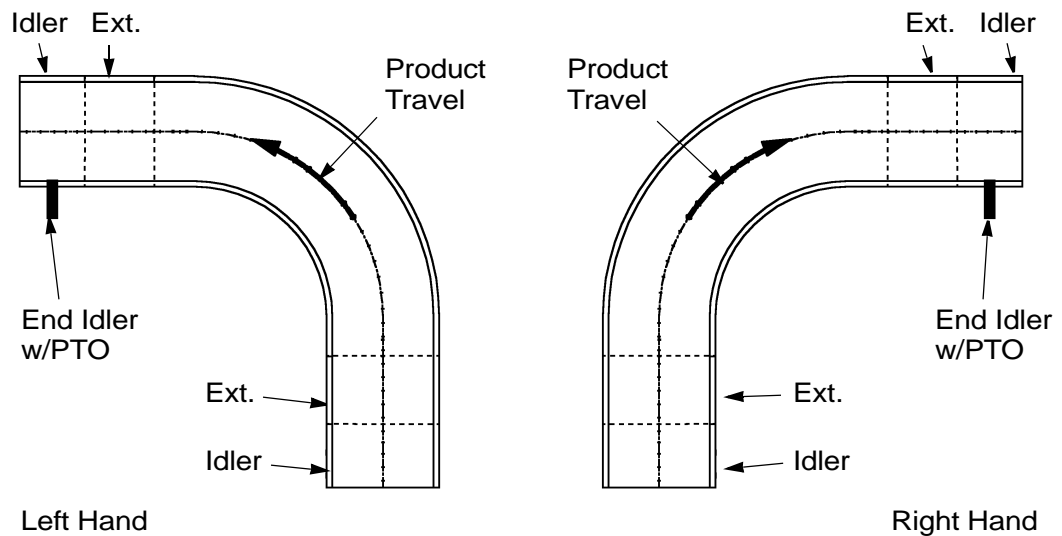


Figure J - 4 Curves and Junctions (Curves with Extensions) - 2'-6"

*See available extension lengths in back of this section.

Curves and Junctions (Curves With Extensions) – TT

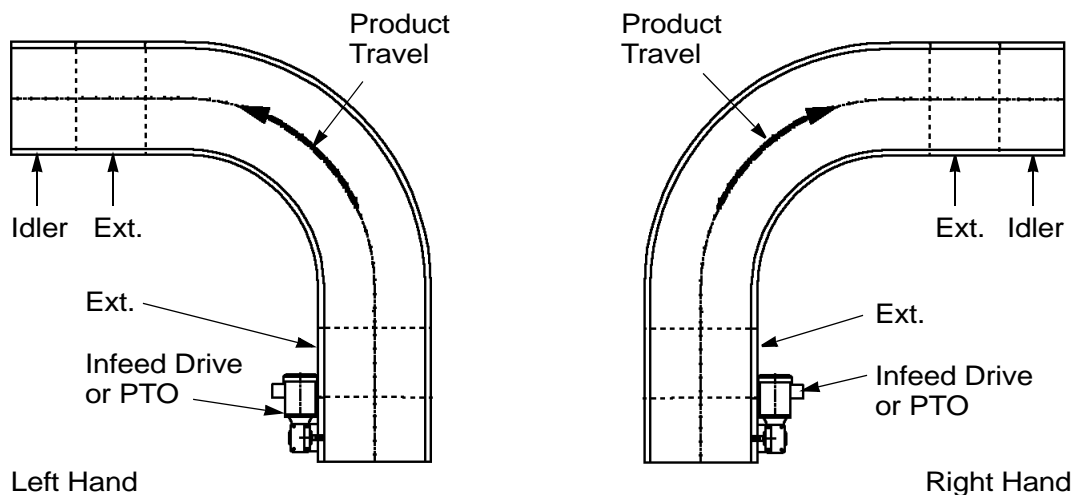
ITEM CLASS B 2 3 2

- | | |
|--------------------|---------------------|
| (F1) INFDRV W/ROLR | (F6) PU RH |
| (F2) EXT W/ROLR* | (F7) PU LH |
| (F3) CRV _ - _ IR | (F8) MOTOR |
| (F4) EXT W/ROLR* | (F9) BELT |
| (F5) DISID W/ROLR | (F10) DUALY TAKE-UP |

DESCRIPTION	DWG. NO.	22" W 3'-4" IR	28" W 4'-0" IR	34" W 5'-0" IR	40" W 5'-0" IR
V/B 08P 30 DEG CRV _ - _ IR W__	19406 D	826751	826752	826753	826754
V/B 07P 45 DEG CRV _ - _ IR W__	19406 D	826755	826756	826757	826758
V/B 06P 60 DEG CRV _ - _ IR W__	19406 D	826759	826760	826761	826762
V/B 05P 90 DEG CRV _ - _ IR W__	19406 D	826763	826764	826765	826766

Curves and Junctions - TT - Close Centers 2"

DESCRIPTION	DWG. NO.	16" W 2'-6" IR	22" W 3'-4" IR	28" W 4'-0" IR	34" W 5'-0" IR	40" W 5'-0" IR
V/B 08P 30 DEG CRV _ - _ IR 2C W__	19406 D	826800	826801	826802	826803	826804
V/B 07P 45 DEG CRV _ - _ IR 2C W__	19406 D	826805	826806	826807	826808	826809
V/B 06P 60 DEG CRV _ - _ IR 2C W__	19406 D	826810	826811	826812	826813	826814
V/B 05P 90 DEG CRV _ - _ IR 2C W__	19406 D	826815	826816	826817	826818	826819



Curves and Junctions (Curves with Extensions) - True Taper

*See available extension lengths in back of this section.

ITEM CLASS B 2 3 2

- | | |
|-----------------------|---------------------|
| (F1) INFID W/ROLR | (F5) DISPTO W/ROLR |
| (F2) EXT W/ROLR* | (F6) NON-REQUIRED |
| (F3) CRV _- IR W/ROLR | (F7) BELT |
| (F4) EXT W/ROLR* | (F8) DUALLY TAKE-UP |
- Styles 5 through 8 for Discharge PTO Only.

DESCRIPTION	DWG. NO.	22" W 3'-4" IR	28" W 4'-0" IR	34" W 5'-0" IR	40" W 5'-0" IR
V/B 08 30 DEG CRV _- IR W__	19406 D	822356	822357	822358	822359
V/B 07 45 DEG CRV _- IR W__	19406 D	822360	822361	822362	822363
V/B 06 60 DEG CRV _- IR W__	19406 D	822364	822365	822366	822367
V/B 05 90 DEG CRV _- IR W__	19406 D	822368	822369	822370	822371

Curves and Junctions - TT - Close Centers 2"

DESCRIPTION	DWG. NO.	16" W 2'-6" IR	22" W 3'-4" IR	28" W 4'-0" IR	34" W 5'-0" IR	40" W 5'-0" IR
V/B 08 30D CRV _- IR 2C W__	19406 D	824360	824361	824362	824363	824364
V/B 07 45D CRV _- IR 2C W__	19406 D	824365	824366	824367	824368	824369
V/B 06 60D CRV _- IR 2C W__	19406 D	824370	824371	824372	824373	824374
V/B 05 90D CRV _- IR 2C W__	19406 D	824375	824376	824377	824378	824379

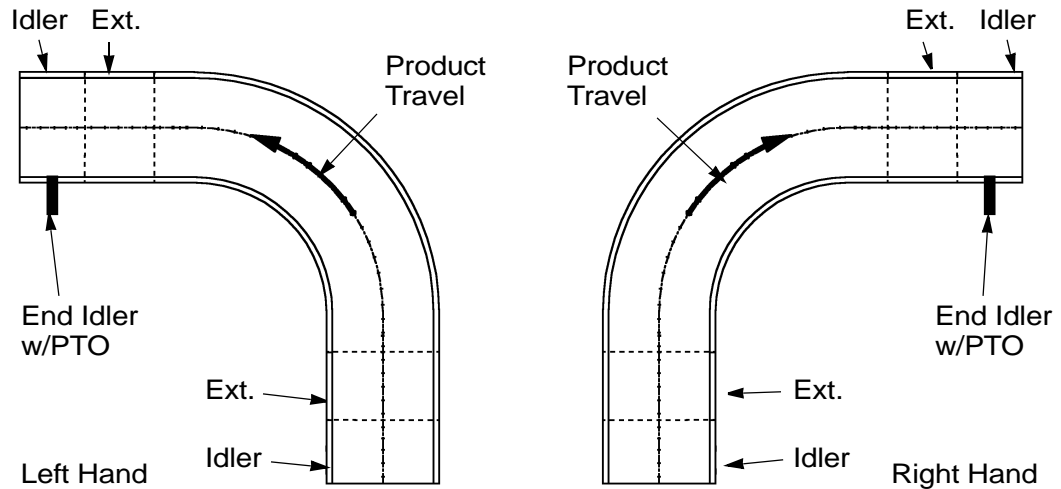


Figure J - 5 Curves and Junctions (Curves with Extensions) - True Taper

*See available extension lengths in back of this section.

Curves and Junctions (Curves With Extensions) – 2'-6" IR

ITEM CLASS B 2 3 1

STYLE 09P - INFEED

- | | | |
|-----------------------|-------------------|---------------------|
| (F1) INFDRV W/ROLR | (F5) NON-REQUIRED | (F8) MOTOR |
| (F2) EXT W/ROLR* | (F6) PU RH | (F9) BELT |
| (F3) CRV 2-6IR W/ROLR | (F7) PU LH | (F10) DUALY TAKE-UP |
| (F4) EXT W/ROLR* | | |

STYLE 09P - DISCHARGE

- | | |
|-----------------------|--------------------|
| (F1) CRV 2-6IR W/ROLR | (F4) NON-REQUIRED |
| (F2) EXT W/ROLR* | (F5) DUALY TAKE-UP |
| (F3) DISID W/ROLR | |

DESCRIPTION	DWG. NO.	16" W	22" W	28" W	34" W	40" W
V/B 09P 180/2INF CRV2-6 W_ _	19405 D	827786	827787	827788	827789	827790
V/B 09P 180/2DIS CRV2-6 W_ _	19405 D	827791	827792	827793	827794	827795

STYLE 09_ - INFEED

- | | |
|-----------------------|--------------------|
| (F1) INFID W/ROLR | (F4) NON-REQUIRED |
| (F2) EXT W/ROLR* | (F5) DUALY TAKE-UP |
| (F3) CRV 2-6IR W/ROLR | |

STYLE 09_ - DISCHARGE

- | | |
|-----------------------|--------------------|
| (F1) EXT W/ROLR* | (F5) NON-REQUIRED |
| (F2) CRV 2-6IR W/ROLR | (F6) BELT |
| (F3) EXT W/ROLR* | (F7) DUALY TAKE-UP |
| (F4) DISPTO W/ROLR | |

DESCRIPTION	DWG. NO.	16" W	22" W	28" W	34" W	40" W
V/B 09 180/2INF CRV2-6 W_ _	19405 D	827816	827817	827818	827819	827820
V/B 09 180/2DIS CRV2-6 W_ _	19405 D	827821	827822	827823	827824	827825

Curves and Junctions (Curves With Extensions) – TT 2”Centers

ITEM CLASS B 2 3 1

STYLE 09P - INFEED

- | | | |
|-----------------------|-------------------|---------------------|
| (F1) INFDRV W/ROLR | (F5) NON-REQUIRED | (F8) MOTOR |
| (F2) EXT W/ROLR* | (F6) PU RH | (F9) BELT |
| (F3) CRV 2-6IR W/ROLR | (F7) PU LH | (F10) DUALY TAKE-UP |
| (F4) EXT W/ROLR* | | |

STYLE 09P - DISCHARGE

- | | |
|-----------------------|--------------------|
| (F1) CRV 2-6IR W/ROLR | (F4) NON-REQUIRED |
| (F2) EXT W/ROLR* | (F5) DUALY TAKE-UP |
| (F3) DISID W/ROLR | |

DESCRIPTION	DWG. NO.	16” W	22” W	28” W	34” W	40” W
V/B 09P 180/2INF CRV_ _ 2CW_ _	19405 D	827776	827777	827778	827779	827780
V/B 09P 180/2DIS CRV_ _ 2CW_ _	19405 D	827781	827782	827783	827784'	827785

STYLE 09_ - INFEED

- | | |
|-----------------------|--------------------|
| (F1) INFID W/ROLR | (F4) NON-REQUIRED |
| (F2) EXT W/ROLR* | (F5) DUALY TAKE-UP |
| (F3) CRV 2-6IR W/ROLR | |

STYLE 09_ - DISCHARGE

- | | |
|------------------------|--------------------|
| (F1) EXT W/ROLR* | (F5) NON-REQUIRED |
| (F2) CRV _ _ IR W/ROLR | (F6) BELT |
| (F3) EXT W/ROLR | (F7) DUALY TAKE-UP |
| (F4) DISPTO W/ROLR | |

DESCRIPTION	DWG. NO.	16” W	22” W	28” W	34” W	40” W
V/B 09 180/2INF CRV_ 2CW_ _	19405 D	827806	827807	827808	827809	827810
V/B 09 180/2DIS CRV_ 2CW_ _	19405 D	827811	827812	827813	827814	827815

Curves and Junctions (Curves With Extensions) – TT

ITEM CLASS B 2 3 1

STYLE 09P - INFEED

- | | | |
|-----------------------|-------------------|---------------------|
| (F1) INFDRV W/ROLR | (F5) NON-REQUIRED | (F8) MOTOR |
| (F2) EXT W/ROLR* | (F6) PU RH | (F9) BELT |
| (F3) CRV 2-6IR W/ROLR | (F7) PU LH | (F10) DUALY TAKE-UP |
| (F4) EXT W/ROLR* | | |

STYLE 09P - DISCHARGE

- | | |
|-----------------------|--------------------|
| (F1) CRV 2-6IR W/ROLR | (F4) NON-REQUIRED |
| (F2) EXT W/ROLR* | (F5) DUALY TAKE-UP |
| (F3) DISID W/ROLR | |

DESCRIPTION	DWG. NO.	16" W	22" W	28" W	34" W	40" W
V/B 09P 180/2INF CRV_ _ W_ _	19405 D		827796	827797	827798	827799
V/B 09P 180/2DIS CRV_ _ W_ _	19405 D		827800	827801	827802	827803

STYLE 09_ - INFEED

- | | |
|-----------------------|--------------------|
| (F1) INFID W/ROLR | (F4) NON-REQUIRED |
| (F2) EXT W/ROLR* | (F5) DUALY TAKE-UP |
| (F3) CRV 2-6IR W/ROLR | |

STYLE 09_ - DISCHARGE

- | | |
|------------------------|--------------------|
| (F1) EXT W/ROLR* | (F5) NON-REQUIRED |
| (F2) CRV _ _ IR W/ROLR | (F6) BELT |
| (F3) EXT W/ROLR | (F7) DUALY TAKE-UP |
| (F4) DISPTO W/ROLR | |

DESCRIPTION	DWG. NO.	16" W	22" W	28" W	34" W	40" W
V/B 09 180/2INF CRV_ W_ _	19405 D		827826	827827	827828	827829
V/B 09 180/2DIS CRV_ W_ _	19405 D		827830	827831	827832	827833

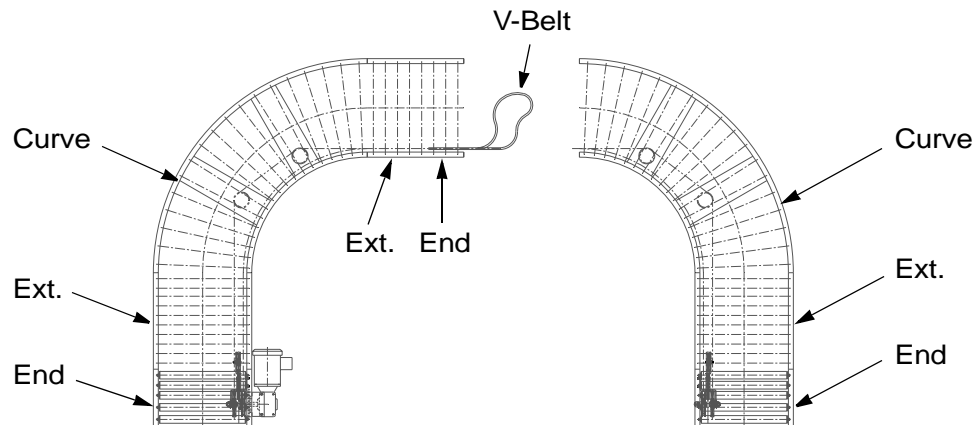


Figure J - 6 180° Curve

180° curves ship in two separate assemblies. When selecting V-Belt from the extension charts for 180° curves, add the lengths of all extensions for both 90° curves that make up the 180° curve.

Straight Junctions (Spur Junctions)

ITEM CLASS B 2 3 1

- | | | |
|-----------------------------|------------|--------------------|
| (F1) JCT RH OR LH W/ROLR | (F5) PU RH | (F9) DUALY TAKE-UP |
| (F2) EXT W/ROLR* | (F6) PU LH | |
| (F3) DISID OR INFDRV W/ROLR | (F7) MOTOR | |
| (F4) NON-REQUIRED | (F8) BELT | |

DESCRIPTION	DWG. NO.	16" W	22" W	28" W	34" W	40" W
V/B 14 30 DEG STRAT JCT W__	19407 D	826820	826821	826822	826823	826824
V/B 14P 30 DEG STRAT JCT W__	19407 D	826825	826826	826827	826828	826829
V/B 18 45 DEG STRAT JCT W__	19408 D	826830	826831	826832	826833	826834
V/B 18P 45 DEG STRAT JCT W__	19408 D	826835	826836	826837	826838	826839

Junctions (Spur Junctions) - Close Centers 2"

DESCRIPTION	DWG. NO.	16" W	22" W	28" W	34" W	40" W
V/B 14 30D STRAT JCT 2C W_	19407 D	826850	826851	826852	826853	826854
V/B 14P 30D STRAT JCT 2C W_	19407 D	826855	826856	826857	826858	826859
V/B 18 45D STRAT JCT 2C W_	19408 D	826860	826861	826862	826863	826864
V/B 18P 45D STRAT JCT 2C W_	19408 D	826865	826866	826867	826868	826869

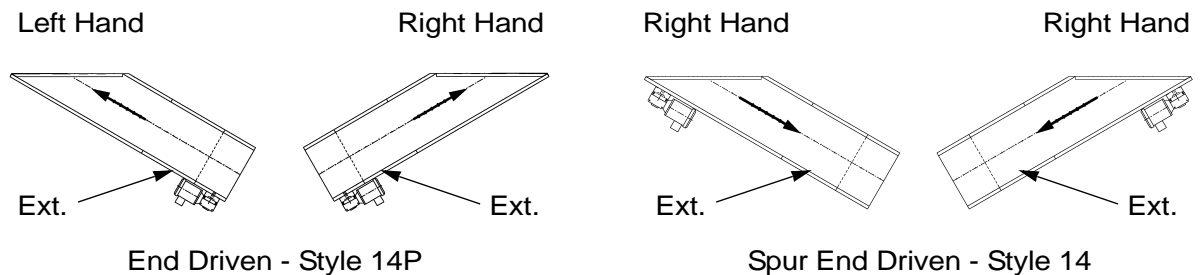


Figure J - 7 Straight Junctions (Spur Junctions)

PTO drive available for all styles above.

*See available extension lengths in back of this section.

Curve Junctions

ITEM CLASS B 2 3 1

- | | | |
|-----------------------------|------------|--------------------|
| (F1) JCT RH OR LH W/ROLR | (F5) PU RH | (F9) DUALY TAKE-UP |
| (F2) EXT W/ROLR* | (F6) PU LH | |
| (F3) DISID OR INFDRV W/ROLR | (F7) MOTOR | |
| (F4) NON-REQUIRED | (F8) BELT | |

Curve Junctions 2-6IR - Standard Centers

DESCRIPTION	DWG. NO.	16" W 2'-6" IR	22" W 2'-6" IR	28" W 2'-6" IR	34" W 2'-6" IR	40" W 2'-6" IR
V/B 21 90 DEG CRV JCT W__	19409 D	826840	826841	826842	826843	826844
V/B 21P 90 DEG CRV JCT W__	19409 D	826845	826846	826847	826848	826849

Curve Junctions TTF - Standard Centers

DESCRIPTION	DWG. NO.	16" W 2'-6" IR	22" W 3'-4" IR	28" W 4'-0" IR	34" W 5'-0" IR	40" W 5'-0" IR
V/B 21 90 DEG CRV JCT W__	19409 D	826840	824440	824441	824442	824443
V/B 21P 90 DEG CRV JCT W__	19409 D	826845	824444	824445	824446	824447

Curve Junctions TTF - Close Centers 2"

DESCRIPTION	DWG. NO.	16" W 2'-6" IR	22" W 3'-4" IR	28" W 4'-0" IR	34" W 5'-0" IR	40" W 5'-0" IR
V/B 21 90 DEG CRV JCT W__	19409 D	824448	824449	824450	824451	824452
V/B 21P 90 DEG CRV JCT W__	19409 D	824453	824454	824455	824456	824457

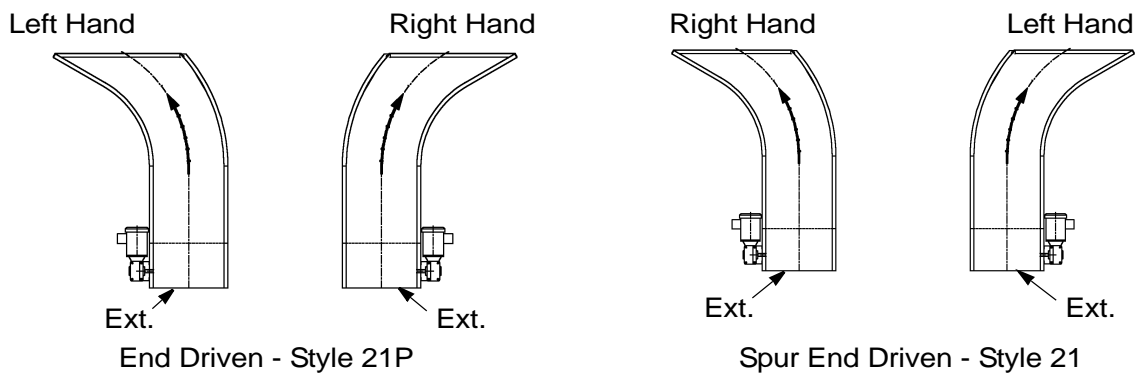


Figure J - 8 Curve Junctions

PTO drive available for all styles above.

*See available extension lengths in back of this section.

Curves and Junctions (Combination Junctions) – 2'-6" IR

ITEM CLASS B 2 3 4

- | | |
|-----------------------------|---------------------|
| (F1) JCT RH OR LH W/ROLR | (F6) PU RH |
| (F2) EXT W/ROLR* | (F7) PU LH |
| (F3) CURVE 2-6 IR W/ROLR | (F8) MOTOR |
| (F4) EXT W/ROLR* | (F9) BELT |
| (F5) INFDRV OR DISID W/ROLR | (F10) DUALY TAKE-UP |

DESCRIPTION	DWG. NO.	16" W	22" W	28" W	34" W	40" W
V/B 15 30 DEG COMB JCT W__	19410 D	826870	826871	826872	826873	826874
V/B 15P 30 DEG COMB JCT W__	19410 D	826875	826876	826877	826878	826879
V/B 19 45 DEG COMB JCT W__	19411 D	826880	826881	826882	826883	826884
V/B 19P 45 DEG COMB JCT W__	19411 D	826885	826886	826887	826888	826889

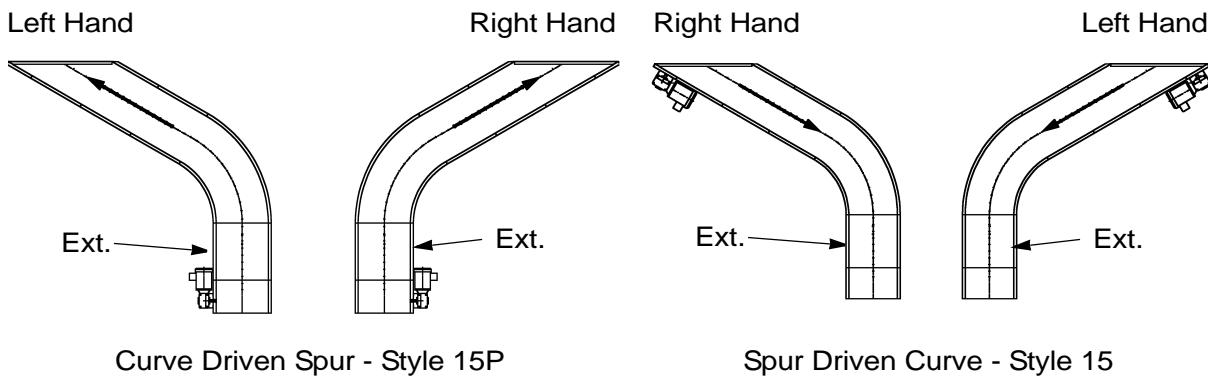


Figure J - 9 Combination Spur Curves and Junctions (2'-6" IR)

PTO Drive available for all styles above.

*See available extension lengths in back of this section.

Curves and Junctions (Combination Junctions) – TT

ITEM CLASS B 2 3 4

- | | |
|-----------------------------|---------------------|
| (F1) JCT RH OR LH W/ROLR | (F6) PU RH |
| (F2) EXT W/ROLR* | (F7) PU LH |
| (F3) CURVE _ _ IR W/ROLR | (F8) MOTOR |
| (F4) EXT W/ROLR* | (F9) BELT |
| (F5) INFDRV OR DISID W/ROLR | (F10) DUALY TAKE-UP |

DESCRIPTION	DWG. NO.	22" W 3'-4" IR	28" W 4'-0" IR	34" W 5'-0" IR	40" W 5'-0" IR
V/B 15 30D COMB JCT _ _ IR W__	19410 D	826767	826768	826769	826770
V/B 15P 30D COMB JCT _ _ IR W__	19410 D	826771	826772	826773	826774
V/B 19 45D COMB JCT _ _ IR W__	19411 D	826775	826776	826777	826778
V/B 19P 45D COMB JCT _ _ IR W__	19411 D	826779	826780	826781	826782

Curve and Junctions (Comb. Junctions) - TT - Close Centers 2"

DESCRIPTION	DWG. NO.	16" 2'-6" IR	22" W 3'-4" IR	28" W 4'-0" IR	34" W 5'-0" IR	40" W 5'-0" IR
V/B 15 30D COMB _ _ IR 2C W__	19410 D	826890	826891	826892	826893	826894
V/B 15P 30D COMB _ _ IR 2C W__	19410 D	826895	826896	826897	826898	826899
V/B 19 45D COMB _ _ IR 2C W__	19411 D	826900	826901	826902	826903	826904
V/B 19P 45D COMB _ _ IR 2C W__	19411 D	826905	826906	826907	826908	826909

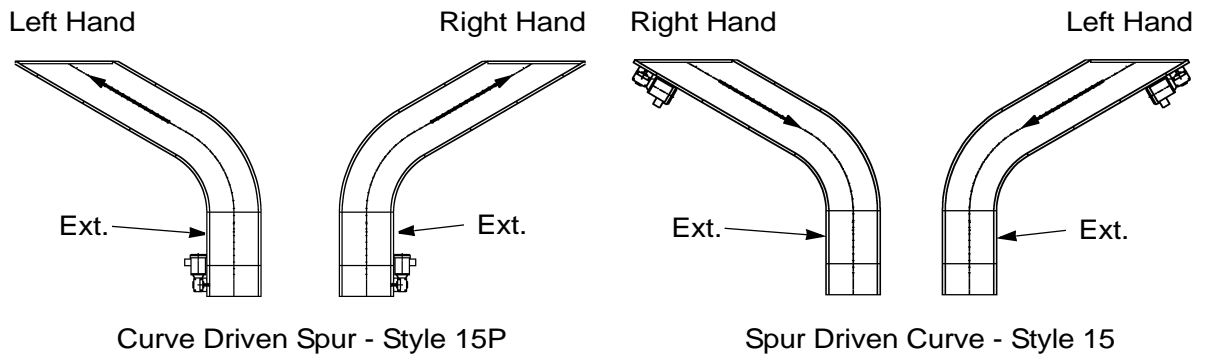


Figure J - 10 Combination Spur Curves and Junctions - True Taper

PTO Drive available for all styles above.

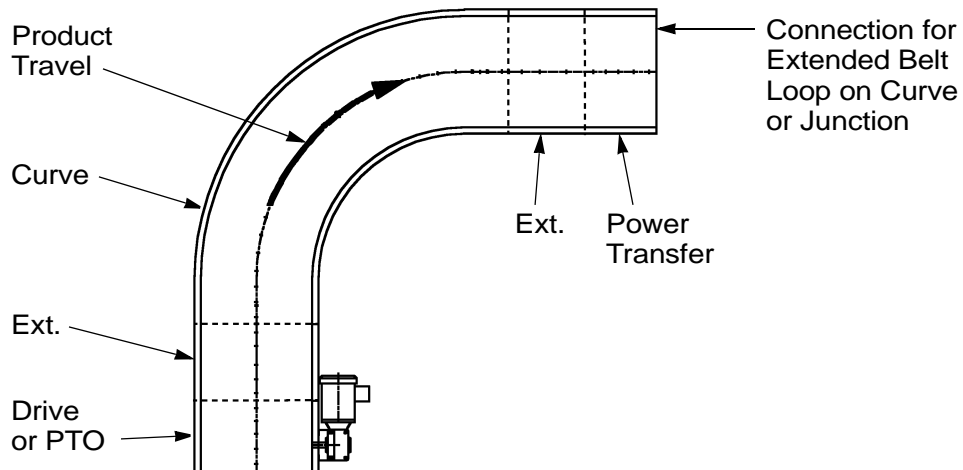
*See available extension lengths in back of this section.

Parallel Junction and S-Curve (Dr/Ext/Crv/Ext/Pt) – 2’-6” IR

ITEM CLASS B 2 3 9

- | | |
|-----------------------|---------------------|
| (F1) INF DRV W/ROLR | (F6) PU RH |
| (F2) EXT W/ROLR* | (F7) PU LH |
| (F3) CRV 2-6IR W/ROLR | (F8) MOTOR |
| (F4) EXT W/ROLR* | (F9) BELT |
| (F5) POWER TRANSFER | (F10) DUALY TAKE-UP |

DESCRIPTION	DWG. NO.	16” W	22” W	28” W	34” W	40” W
V/B DR/EXT/30/EXT/PT 2-6 W__	18972 D	826910	826911	826912	826913	826914
V/B DR/EXT/45/EXT/PT 2-6 W__	18972 D	826915	826916	826917	826918	826919
V/B DR/EXT/60/EXT/PT 2-6 W__	18972 D	826920	826921	826922	826923	826924
V/B DR/EXT/90/EXT/PT 2-6 W__	18972 D	826925	826926	826927	826928	826929



Note: This unit is used for Parallel Junctions and S-Curves

Figure J - 11 Drive/Curve/Power Transfer Extensions for Parallel Junctions and S-Curves

All units furnished with dually.

*See available extension lengths in back of this section.

Parallel Junction and S-Curve (Dr/Ext/Crv/Ext/Pt) – TT

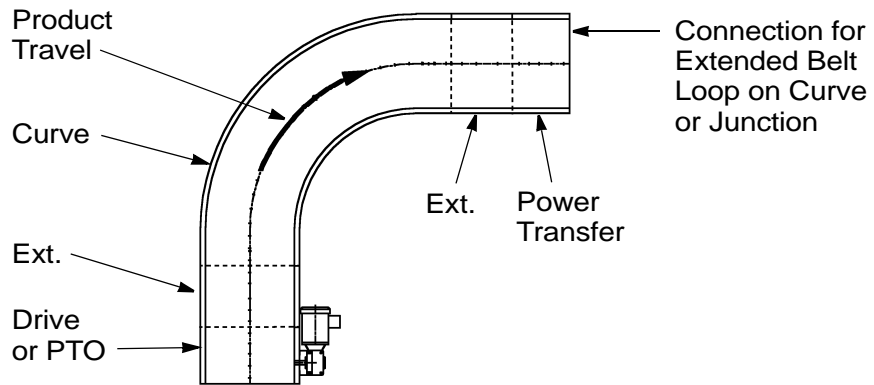
ITEM CLASS B 2 3 9

- | | | |
|-----------------------|---------------------|---------------------|
| (F1) INF DRV W/ROLR | (F5) POWER TRANSFER | (F9) BELT |
| (F2) EXT W/ROLR* | (F6) PU RH | (F10) DUALY TAKE-UP |
| (F3) CRV __ IR W/ROLR | (F7) PU LH | |
| (F4) EXT W/ROLR* | (F8) MOTOR | |

DESCRIPTION	DWG. NO.	22" W 3'-4" IR	28" W 4'-0" IR	34" W 5'-0" IR	40" W 5'-0" IR
V/B DR/EXT/30D/EXT/PT __ IR W__	18972 D	826783	826784	826785	826786
V/B DR/EXT/45D/EXT/PT __ IR W__	18972 D	826787	826788	826789	826790
V/B DR/EXT/60D/EXT/PT __ IR W__	18972 D	826791	826792	826793	826794
V/B DR/EXT/90D/EXT/PT __ IR W__	18972 D	826795	826796	826797	826798

DR/EXT/CRV/EXT/PT - TT - Close Centers 2"

DESCRIPTION	DWG. NO.	16" W 2'-6" IR	22" W 3'-4" IR	28" W 4'-0" IR	34" W 5'-0" IR	40" W 5'-0" IR
V/B DR/EXT/30D/EXT/PT TT2C W__	18972 D	826930	826931	826932	826933	826934
V/B DR/EXT/45D/EXT/PT TT2C W__	18972 D	826935	826936	826937	826938	826939
V/B DR/EXT/60D/EXT/PT TT2C W__	18972 D	826940	826941	826942	826943	826944
V/B DR/EXT/90D/EXT/PT TT2C W__	18972 D	826945	826946	826947	826948	826949



Note: This unit is used for Parallel Junctions and S-Curves

Figure J - 12 Drive/Curve/Power Transfer Extensions for Parallel Junctions and S-Curves

All units furnished with dually.

*See available extension lengths in back of this section.

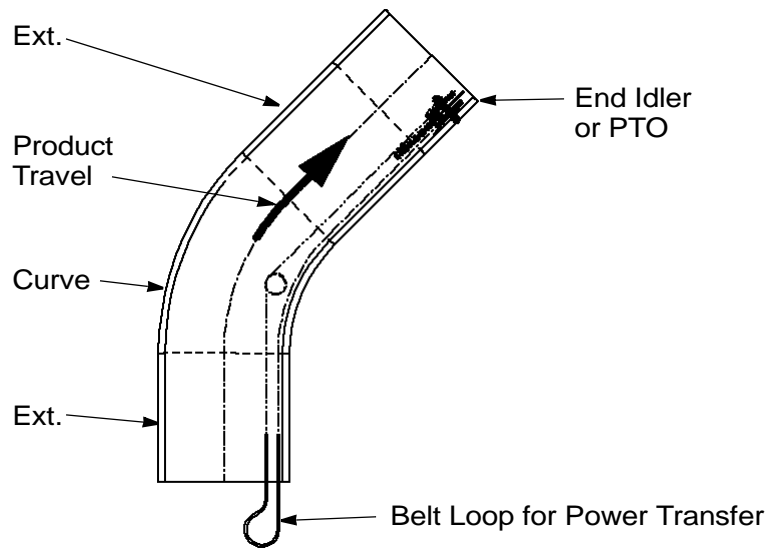
S-Curve (Ext/Curve/Ext/Idler) – 2'-6" IR

ITEM CLASS B 2 3 9

- (F1) EXT W/ROLR
- (F2) CRV 2-6 IR W/ROLR
- (F3) EXT W/ROLR*
- (F4) DISID W/ROLR

- (F5) NON-REQUIRED
- (F6) BELT
- (F7) DUALY TAKE-UP

DESCRIPTION	DWG. NO.	16" W	22" W	28" W	34" W	40" W
V/B EXT/ 30D /EXT/ID 2-6 W__	18971 D	822428	822429	822430	822431	822432
V/B EXT/ 45D /EXT/ID 2-6 W__	18971 D	822433	822434	822435	822436	822437
V/B EXT/ 60D /EXT/ID 2-6 W__	18971 D	822438	822439	822440	822441	822442
V/B EXT/ 90D /EXT/ID 2-6 W__	18971 D	822443	822444	822445	822446	822447



Note: This unit is used for Parallel Junctions and S-Curves

Figure J - 13 Idler/Curve Extensions for S-Curves

All units furnished with dually.

*See available extension lengths in back of this section.

S-Curve (Ext/Curve/Ext/Idler) – TT

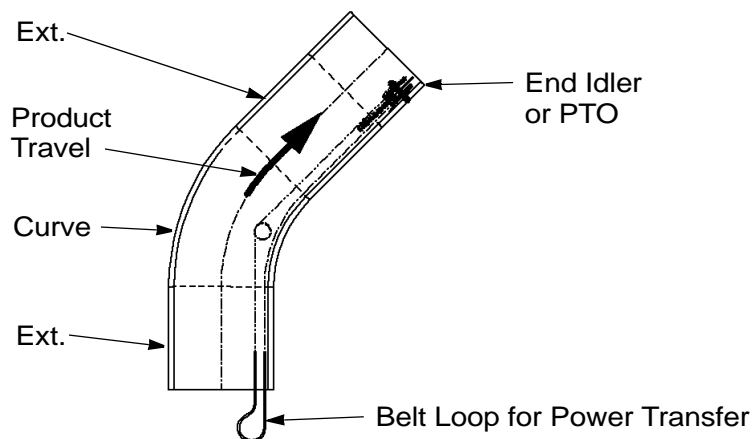
ITEM CLASS B 2 3 9

- (F1) EXT W/ROLR
- (F2) CRV _- IR W/ROLR
- (F3) EXT W/ROLR*
- (F4) DISID or DISPTO W/ROLR
- (F5) NON-REQUIRED
- (F6) BELT
- (F7) DUALLY TAKE-UP

DESCRIPTION	DWG. NO.	22" W 3'-4" IR	28" W 4'-0" IR	34" W 5'-0" IR	40" W 5'-0" IR
V/B EXT/ 30D /EXT/ID _- IR W	18971 D	822448	822449	822450	822451
V/B EXT/ 45D /EXT/ID _- IR W	18971 D	822452	822453	822454	822455
V/B EXT/ 60D /EXT/ID _- IR W	18971 D	822456	822457	822458	822459
V/B EXT/ 90D /EXT/ID _- IR W	18971 D	822460	822461	822462	822463

EXT/CURVE/EXT/IDLER - TT - Close Centers 2"

DESCRIPTION	DWG. NO.	16" W 2'-6" IR	22" W 3'-4" IR	28" W 4'-0" IR	34" W 5'-0" IR	34" W 5'-0" IR
V/B EXT/ 30D /EXT/ID _- 2C W__	18971 D	824420	824421	824422	824423	824424
V/B EXT/ 45D /EXT/ID _- 2C W__	18971 D	824425	824426	824427	824428	824429
V/B EXT/ 60D /EXT/ID _- 2C W__	18971 D	824430	824431	824432	824433	824434
V/B EXT/ 90D /EXT/ID _- 2C W__	18971 D	824435	824436	824437	824438	824439



Note: This unit is used for Parallel Junctions and S-Curves

Figure J - 14 Idler/Curve Extensions for Parallel Junctions and S-Curves

All units furnished with dually.

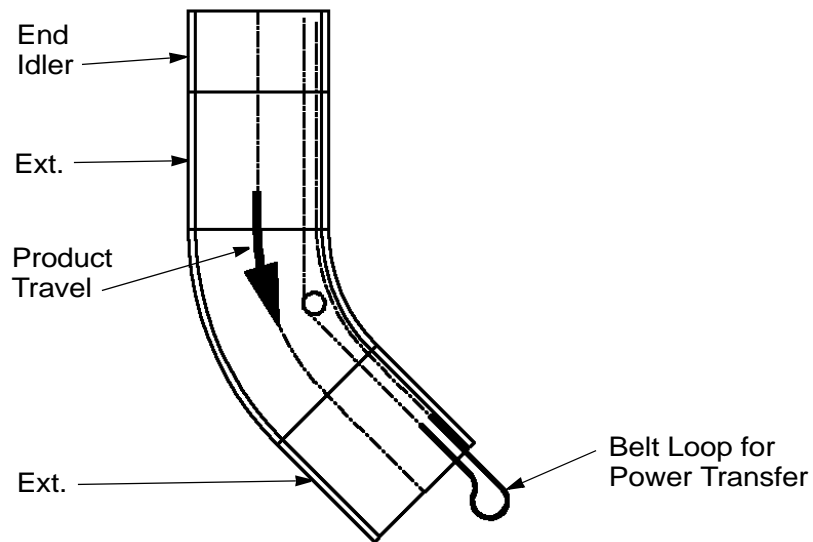
*See available extension lengths in back of this section.

S-Curve (Idler/Ext/Curve/Ext) – 2’-6” IR

ITEM CLASS B 2 3 9

- | | |
|--------------------------|--------------------|
| (F1) INF IDLER W/ROLR | (F5) NON-REQUIRED |
| (F2) EXT W/ROLR* | (F6) BELT |
| (F3) CURVE 2-6 IR W/ROLR | (F7) DUALY TAKE-UP |
| (F4) EXT W/ROLR | |

DESCRIPTION	DWG. NO.	16” W	22” W	28” W	34” W	40” W
V/B ID/EXT/ 30D /EXT 2-6 W__	18971 D	822926	822927	822928	822929	822930
V/B ID/EXT/ 45D /EXT 2-6 W__	18971 D	822931	822932	822933	822934	822935
V/B ID/EXT/ 60D /EXT 2-6 W__	18971 D	822936	822937	822938	822939	822940
V/B ID/EXT/ 90D /EXT 2-6 W__	18971 D	822941	822942	822943	822944	822945



Note: This unit is used for S-Curves

Figure J - 15 Idler/Curve Extensions for S-Curves

All units furnished with dually.

*See available extension lengths in back of this section.

S-Curve (Idler/Ext/Curve/Ext) – TT

ITEM CLASS B 2 3 9

- (F1) INFIDL W/ROLR
- (F2) EXT W/ROLR*
- (F3) CURVE _ _ IR W/ROLR
- (F4) EXT W/ROLR
- (F5) NON-REQUIRED
- (F6) BELT
- (F7) DUALLY TAKE-UP

DESCRIPTION	DWG. NO.	22" W 3'-4" IR	28" W 4'-0" IR	34" W 5'-0" IR	40" W 5'-0" IR
V/B ID/EXT/ 30D /EXT _ _ IR W__	18971 D	822946	822947	822948	822949
V/B ID/EXT/ 45D /EXT _ _ IR W__	18971 D	822950	822951	822952	822953
V/B ID/EXT/ 60D /EXT _ _ IR W__	18971 D	822954	822955	822956	822957
V/B ID/EXT/ 90D /EXT _ _ IR W__	18971 D	822958	822959	822960	822961

ID/EXT/CURVE/EXT - TT - Close Centers 2"

DESCRIPTION	DWG. NO.	16" W 2'-6" IR	22" W 3'-4" IR	28" W 4'-0" IR	34" W 5'-0" IR	40" W 5'-0" IR
V/B ID/EXT/ 30D /EXT _ _ 2C W__	18971 D	824250	824251	824252	824253	824254
V/B ID/EXT/ 45D /EXT _ _ 2C W__	18971 D	824255	824256	824257	824258	824259
V/B ID/EXT/ 60D /EXT _ _ 2C W__	18971 D	824260	824261	824262	824263	824264
V/B ID/EXT/ 90D /EXT _ _ 2C W__	18971 D	824265	824266	824267	824268	824269

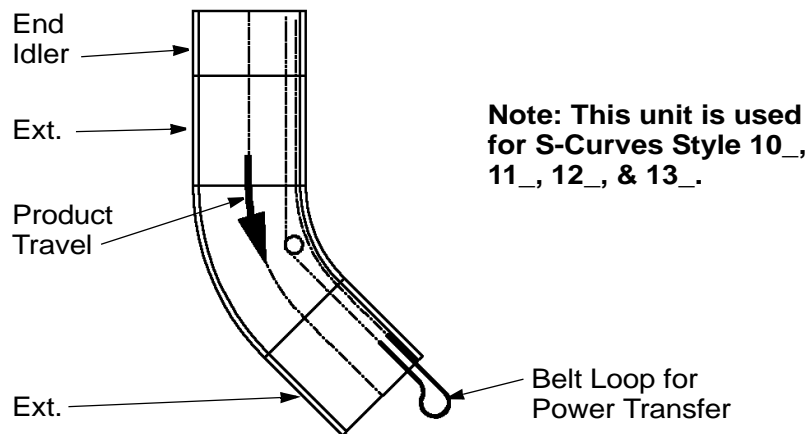


Figure J - 16 Idler/Curve Extensions for Infeed S-Curve Styles 10__, 11__, 12__, 13__

All units furnished with dually.

*See available extension lengths in back of this section.

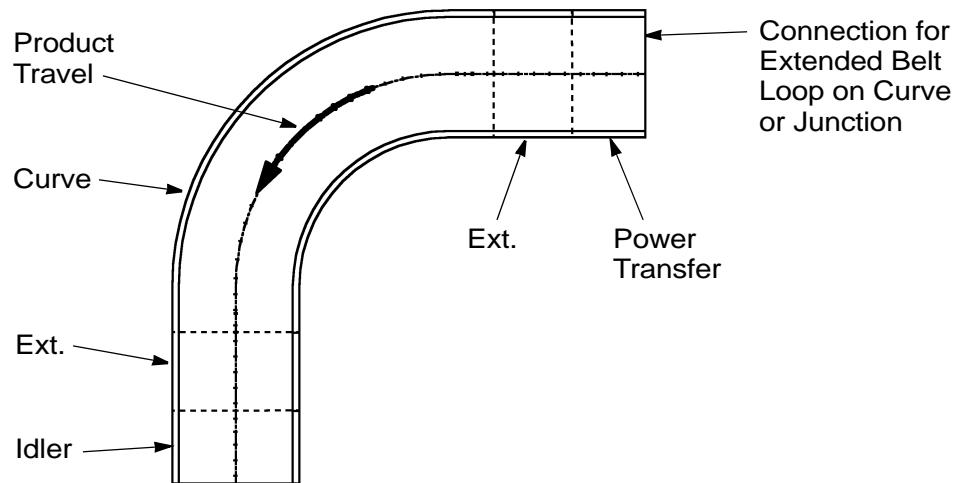
Parallel Junction and S-Curve (Pt/Ext/Crv/Ext/Idler) – 2'-6" IR

ITEM CLASS B 2 3 9

(F1) POWER TRANSFER
 (F2) EXT W/ROLR*
 (F3) CRV 2-6 IR W/ROLR
 (F4) EXT W/ROLR*

(F5) DISPTO or DISID W/ROLR
 (F6) NON-REQUIRED
 (F7) BELT
 (F8) DUALLY TAKE-UP

DESCRIPTION	DWG. NO.	16" W	22" W	28" W	34" W	40" W
V/B PT/EXT/30/EXT/ID 2-6 W__	18972 D	822962	822963	822964	822965	822966
V/B PT/EXT/45/EXT/ID 2-6 W__	18972 D	822967	822968	822969	822970	822971
V/B PT/EXT/60/EXT/ID 2-6 W__	18972 D	822972	822973	822974	822975	822976
V/B PT/EXT/90/EXT/ID 2-6 W__	18972 D	822977	822978	822979	822980	822981



Note: This unit is used for Parallel junctions and S-Curves

Figure J - 17 Power Transfer/Curve Extensions for Parallel Junctions and S-Curves

All units furnished with dually.

*See available extension lengths in back of this section.

Parallel Junction and S-Curve (Pt/Ext/Crv/Ext/Idler) – TT

ITEM CLASS B 2 3 9

(F1) POWER TRANSFER

(F4) EXT W/ROLR*

(F7) BELT

(F2) EXT W/ROLR*

(F5) DISID or DISPTO W/ROLR

(F8) DUALY TAKE-UP

(F3) CRV __ IR W/ROLR

(F6) NON-REQUIRED

DESCRIPTION	DWG. NO.	22" W 3'-4" IR	28" W 4'-0" IR	34" W 5'-0" IR	40" W 5'-0" IR
V/B PT/EXT/30/EXT/ID TT W__	18972 D	822982	822983	822984	822985
V/B PT/EXT/45/EXT/ID TT W__	18972 D	822986	822987	822988	822989
V/B PT/EXT/60/EXT/ID TT W__	18972 D	822990	822991	822992	822993
V/B PT/EXT/90/EXT/ID TT W__	18972 D	822994	822995	822996	822997

PT/EXT/CRV/EXT/ID - TT - Close Centers 2"

DESCRIPTION	DWG. NO.	16" W 2'-6" IR	22" W 3'-4" IR	28" W 4'-0" IR	34" W 5'-0" IR	40" W 5'-0" IR
V/B PT/EXT/30/EXT/ID TT W__	18972 D	824270	824271	824272	824273	824274
V/B PT/EXT/45/EXT/ID TT W__	18972 D	824275	824276	824277	824278	824279
V/B PT/EXT/60/EXT/ID TT W__	18972 D	824280	824281	824282	824283	824284
V/B PT/EXT/90/EXT/ID TT W__	18972 D	824285	824286	824287	824288	824289

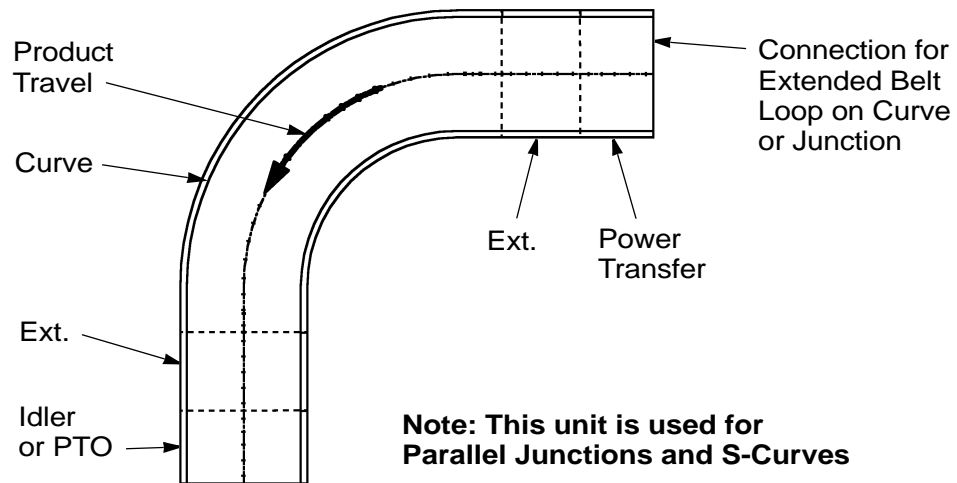


Figure J - 18 Idler/Curve/Power Transfer Extensions for Parallel Junctions and S-Curves

All units furnished with dually.

*See available extension lengths in back of this section.

Parallel Junctions (Junction)

ITEM CLASS B 2 3 9

(F1) JCT RH OR LH W/ROLR (F4) PU RH
 (F2) EXT W/ROLR* (F5) PU LH
 (F3) BELT (F6) MOTOR

DESCRIPTION	DWG. NO.	16" W	22" W	28" W	34" W	40" W
V/B MERGE JCT 45 DEG W__	18974 D	822906	822907	822908	822909	822910
V/B DIVERGE JCT 45 DEG W__	18974 D	826955	826956	826957	826958	826959
V/B MERGE JCT 30 DEG W__	18973 D	822916	822917	822918	822919	822920
V/B DIVERGE JCT 30 DEG W__	18973 D	826965	826966	826967	826968	826969

Junctions - Close Centers 2"

DESCRIPTION	DWG. NO.	16" W	22" W	28" W	34" W	40" W
V/B MERGE JCT 45D 2C W__	18974 D	824230	824231	824232	824233	824234
V/B DIVERGE JCT 45D 2C W__	18974 D	826975	826976	826977	826978	826979
V/B MERGE JCT 30D 2C W__	18973 D	824240	824241	824242	824243	824244
V/B DIVERGE JCT 30D 2C W__	18973 D	826985	826986	826987	826988	826989

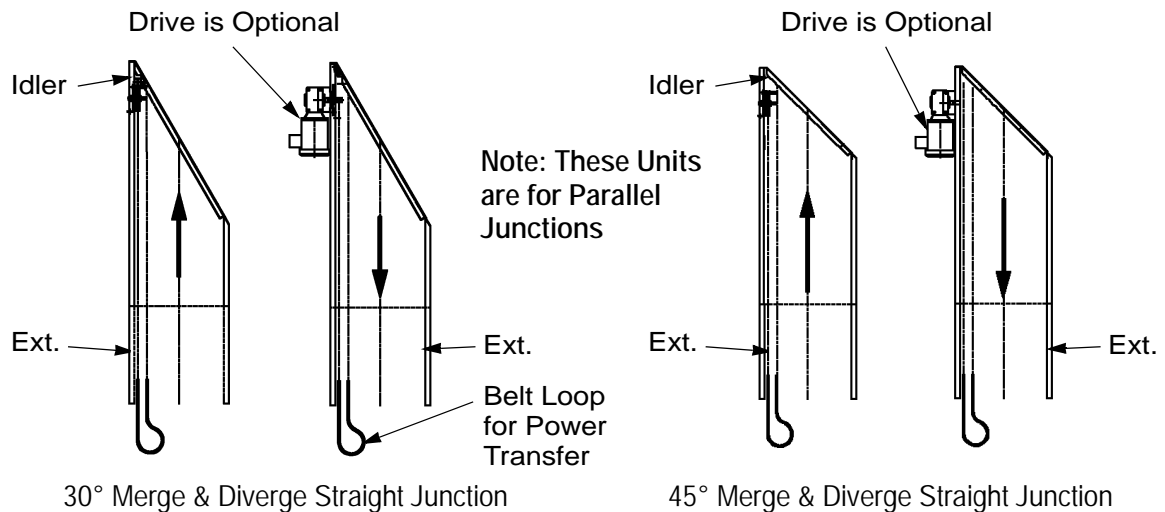


Figure J - 19 Parallel Junction Units

Power unit options available on diverge junction only. All units furnished with dually.

*See available extension lengths in back of this section.

Accessories and Kits

DESCRIPTION	DWG. NO.	PART NO.
V/B OIL DRIP PAN & BRACKET ASSY	4800366L	4800366
A/C to VBLRPTO Kit	22701	820003
A/C to VBLR w/Spring Wrap Clutch PTO Kit	22701	820004
6" Belt Idler to VBLR PTO Kit	22701	820010
T/C to VBLRPTO Kit	22701	820012

Extensions

Index pages J - 32 through J - 87 list available extension lengths for the V-Belt Live Roller Conveyor. Keep these notes in mind as you read the following pages:

- All extension lengths listed are available with 3" centers.
- Only the extension lengths marked with (2", 3") are available in 2" centers.
- Only even-numbered extension lengths are available in 2" centers. An odd-length extension leaves a 1" gap, defeating the purpose of 2" centers.
- The extension for 2" centers can be split into even lengths. For example, a 42" total extension can be split into segments of 22" and 20", but not two segments of 21".
- 2" centers are available for all widths in true taper radius. The 2'-6" IR is true taper for 16" widths.
- Table J 1 and Table J 2 list the availability of 2" and 3" roller centers.

Table J 1: Three Inch (3") Roller Center Availability

STYLE	DESCRIPTION	2'-6"IR					True Taper					Straight				
		16" W	22" W	28" W	34" W	40" W	16" W	22" W	28" W	34" W	40" W	16" W	22" W	28" W	34" W	40" W
9	180° Curve	X	X	X	X	X	X	X	X	X	X					
5	90° Curve	X	X	X	X	X	X	X	X	X	X					
6	60° Curve	X	X	X	X	X	X	X	X	X	X					
7	45° Curve	X	X	X	X	X	X	X	X	X	X					
8	30° Curve	X	X	X	X	X	X	X	X	X	X					
21	90° Spur/Curve	X	X	X	X	X	X	X	X	X	X					
19	45°-45° Spur/Curve	X	X	X	X	X	X	X	X	X	X					
15	30°-60° Spur/Curve	X	X	X	X	X	X	X	X	X	X					
10	90° "S" Curve	X	X	X	X	X	X	X	X	X	X					
11	60° "S" Curve	X	X	X	X	X	X	X	X	X	X					
12	45° "S" Curve	X	X	X	X	X	X	X	X	X	X					
13	30° "S" Curve	X	X	X	X	X	X	X	X	X	X					
14	30° Straight Spur											X	X	X	X	X
18	45° Straight Spur											X	X	X	X	X
1	Straight											X	X	X	X	X
16/20	30° or 45° Parallel Junction	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X

X = Available as a Standard

NA = Not Available as a Standard/Not Applicable

Table J 2: Two Inch (2") Roller Center Availability

STYLE	DESCRIPTION	2'-6"IR					True Taper					Straight				
		16" W	22" W	28" W	34" W	40" W	16" W	22" W	28" W	34" W	40" W	16" W	22" W	28" W	34" W	40" W
9	180° Curve	X	NA	NA	NA	NA	X	X	X	X	X					
5	90° Curve	X	NA	NA	NA	NA	X	X	X	X	X					
6	60° Curve	X	NA	NA	NA	NA	X	X	X	X	X					
7	45° Curve	X	NA	NA	NA	NA	X	X	X	X	X					
8	30° Curve	X	NA	NA	NA	NA	X	X	X	X	X					
21	90° Spur/Curve	X	NA	NA	NA	NA	X	X	X	X	X					
19	45°-45° Spur/Curve	X	NA	NA	NA	NA	X	X	X	X	X					
15	30°-60° Spur/Curve	X	NA	NA	NA	NA	X	X	X	X	X					
10	90° "S" Curve	X	NA	NA	NA	NA	X	X	X	X	X					
11	60° "S" Curve	X	NA	NA	NA	NA	X	X	X	X	X					
12	45° "S" Curve	X	NA	NA	NA	NA	X	X	X	X	X					
13	30° "S" Curve	X	NA	NA	NA	NA	X	X	X	X	X					
14	30° Straight Spur											X	X	X	X	X
18	45° Straight Spur											X	X	X	X	X
1	Straight											X	X	X	X	X
16/20	30° or 45° Parallel Junction	X	NA	NA	NA	NA	X	X	X	X	X	X	X	X	X	X

X = Available as a Standard

NA = Not Available as a Standard/Not Applicable

Style 01 – Straight 16”, 22”, 28”, 34” & 40”W – 2” or 3” Centers

The conveyor consists of drive end, idler and an extension length from this chart. Conveyor length equals 28” plus extension length. For additional information, see page 1.

Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	
0	B-53	-	41	B-133	-	71	B-195	-	
10 (2", 3")	B-73	-	42 (2", 3")	B-136	-	72 (2", 3")	B-195	-	
11	B-75	-	43	-	B-225	73	-	B-285	
12 (2", 3")	B-77	-	44 (2", 3")	B-140	-	74 (2", 3")	-	B-285	
13	B-79	-	45	-	B-225	75	-	B-285	
14 (2", 3")	B-80	-	46 (2", 3")	B-144	-	76 (2", 3")	-	B-285	
15	B-83	-	47	-	B-225	77	B-205	-	
16 (2", 3")	B-85	-	48 (2", 3")	B-148	-	78 (2", 3")	-	B-300	
17	B-87	-	49	B-150	-	79	B-210	-	
18 (2", 3")	B-89	-	50 (2", 3")	-	B-240	80 (2", 3")	-	B-300	
19	B-90	-	51	B-154	-	81	-	B-300	
20 (2", 3")	B-93	-	52 (2", 3")	-	B-240	82 (2", 3")	-	B-300	
21	B-95	-	53	B-158	-	83	-	B-300	
22 (2", 3")	B-96	-	54 (2", 3")	-	B-240	84 (2", 3")	-	B-300	
23	B-99	-	55	B-162	-	85	-	B-300	
24 (2", 3")	B-101	-	56 (2", 3")	-	B-255	86 (2", 3")	B-225	-	
25	B-103	-	57	-	B-255	87	-	B-315	
26 (2", 3")	B-105	-	58 (2", 3")	-	B-255	88 (2", 3")	-	B-315	
27	B-105	-	59	-	B-255	89	-	B-315	
28 (2", 3")	B-108	-	60 (2", 3")	B-173	-	90 (2", 3")	-	B-315	
29	B-111	-	61	B-173	-	91	-	B-315	
30 (2", 3")	B-112	-	62 (2", 3")	-	B-255	92 (2", 3")	-	B-315	
31	-	B-195	63	-	B-270	93	-	B-330	
32 (2", 3")	B-116	-	64 (2", 3")	B-180	-	94 (2", 3")	B-240	-	
33	-	B-195	65	-	B-270	95	-	B-330	
34 (2", 3")	B-120	-	66 (2", 3")	-	B-270	96 (2", 3")	-	B-330	
35	-	B-205	67	-	B-270	97	-	B-330	
36 (2", 3")	B-124	-	68 (2", 3")	-	B-270	98 (2", 3")	-	B-330	
37	-	B-205	69	B-190	-	99	-	B-330	
38 (2", 3")	B-128	-	70 (2", 3")	-	B-270	100 (2", 3")	-	B-330	
39	-	B-210	10" extension length equals base straight conveyor with 14" drive and idler ends and 10" straight extension. For a minimum length of 3'-2".						
40 (2", 3")	B-133	-							

Style 01 – Straight 16”, 22”, 28”, 34” & 40”W – 2” or 3” Centers (Cont’d.)

The conveyor consists of drive end, idler and an extension length from this chart. Conveyor length equals 28” plus extension length. For additional information, see page 1.

Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	Total Ext. Length(s)	Standard V-Belt	Dually V-Belt
101	B-255	-	133	-	B-405	163	-	B-460
102 (2", 3")	-	B-345	134 (2", 3")	-	B-405	164 (2", 3")	-	B-460
103	-	B-345	135	-	B-405	165	-	B-470
104 (2", 3")	-	B-345	136 (2", 3")	-	B-405	166 (2", 3")	-	B-470
105	-	B-345	137	-	B-405	167	-	B-470
106 (2", 3")	-	B-345	138 (2", 3")	-	B-420	168 (2", 3")	B-390	-
107	-	B-345	139	B-330	-	169	-	B-470
108 (2", 3")	-	B-360	140 (2", 3")	-	B-420	170 (2", 3")	-	B-480
109	B-270	-	141	-	B-420	171	-	B-480
110 (2", 3")	-	B-360	142 (2", 3")	-	B-420	172 (2", 3")	-	B-480
111	-	B-360	143	-	B-420	173	-	B-480
112 (2", 3")	-	B-360	144 (2", 3")	-	B-420	174 (2", 3")	-	B-480
113	-	B-360	145	-	B-430	175	-	B-490
114 (2", 3")	-	B-360	146 (2", 3")	B-345	-	176 (2", 3")	B-405	-
115	-	B-360	147	-	B-430	177	-	B-490
116 (2", 3")	B-285	-	148 (2", 3")	-	B-430	178 (2", 3")	-	B-490
117	-	B-375	149	-	B-430	179	-	B-490
118 (2", 3")	-	B-375	150 (2", 3")	-	B-445	180 (2", 3")	-	B-500
119	-	B-375	151	-	B-445	181	-	B-500
120 (2", 3")	-	B-375	152 (2", 3")	-	B-445	182 (2", 3")	-	B-500
121	-	B-375	153	-	B-445	183	B-420	-
122 (2", 3")	-	B-375	154 (2", 3")	B-360	-	184 (2", 3")	-	B-500
123	-	B-390	155	-	B-445	185	-	-
124 (2", 3")	B-300	-	156 (2", 3")	-	B-445	186 (2", 3")	-	-
125	-	B-390	157	-	B-445	187	-	-
126 (2", 3")	-	B-390	158 (2", 3")	-	B-460	188 (2", 3")	-	-
127	-	B-390	159	-	B-460	189	-	-
128 (2", 3")	-	B-390	160 (2", 3")	-	B-460	190 (2", 3")	-	-
129	-	B-390	161	B-375	-	191	-	-
130 (2", 3")	-	B-405	162 (2", 3")	-	B-460	192 (2", 3")	-	-
131	B-315	-	10" extension length equals base straight conveyor with 14" drive and idler ends and 10" straight extension. For a minimum length of 3'-2".					
132 (2", 3")	-	B-405						

Style 5 or 5P – 90° Curve – 2'-6" IR – 2" (16"W Only) or 3" Centers

24" tangents each end is obtained by adding 10" extensions on both the infeed and discharge or a total extension length of 20". 20" and above can be split between the infeed and discharge ends or extended on one end only. For additional information, see page J - 6 through J - 9. 3" centers available in 16" to 40" width; 2" centers available in true taper 16" width only. See special note regarding 2" centers on page J - 26.

Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	Total Ext. Length(s)	Standard V-Belt	Dually V-Belt
0	B-162	-	41	-	B-330	71	-	B-390
10* (2", 3")	B-180	-	42 (2", 3")	-	B-330	72 (2", 3")	-	B-390
11*	-	B-270	43	-	B-330	73	-	B-405
12* (2", 3")	-	B-270	44 (2", 3")	-	B-345	74 (2", 3")	-	B-405
13*	-	B-270	45	-	B-345	75	-	B-405
14* (2", 3")	B-190	-	46 (2", 3")	B-255	-	76 (2", 3")	B-315	-
15*	B-190	-	47	-	B-345	77	-	B-405
16* (2", 3")	-	B-285	48 (2", 3")	-	B-345	78 (2", 3")	-	B-405
17*	B-195	-	49	-	B-345	79	-	B-405
18* (2", 3")	-	B-285	50 (2", 3")	-	B-345	80 (2", 3")	-	B-405
19*	-	B-285	51	-	B-360	81	-	B-420
20 (2", 3")	-	B-285	52 (2", 3")	-	B-360	82 (2", 3")	-	B-420
21	-	B-300	53	-	B-360	83	-	B-420
22 (2", 3")	B-205	-	54 (2", 3")	B-270	-	84 (2", 3")	B-330	-
23	-	B-300	55	-	B-360	85	-	B-420
24 (2", 3")	-	B-300	56 (2", 3")	-	B-360	86 (2", 3")	-	B-420
25	B-210	-	57	-	B-360	87	-	B-420
26 (2", 3")	-	B-300	58 (2", 3")	-	B-360	88 (2", 3")	-	B-430
27	-	B-300	59	-	B-375	89	-	B-430
28 (2", 3")	-	B-300	60 (2", 3")	-	B-375	90 (2", 3")	-	B-430
29	-	B-315	61	B-285	-	91	B-345	-
30 (2", 3")	-	B-315	62 (2", 3")	-	B-375	92 (2", 3")	-	B-430
31	B-225	-	63	-	B-375	93	-	B-445
32 (2", 3")	-	B-315	64 (2", 3")	-	B-375	94 (2", 3")	-	B-445
33	-	B-315	65	-	B-375	95	-	B-445
34 (2", 3")	-	B-315	66 (2", 3")	-	B-390	96 (2", 3")	-	B-445
35	-	B-315	67	-	B-390	97	-	B-445
36 (2", 3")	-	B-330	68 (2", 3")	-	B-390	98 (2", 3")	-	B-445
37	-	B-330	69	B-300	-	99	B-360	-
38 (2", 3")	-	B-330	70 (2", 3")	-	B-390	100 (2", 3")	-	B-445
39	B-240	-	"0" extension length equals base curve with 14" drive and idler ends - no extensions. *Indicates extension length one end only. Blank = Not Available					
40 (2", 3")	-	B-330						

Style 5 – 90° Curve – 3'-4" IR TT 22"W – 2" or 3" Centers

24" tangents each end is obtained by adding 10" extensions on both the infeed and discharge or a total extension length of 20". 20" and above can be split between the infeed and discharge ends or extended on one end only. For additional information, see page J - 6 through J - 9.

Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	
0	-	B-285	41	-	B-375	71	-	B-430	
10* (2", 3")	-	B-300	42 (2", 3")	-	B-375	72 (2", 3")	-	B-430	
11*	-	B-315	43	B-285	-	73	B-345	-	
12* (2", 3")	-	B-315	44 (2", 3")	-	B-375	74 (2", 3")	-	B-430	
13*	B-225	-	45	-	B-375	75	-	B-430	
14* (2", 3")	-	B-315	46 (2", 3")	-	B-375	76 (2", 3")	-	B-445	
15*	-	B-315	47	-	B-375	77	-	B-445	
16* (2", 3")	-	B-315	48 (2", 3")	-	B-390	78 (2", 3")	-	B-445	
17*	-	B-315	49	-	B-390	79	-	B-445	
18* (2", 3")	-	B-330	50 (2", 3")	-	B-390	80 (2", 3")	-	B-445	
19*	-	B-330	51	B-300	-	81	B-360	-	
20 (2", 3")	-	B-330	52 (2", 3")	-	B-390	82 (2", 3")	-	B-445	
21	B-240	-	53	-	B-390	83	-	B-460	
22 (2", 3")	-	B-330	54 (2", 3")	-	B-390	84 (2", 3")	-	B-460	
23	-	B-330	55	-	B-390	85	-	B-460	
24 (2", 3")	-	B-330	56 (2", 3")	-	B-405	86 (2", 3")	-	B-460	
25	-	B-330	57	-	B-405	87	-	B-460	
26 (2", 3")	-	B-345	58 (2", 3")	B-315	-	88 (2", 3")	B-375	-	
27	-	B-345	59	-	B-405	89	-	B-460	
28 (2", 3")	B-255	-	60 (2", 3")	-	B-405	90 (2", 3")	-	B-460	
29	-	B-345	61	-	B-405	91	-	B-470	
30 (2", 3")	-	B-345	62 (2", 3")	-	B-405	92 (2", 3")	-	B-470	
31	-	B-345	63	-	B-420	93	-	B-470	
32 (2", 3")	-	B-345	64 (2", 3")	-	B-420	94 (2", 3")	-	B-470	
33	-	B-360	65	-	B-420	95	-	B-470	
34 (2", 3")	-	B-360	66 (2", 3")	B-330	B-420	96 (2", 3")	B-390	-	
35	-	B-360	67	-	B-420	97	-	B-480	
36 (2", 3")	B-270	-	68 (2", 3")	-	B-420	98 (2", 3")	-	B-480	
37	-	B-360	69	-	B-420	99	-	B-480	
38 (2", 3")	-	B-360	70 (2", 3")	-	B-420	100 (2", 3")	-	B-480	
39	-	B-360	"0" extension length equals base curve with 14" drive and idler ends - no extensions. *Indicates extension length one end only. Blank = Not Available						
40 (2", 3")	-	B-360							

Style 5 – 90° Curve – 4’-0” IR TT 28”W – 2” or 3” Centers

24” tangents each end is obtained by adding 10” extensions on both the infeed and discharge or a total extension length of 20”. 20” and above can be split between the infeed and discharge ends or extended on one end only. For additional information, see page J - 6 through J - 9.

Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	Total Ext. Length(s)	Standard V-Belt	Dually V-Belt
0	-	B-315	41	-	B-405	71	-	B-460
10* (2", 3")	-	B-330	42 (2", 3")	-	B-405	72 (2", 3")	-	B-460
11*	-	B-345	43	-	B-405	73	-	B-460
12* (2", 3")	-	B-345	44 (2", 3")	B-315	-	74 (2", 3")	B-375	-
13*	-	B-345	45	-	B-405	75	-	B-460
14* (2", 3")	B-255	-	46 (2", 3")	-	B-405	76 (2", 3")	-	B-470
15*	-	B-345	47	-	B-405	77	-	B-470
16* (2", 3")	-	B-345	48 (2", 3")	-	B-405	78 (2", 3")	-	B-470
17*	-	B-345	49	-	B-420	79	-	B-470
18* (2", 3")	-	B-345	50 (2", 3")	-	B-420	80 (2", 3")	-	B-470
19*	-	B-360	51	-	B-420	81	-	B-480
20 (2", 3")	-	B-360	52 (2", 3")	B-330	-	82 (2", 3")	B-390	-
21	-	B-360	53	-	B-420	83	-	B-480
22 (2", 3")	B-270	-	54 (2", 3")	-	B-420	84 (2", 3")	-	B-480
23	-	B-360	55	-	B-420	85	-	B-480
24 (2", 3")	-	B-360	56 (2", 3")	-	B-430	86 (2", 3")	-	B-490
25	-	B-360	57	-	B-430	87	-	B-490
26 (2", 3")	-	B-375	58 (2", 3")	-	B-430	88 (2", 3")	-	B-490
27	-	B-375	59	B-345	-	89	B-405	-
28 (2", 3")	-	B-375	60 (2", 3")	-	B-430	90 (2", 3")	-	B-490
29	B-285	-	61	-	B-445	91	-	B-500
30 (2", 3")	-	B-375	62 (2", 3")	-	B-445	92 (2", 3")	-	B-500
31	-	B-375	63	-	B-445	93	-	B-500
32 (2", 3")	-	B-375	64 (2", 3")	-	B-445	94 (2", 3")	-	B-500
33	-	B-375	65	-	B-445	95	-	B-500
34 (2", 3")	-	B-390	66 (2", 3")	-	B-445	96 (2", 3")	-	-
35	-	B-390	67	B-360	-	97	B-420	-
36 (2", 3")	-	B-390	68 (2", 3")	-	B-445	98 (2", 3")	-	-
37	B-300	-	69	-	B-460	99	-	-
38 (2", 3")	-	B-390	70 (2", 3")	-	B-460	100 (2", 3")	-	-
39	-	B-390	"0" extension length equals base curve with 14" drive and idler ends - no extensions. *Indicates extension length one end only. Blank = Not Available					
40 (2", 3")	-	B-390						

Style 5 – 90° Curve – 5'-0" IR TT 34" & 40"W – 2" or 3" Centers

24" tangents each end is obtained by adding 10" extensions on both the infeed and discharge or a total extension length of 20". 20" and above can be split between the infeed and discharge ends or extended on one end only. For additional information see page J - 6 through J - 9.

Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	Total Ext. Length(s)	Standard V-Belt	Dually V-Belt		
0	-	B-330	41	-	B-420	71	-	B-480		
10* (2", 3")	B-270	-	42 (2", 3")	-	B-420	72 (2", 3")	-	B-480		
11*	-	B-360	43	-	B-420	73	-	B-480		
12* (2", 3")	-	B-360	44 (2", 3")	-	B-420	74 (2", 3")	-	B-480		
13*	-	B-360	45	-	B-430	75	-	B-490		
14* (2", 3")	-	B-360	46 (2", 3")	-	B-430	76 (2", 3")	-	B-490		
15*	-	B-360	47	-	B-430	77	-	B-490		
16 (2", 3")	-	B-375	48 (2", 3")	B-345	-	78 (2", 3")	B-405	-		
17	-	B-375	49	-	B-430	79	-	B-490		
18* (2", 3")	B-285	-	50 (2", 3")	-	B-445	80 (2", 3")	-	B-500		
19	-	B-375	51	-	B-445	81	-	B-500		
20 (2", 3")	-	B-375	52 (2", 3")	-	B-445	82 (2", 3")	-	B-500		
21	-	B-375	53	-	B-445	83	-	B-500		
22 (2", 3")	-	B-375	54 (2", 3")	-	B-445	84 (2", 3")	-	B-500		
23	-	B-390	55	B-360	-	85	B-420	-		
24 (2", 3")	-	B-390	56 (2", 3")	-	B-445	86 (2", 3")	-	-		
25	B-300	-	57	-	B-445	87	-	-		
26 (2", 3")	-	B-390	58 (2", 3")	-	B-460	88 (2", 3")	-	-		
27	-	B-390	59	-	B-460	89	-	-		
28 (2", 3")	-	B-390	60 (2", 3")	-	B-460	90 (2", 3")	B-430	-		
29	-	B-390	61	-	B-460	91	-	-		
30 (2", 3")	-	B-405	62 (2", 3")	-	B-460	92 (2", 3")	-	-		
31	-	B-405	63	B-375	-	93	-	-		
32 (2", 3")	-	B-405	64 (2", 3")	-	B-460	94 (2", 3")	-	-		
33	B-315	-	65	-	B-470	95	-	-		
34 (2", 3")	-	B-405	66 (2", 3")	-	B-470	96 (2", 3")	-	-		
35	-	B-405	67	-	B-470	97	-	-		
36 (2", 3")	-	B-405	68 (2", 3")	-	B-470	98 (2", 3")	B-445	-		
37	-	B-405	69	-	B-470	99	-	-		
38 (2", 3")	-	B-420	70 (2", 3")	B-390	-	100 (2", 3")	-	-		
39	-	B-420	"0" extension length equals base curve with 14" drive and idler ends - no extensions. *Indicates extension length one end only. Blank = Not Available							
40 (2", 3")	B-330	-								

Style 6 or 6P – 60° Curve – 2'-6" IR – 2" (16"W Only) or 3" Centers

24" tangents each end is obtained by adding 10" extensions on both the infeed and discharge or a total extension length of 20". 20" and above can be split between the infeed and discharge ends or extended on one end only. For additional information, see page J - 6 through J - 9. 3" centers available in 16" to 40" width; 2" centers available in true taper 16" width only. See special note regarding 2" centers on page J - 26.

Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	Total Ext. Length(s)	Standard V-Belt	Dually V-Belt
0	B-120	-	41	-	B-285	71	-	B-345
10* (2", 3")	B-140	-	42 (2", 3")	-	B-285	72 (2", 3")	-	B-345
11*	-	B-225	43	B-205	-	73	-	B-360
12* (2", 3")	B-144	-	44 (2", 3")	-	B-300	74 (2", 3")	-	B-360
13*	-	B-240	45	B-210	-	75	B-270	-
14* (2", 3")	B-148	-	46 (2", 3")	-	B-300	76 (2", 3")	-	B-360
15*	B-150	-	47	-	B-300	77	-	B-360
16* (2", 3")	-	B-240	48 (2", 3")	-	B-300	78 (2", 3")	-	B-360
17*	B-154	-	49	-	B-300	79	-	B-360
18* (2", 3")	-	B-240	50 (2", 3")	-	B-315	80 (2", 3")	-	B-375
19*	B-158	-	51	-	B-315	81	-	B-375
20 (2", 3")	-	B-255	52 (2", 3")	B-225	-	82 (2", 3")	B-285	-
21	B-162	-	53	-	B-315	83	-	B-375
22 (2", 3")	-	B-255	54 (2", 3")	-	B-315	84 (2", 3")	-	B-375
23	-	B-255	55	-	B-315	85	-	B-375
24 (2", 3")	-	B-255	56 (2", 3")	-	B-315	86 (2", 3")	-	B-375
25	-	B-255	57	-	B-315	87	-	B-375
26 (2", 3")	-	B-255	58 (2", 3")	-	B-330	88 (2", 3")	-	B-390
27	B-173	-	59	-	B-330	89	-	B-390
28 (2", 3")	-	B-270	60 (2", 3")	B-240	-	90 (2", 3")	B-300	-
29	-	B-270	61	-	B-330	91	-	B-390
30 (2", 3")	B-180	-	62 (2", 3")	-	B-330	92 (2", 3")	-	B-390
31	-	B-270	63	-	B-330	93	-	B-390
32 (2", 3")	-	B-270	64 (2", 3")	-	B-330	94 (2", 3")	-	B-390
33	-	B-270	65	-	B-345	95	-	B-405
34 (2", 3")	-	B-270	66 (2", 3")	-	B-345	96 (2", 3")	-	B-405
35	B-190	-	67	B-255	-	97	B-315	-
36 (2", 3")	-	B-285	68 (2", 3")	-	B-345	98 (2", 3")	-	B-405
37	-	B-285	69	-	B-345	99	-	B-405
38 (2", 3")	B-195	-	70 (2", 3")	-	B-345	100 (2", 3")	-	B-405
39	-	B-285	"0" extension length equals base curve with 14" drive and idler ends - no extensions. *Indicates extension length one end only. Blank = Not Available					
40 (2", 3")	-	B-285						

Style 6 – 60° Curve – 3'-4" IR TT 22"W – 2" or 3" Centers

24" tangents each end is obtained by adding 10" extensions on both the infeed and discharge or a total extension length of 20". 20" and above can be split between the infeed and discharge ends or extended on one end only. For additional information, see page J - 6 through J - 9.

Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	Total Ext. Length(s)	Standard V-Belt	Dually V-Belt
0	-	B-225	41	B-225	-	71	B-285	-
10* (2", 3")	B-162	0	42 (2", 3")	-	B-315	72 (2", 3")	-	B-375
11*	-	B-255	43	-	B-315	73	-	B-375
12* (2", 3")	-	B-255	44 (2", 3")	-	B-315	74 (2", 3")	-	B-375
13*	-	B-255	45	-	B-315	75	-	B-375
14* (2", 3")	-	B-255	46 (2", 3")	-	B-315	76 (2", 3")	-	B-375
15*	-	B-255	47	-	B-330	77	-	B-390
16* (2", 3")	B-173	-	48 (2", 3")	-	B-330	78 (2", 3")	-	B-390
17*	-	B-270	49	B-240	-	79	B-300	-
18* (2", 3")	-	B-270	50 (2", 3")	-	B-330	80 (2", 3")	-	B-390
19*	B-180	-	51	-	B-330	81	-	B-390
20 (2", 3")	-	B-270	52 (2", 3")	-	B-330	82 (2", 3")	-	B-390
21	-	B-270	53	-	B-330	83	-	B-390
22 (2", 3")	-	B-270	54 (2", 3")	-	B-345	84 (2", 3")	-	B-405
23	-	B-270	55	-	B-345	85	-	B-405
24 (2", 3")	B-190	-	56 (2", 3")	B-255	-	86 (2", 3")	B-315	-
25	-	B-285	57	-	B-345	87	-	B-405
26 (2", 3")	-	B-285	58 (2", 3")	-	B-345	88 (2", 3")	-	B-405
27	B-195	-	59	-	B-345	89	-	B-405
28 (2", 3")	-	B-285	60 (2", 3")	-	B-345	90 (2", 3")	-	B-405
29	-	B-285	61	-	B-345	91	-	B-405
30 (2", 3")	-	B-285	62 (2", 3")	-	B-360	92 (2", 3")	-	B-420
31	-	B-285	63	-	B-360	93	-	B-420
32 (2", 3")	B-205	-	64 (2", 3")	B-270	-	94 (2", 3")	B-330	-
33	-	B-300	65	-	B-360	95	-	B-420
34 (2", 3")	B-210	-	66 (2", 3")	-	B-360	96 (2", 3")	-	B-420
35	-	B-300	67	-	B-360	97	-	B-420
36 (2", 3")	-	B-300	68 (2", 3")	-	B-360	98 (2", 3")	-	B-420
37	-	B-300	69	-	B-375	99	-	B-430
38 (2", 3")	-	B-300	70 (2", 3")	-	B-375	100 (2", 3")	-	B-430
39	-	B-315	"0" extension length equals base curve with 14" drive and idler ends - no extensions. *Indicates extension length one end only. Blank = Not Available					
40 (2", 3")	-	B-315						

Style 6 – 60° Curve – 4’-0” IR TT 28”W – 2” or 3” Centers

24” tangents each end is obtained by adding 10” extensions on both the infeed and discharge or a total extension length of 20”. 20” and above can be split between the infeed and discharge ends or extended on one end only. For additional information, see page J - 6 through J - 9.

Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	
0	B158	-	41	-	B330	71	-	B390	
10 (2", 3")	B180	-	42 (2", 3")	-	B330	72 (2", 3")	-	B390	
11	B180	-	43	-	B330	73	-	B390	
12 (2", 3")	-	B270	44 (2", 3")	-	B330	74 (2", 3")	-	B390	
13	-	B270	45	-	B330	75	-	B405	
14 (2", 3")	-	B270	46 (2", 3")	-	B345	76 (2", 3")	-	B405	
15	B190	-	47	B255	-	77	B315	-	
16 (2", 3")	B190	-	48 (2", 3")	-	B345	78 (2", 3")	-	B405	
17	-	B285	49	-	B345	79	-	B405	
18 (2", 3")	B195	-	50 (2", 3")	-	B345	80 (2", 3")	-	B405	
19	-	B285	51	-	B345	81	-	B405	
20 (2", 3")	-	B285	52 (2", 3")	-	B345	82 (2", 3")	-	B405	
21	-	B285	53	-	B360	83	-	B420	
22 (2", 3")	-	B285	54 (2", 3")	-	B360	84 (2", 3")	-	B420	
23	B205	-	55	B270	-	85	B330	-	
24 (2", 3")	-	B300	56 (2", 3")	-	B360	86 (2", 3")	-	B420	
25	-	B300	57	-	B360	87	-	B420	
26 (2", 3")	B210	-	58 (2", 3")	-	B360	88 (2", 3")	-	B420	
27	-	B300	59	-	B360	89	-	B420	
28 (2", 3")	-	B300	60 (2", 3")	-	B360	90 (2", 3")	-	B430	
29	-	B300	61	-	B375	91	-	B430	
30 (2", 3")	-	B300	62 (2", 3")	B285	-	92 (2", 3")	B345	-	
31	-	B315	63	-	B375	93	-	B430	
32 (2", 3")	B225	-	64 (2", 3")	-	B375	94 (2", 3")	-	B430	
33	-	B315	65	-	B375	95	-	B445	
34 (2", 3")	-	B315	66 (2", 3")	-	B375	96 (2", 3")	-	B445	
35	-	B315	67	-	B375	97	-	B445	
36 (2", 3")	-	B315	68 (2", 3")	-	B390	98 (2", 3")	-	B445	
37	-	B315	69	-	B390	99	-	B445	
38 (2", 3")	-	B330	70 (2", 3")	B300	-	100 (2", 3")	B360	-	
39	-	B330	"0" extension length equals base curve with 14" drive and idler ends - no extensions. *Indicates extension length one end only. Blank = Not Available						
40 (2", 3")	B240	-							

Style 6 – 60° Curve – 5'-0" IR TT 34" & 40"W – 2" or 3" Centers

24" tangents each end is obtained by adding 10" extensions on both the infeed and discharge or a total extension length of 20". 20" and above can be split between the infeed and discharge ends or extended on one end only. For additional information, see page J - 6 through J - 9.

Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	
0	-	B-270	41	-	B-360	71	-	B-420	
10* (2", 3")	B-205	-	42 (2", 3")	B-270	-	72 (2", 3")	B-330	-	
11*	-	B-300	43	-	B-360	73	-	B-420	
12* (2", 3")	B-210	-	44 (2", 3")	-	B-360	74 (2", 3")	-	B-420	
13*	-	B-300	45	-	B-360	75	-	B-420	
14* (2", 3")	-	B-300	46 (2", 3")	-	B-360	76 (2", 3")	-	B-420	
15*	-	B-300	47	-	B-375	77	-	B-430	
16* (2", 3")	-	B-300	48 (2", 3")	-	B-375	78 (2", 3")	-	B-430	
17*	-	B-315	49	B-285	-	79	B-345	-	
18* (2", 3")	-	B-315	50 (2", 3")	-	B-375	80 (2", 3")	-	B-430	
19*	B-225	-	51	-	B-375	81	-	B-430	
20 (2", 3")	-	B-315	52 (2", 3")	-	B-375	82 (2", 3")	-	B-445	
21	-	B-315	53	-	B-375	83	-	B-445	
22 (2", 3")	-	B-315	54 (2", 3")	-	B-375	84 (2", 3")	-	B-445	
23	-	B-315	55	-	B-390	85	-	B-445	
24 (2", 3")	-	B-315	56 (2", 3")	-	B-390	86 (2", 3")	-	B-445	
25	-	B-330	57	B-300	-	87	B-360	-	
26 (2", 3")	-	B-330	58 (2", 3")	-	B-390	88 (2", 3")	-	B-445	
27	B-240	-	59	-	B-390	89	-	B-445	
28 (2", 3")	-	B-330	60 (2", 3")	-	B-390	90 (2", 3")	-	B-460	
29	-	B-330	61	-	B-390	91	-	B-460	
30 (2", 3")	-	B-330	62 (2", 3")	-	B-405	92 (2", 3")	-	B-460	
31	-	B-330	63	-	B-405	93	-	B-460	
32 (2", 3")	-	B-345	64 (2", 3")	B-315	-	94 (2", 3")	-	-	
33	-	B-345	65	-	B-405	95	-	B-460	
34 (2", 3")	B-255	-	66 (2", 3")	-	B-405	96 (2", 3")	-	B-460	
35	-	B-345	67	-	B-405	97	-	B-470	
36 (2", 3")	-	B-345	68 (2", 3")	-	B-405	98 (2", 3")	-	B-470	
37	-	B-345	69	-	B-405	99	-	B-470	
38 (2", 3")	-	B-345	70 (2", 3")	-	B-420	100 (2", 3")	-	B-470	
39	-	B-345	"0" extension length equals base curve with 14" drive and idler ends - no extensions. *Indicates extension length one end only. Blank = Not Available						
40 (2", 3")	-	B-360							

Style 7 or 7P – 45° Curve – 2'-6" IR – 2" (16"W Only) or 3" Centers

24" tangents each end is obtained by adding 10" extensions on both the infeed and discharge or a total extension length of 20". 20" and above can be split between the infeed and discharge ends or extended on one end only. For additional information, see page J - 6 through J - 9 . 3" centers available in 16" to 40" width; 2" centers available in true taper 16" width only. See special note regarding 2" centers on page J - 26.

Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	Total Ext. Length(s)	Standard V-Belt	Dually V-Belt
0	B-101	-	41	-	B-270	71	-	B-330
10* (2", 3")	-	B-205	42 (2", 3")	-	B-270	72 (2", 3")	-	B-330
11*	B-124	-	43	-	B-270	73	-	B-330
12* (2", 3")	-	B-205	44 (2", 3")	B-190	-	74 (2", 3")	-	B-330
13*	B-128	-	45	-	B-285	75	-	B-345
14* (2", 3")	-	B-210	46 (2", 3")	-	B-285	76 (2", 3")	B-255	-
15*	-	B-210	47	B-195	-	77	-	B-345
16* (2", 3")	B-133	-	48 (2", 3")	-	B-285	78 (2", 3")	-	B-345
17*	B-136	-	49	-	B-285	79	-	B-345
18* (2", 3")	-	B-225	50 (2", 3")	-	B-285	80 (2", 3")	-	B-345
19*	B-140	-	51	-	B-285	81	-	B-345
20 (2", 3")	-	B-225	52 (2", 3")	B-205	-	82 (2", 3")	-	B-360
21	B-144	-	53	-	B-300	83	-	B-360
22 (2", 3")	-	B-240	54 (2", 3")	B-210	-	84 (2", 3")	B-270	-
23	B-148	-	55	-	B-300	85	-	B-360
24 (2", 3")	B-150	-	56 (2", 3")	-	B-300	86 (2", 3")	-	B-360
25	-	B-240	57	-	B-300	87	-	B-360
26 (2", 3")	B-154	-	58 (2", 3")	-	B-300	88 (2", 3")	-	B-360
27	-	B-240	59	-	B-300	89	-	B-360
28 (2", 3")	B-158	-	60 (2", 3")	-	B-315	90 (2", 3")	-	B-375
29	-	B-240	61	B-225	-	91	B-285	-
30 (2", 3")	B-162	-	62 (2", 3")	-	B-315	92 (2", 3")	-	B-375
31	-	B-255	63	-	B-315	93	-	B-375
32 (2", 3")	-	B-255	64 (2", 3")	-	B-315	94 (2", 3")	-	B-375
33	-	B-255	65	-	B-315	95	-	B-375
34 (2", 3")	-	B-255	66 (2", 3")	-	B-315	96 (2", 3")	-	B-375
35	-	B-255	67	-	B-330	97	-	B-390
36 (2", 3")	B-173	-	68 (2", 3")	-	B-330	98 (2", 3")	-	B-390
37	-	B-270	69	B-240	-	99	B-300	-
38 (2", 3")	-	B-270	70 (2", 3")	-	B-330	100 (2", 3")	-	B-390
39	B-180	-	"0" extension length equals base curve with 14" drive and idler ends - no extensions. *Indicates extension length one end only. Blank = Not Available					
40 (2", 3")	-	B-270						

Style 7 – 45° Curve – 3'-4" IR TT 22"W – 2" or 3" Centers

24" tangents each end is obtained by adding 10" extensions on both the infeed and discharge or a total extension length of 20". 20" and above can be split between the infeed and discharge ends or extended on one end only. For additional information, see page J - 6 through J - 9.

Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	Total Ext. Length(s)	Standard V-Belt	Dually V-Belt		
0	-	B-205	41	-	B-285	71	-	B-345		
10* (2", 3")	-	B-225	42 (2", 3")	-	B-285	72 (2", 3")	-	B-345		
11*	B-140	-	43	-	B-285	73	-	B-345		
12* (2", 3")	-	B-225	44 (2", 3")	B-205	-	74 (2", 3")	-	B-360		
13*	B-144	-	45	-	B-300	75	-	B-360		
14* (2", 3")	-	B-240	46 (2", 3")	B-210	-	76 (2", 3")	B-270	-		
15*	B-148	-	47	-	B-300	77	-	B-360		
16* (2", 3")	B-150	-	48 (2", 3")	-	B-300	78 (2", 3")	-	B-360		
17*	-	B-240	49	-	B-300	79	-	B-360		
18* (2", 3")	B-154	-	50 (2", 3")	-	B-300	80 (2", 3")	-	B-360		
19*	-	B-240	51	-	B-300	81	-	B-360		
20 (2", 3")	B-158	-	52 (2", 3")	-	B-315	82 (2", 3")	-	B-375		
21	-	B-240	53	B-225	-	83	B-285	-		
22 (2", 3")	B-162	-	54 (2", 3")	-	B-315	84 (2", 3")	-	B-375		
23	-	B-255	55	-	B-315	85	-	B-375		
24 (2", 3")	-	B-255	56 (2", 3")	-	B-315	86 (2", 3")	-	B-375		
25	-	B-255	57	-	B-315	87	-	B-375		
26 (2", 3")	-	B-255	58 (2", 3")	-	B-315	88 (2", 3")	-	B-375		
27	B-173	-	59	-	B-330	89	-	B-390		
28 (2", 3")	B-173	-	60 (2", 3")	-	B-330	90 (2", 3")	-	B-390		
29	-	B-270	61	B-240	-	91	B-300	-		
30 (2", 3")	-	B-270	62 (2", 3")	-	B-330	92 (2", 3")	-	B-390		
31	B-180	-	63	-	B-330	93	-	B-390		
32 (2", 3")	-	B-270	64 (2", 3")	-	B-330	94 (2", 3")	-	B-390		
33	-	B-270	65	-	B-330	95	-	B-390		
34 (2", 3")	-	B-270	66 (2", 3")	-	B-330	96 (2", 3")	-	B-390		
35	-	B-270	67	-	B-345	97	-	B-405		
36 (2", 3")	B-190	-	68 (2", 3")	B-255	-	98 (2", 3")	B-315	-		
37	-	B-285	69	-	B-345	99	-	B-405		
38 (2", 3")	B-195	-	70 (2", 3")	-	B-345	100 (2", 3")	-	B-405		
39	B-195	-	"0" extension length equals base curve with 14" drive and idler ends - no extensions. *Indicates extension length one end only. Blank = Not Available							
40 (2", 3")	-	B-285								

Style 7 – 45° Curve – 4’-0” IR TT 28”W – 2” or 3” Centers

24” tangents each end is obtained by adding 10” extensions on both the infeed and discharge or a total extension length of 20”. 20” and above can be split between the infeed and discharge ends or extended on one end only. For additional information, see page J - 6 through J - 9.

Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	
0	-	B-210	41	-	B-300	71	-	B-360	
10* (2", 3")	B-150	-	42 (2", 3")	-	B-300	72 (2", 3")	-	B-360	
11*	-	B-240	43	-	B-300	73	-	B-360	
12* (2", 3")	B-154	-	44 (2", 3")	-	B-300	74 (2", 3")	-	B-360	
13*	-	B-240	45	-	B-315	75	-	B-375	
14* (2", 3")	B-158	-	46 (2", 3")	-	B-315	76 (2", 3")	-	B-375	
15*	-	B-255	47	B-225	-	77	B-285	-	
16* (2", 3")	B-162	-	48 (2", 3")	-	B-315	78 (2", 3")	-	B-375	
17*	-	B-255	49	-	B-315	79	-	B-375	
18* (2", 3")	-	B-255	50 (2", 3")	-	B-315	80 (2", 3")	-	B-375	
19*	-	B-255	51	-	B-315	81	-	B-375	
20 (2", 3")	-	B-255	52 (2", 3")	-	B-315	82 (2", 3")	-	B-375	
21	B-173	-	53	-	B-330	83	-	B-390	
22 (2", 3")	-	B-255	54 (2", 3")	B-240	-	84 (2", 3")	B-300	-	
23	-	B-270	55	-	B-330	85	-	B-390	
24 (2", 3")	-	B-270	56 (2", 3")	-	B-330	86 (2", 3")	-	B-390	
25	B-180	-	57	-	B-330	87	-	B-390	
26 (2", 3")	-	B-270	58 (2", 3")	-	B-330	88 (2", 3")	-	B-390	
27	-	B-270	59	-	B-330	89	-	B-390	
28 (2", 3")	-	B-270	60 (2", 3")	-	B-345	90 (2", 3")	-	B-405	
29	-	B-270	61	-	B-345	91	-	B-405	
30 (2", 3")	B-190	-	62 (2", 3")	B-255	-	92 (2", 3")	B-315	-	
31	-	B-285	63	-	B-345	93	-	B-405	
32 (2", 3")	B-195	-	64 (2", 3")	-	B-345	94 (2", 3")	-	B-405	
33	-	B-285	65	-	B-345	95	-	B-405	
34 (2", 3")	-	B-285	66 (2", 3")	-	B-345	96 (2", 3")	-	B-405	
35	-	B-285	67	-	B-345	97	-	B-405	
36 (2", 3")	-	B-285	68 (2", 3")	-	B-360	98 (2", 3")	-	B-420	
37	B-205	-	69	B-270	-	99	B-330	-	
38 (2", 3")	-	B-300	70 (2", 3")	-	B-360	100 (2", 3")	-	B-420	
39	-	B-300	"0" extension length equals base curve with 14" drive and idler ends - no extensions. *Indicates extension length one end only. Blank = Not Available						
40 (2", 3")	B-210	-							

Style 7 – 45° Curve – 5'-0" IR TT 34" & 40"W – 2" or 3" Centers

24" tangents each end is obtained by adding 10" extensions on both the infeed and discharge or a total extension length of 20". 20" and above can be split between the infeed and discharge ends or extended on one end only.

Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	Total Ext. Length(s)	Standard V-Belt	Dually V-Belt
0	B-150	-	41	-	B-315	71	-	B-375
10* (2", 3")	-	B-255	42 (2", 3")	-	B-315	72 (2", 3")	-	B-375
11*	B-173	-	43	-	B-330	73	-	B-390
12* (2", 3")	B-173	-	44 (2", 3")	B-240	-	74 (2", 3")	B-300	-
13*	-	B-270	45	-	B-330	75	-	B-390
14* (2", 3")	-	B-270	46 (2", 3")	-	B-330	76 (2", 3")	-	B-390
15*	B-180	-	47	-	B-330	77	-	B-390
16* (2", 3")	-	B-270	48 (2", 3")	-	B-330	78 (2", 3")	-	B-390
17*	-	B-270	49	-	B-330	79	-	B-390
18* (2", 3")	-	B-270	50 (2", 3")	-	B-330	80 (2", 3")	-	B-405
19*	-	B-270	51	-	B-345	81	-	B-405
20 (2", 3")	B-190	-	52 (2", 3")	B-255	-	82 (2", 3")	B-315	-
21		B-285	53	-	B-345	83	-	B-405
22 (2", 3")	B-195	-	54 (2", 3")	-	B-345	84 (2", 3")	-	B-405
23	B-195	-	55	-	B-345	85	-	B-405
24 (2", 3")	-	B-285	56 (2", 3")	-	B-345	86 (2", 3")	-	B-405
25	-	B-285	57	-	B-345	87	-	B-405
26 (2", 3")	-	B-285	58 (2", 3")	-	B-360	88 (2", 3")	-	B-420
27	-	B-285	59	B-270	-	89	B-330	-
28 (2", 3")	B-205	-	60 (2", 3")	-	B-360	90 (2", 3")	-	B-420
29	-	B-300	61	-	B-360	91	-	B-420
30 (2", 3")	B-210	-	62 (2", 3")	-	B-360	92 (2", 3")	-	B-420
31	-	B-300	63	-	B-360	93	-	B-420
32 (2", 3")	-	B-300	64 (2", 3")	-	B-360	94 (2", 3")	-	B-420
33	-	B-300	65	-	B-360	95	-	B-430
34 (2", 3")	-	B-300	66 (2", 3")	-	B-375	96 (2", 3")	-	B-430
35	-	B-300	67	B-285	-	97	B-345	-
36 (2", 3")	-	B-315	68 (2", 3")	-	B-375	98 (2", 3")	-	B-430
37	B-225	-	69	-	B-375	99	-	B-430
38 (2", 3")	-	B-315	70 (2", 3")	-	B-375	100 (2", 3")	-	B-445
39	-	B-315	"0" extension length equals base curve with 14" drive and idler ends - no extensions.					
40 (2", 3")	-	B-315	*Indicates extension length one end only. Blank = Not Available					

Style 8 or 8P – 30° Curve – 2'-6" IR – 2" (16"W Only) or 3" Centers

24" tangents each end is obtained by adding 10" extensions on both the infeed and discharge or a total extension length of 20". 20" and above can be split between the infeed and discharge ends or extended on one end only. For additional information, see page J - 6 through J - 9. 3" centers available in 16" to 40" width; 2" centers available in true taper 16" width only. See special note regarding 2" centers on page J - 26.

Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	Total Ext. Length(s)	Standard V-Belt	Dually V-Belt
0	B-85	-	41	-	B-255	71	-	B-315
10* (2", 3")	B-105	-	42 (2", 3")	-	B-255	72 (2", 3")	-	B-315
11*	-	B-190	43	-	B-255	73	-	B-315
12* (2", 3")	B-108	-	44 (2", 3")	B-173	-	74 (2", 3")	-	B-315
13*	B-111	-	45	-	B-255	75	-	B-315
14* (2", 3")	B-112	-	46 (2", 3")	-	B-270	76 (2", 3")	-	B-330
15*	-	B-195	47	-	B-270	77	B-240	-
16* (2", 3")	B-116	-	48 (2", 3")	B-180	-	78 (2", 3")	-	B-330
17*	-	B-205	49	-	B-270	79	-	B-330
18* (2", 3")	B-120	-	50 (2", 3")	-	B-270	80 (2", 3")	-	B-330
19*	-	B-205	51	-	B-270	81	-	B-330
20 (2", 3")	B-124	-	52 (2", 3")	-	B-270	82 (2", 3")	-	B-330
21	-	B-205	53	B-190	-	83	-	B-330
22 (2", 3")	B-128	-	54 (2", 3")	B-285	-	84 (2", 3")	-	B-345
23	-	B-210	55	B-195	-	85	B-255	-
24 (2", 3")	B-133	-	56 (2", 3")	-	B-285	86 (2", 3")	-	B-345
25	-	B-225	57	-	B-285	87	-	B-345
26 (2", 3")	B-136	-	58 (2", 3")	-	B-285	88 (2", 3")	-	B-345
27	0	B-225	59	-	B-285	89	-	B-345
28 (2", 3")	B-140	0	60 (2", 3")	B-205	-	90 (2", 3")	-	B-345
29	-	B-225	61	-	B-300	91	-	B-360
30 (2", 3")	B-144	-	62 (2", 3")	-	B-300	92 (2", 3")	B-270	-
31	-	B-240	63	B-210	-	93	-	B-360
32 (2", 3")	B-148	-	64 (2", 3")	-	B-300	94 (2", 3")	-	B-360
33	B-150	-	65	-	B-300	95	-	B-360
34 (2", 3")	-	B-240	66 (2", 3")	-	B-300	96 (2", 3")	-	B-360
35	B-154	-	67	-	B-300	97	-	B-360
36 (2", 3")	-	B-240	68 (2", 3")	-	B-300	98 (2", 3")	-	B-360
37	B-158	-	69	-	B-315	99	-	B-375
38 (2", 3")	-	B-240	70 (2", 3")	B-225	-	100 (2", 3")	B-285	-
39	B-162	-	"0" extension length equals base curve with 14" drive and idler ends - no extensions. *Indicates extension length one end only. Blank = Not Available					
40 (2", 3")	-	B-255						

Style 8 – 30° Curve – 3'-4" IR TT 22"W – 2" or 3" Centers

24" tangents each end is obtained by adding 10" extensions on both the infeed and discharge or a total extension length of 20". 20" and above can be split between the infeed and discharge ends or extended on one end only. For additional information, see page J - 6 through J - 9.

Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	Total Ext. Length(s)	Standard V-Belt	Dually V-Belt
0	B-96	-	41	-	B-270	71	-	B-330
10* (2", 3")	B-116	-	42 (2", 3")	B-180	-	72 (2", 3")	B-240	-
11*	B-116	-	43	B-180	-	73	-	B-330
12* (2", 3")	B-120	-	44 (2", 3")	-	B-270	74 (2", 3")	-	B-330
13*	B-120	-	45	-	B-270	75	-	B-330
14* (2", 3")	B-124	-	46 (2", 3")	-	B-270	76	-	B-330
15*	B-124	-	47	B-190	-	77	-	B-330
16* (2", 3")	B-128	-	48 (2", 3")	B-190	-	78 (2", 3")	-	B-345
17*	B-128	-	49	-	B-285	79	B-255	-
18* (2", 3")	-	B-210	50 (2", 3")	B-195	-	80 (2", 3")	-	B-345
19*	B-133	-	51	-	B-285	81	-	B-345
20 (2", 3")	B-136	-	52 (2", 3")	-	B-285	82 (2", 3")	-	B-345
21	B-136	-	53	-	B-285	83	-	B-345
22 (2", 3")	B-140	-	54 (2", 3")	-	B-285	84 (2", 3")	-	B-345
23	B-140	-	55	B-205	-	85	-	B-345
24 (2", 3")	B-144	-	56 (2", 3")	-	B-300	86 (2", 3")	-	B-360
25	B-144	-	57	-	B-300	87	B-270	-
26 (2", 3")	B-148	-	58 (2", 3")	B-210	-	88 (2", 3")	-	B-360
27	B-148	-	59	-	B-300	89	-	B-360
28 (2", 3")	B-150	-	60 (2", 3")	-	B-300	90 (2", 3")	-	B-360
29	B-154	-	61	-	B-300	91	-	B-360
30 (2", 3")	B-154	-	62 (2", 3")	-	B-300	92 (2", 3")	-	B-360
31	B-158	-	63	-	B-315	93	-	B-375
32 (2", 3")	B-158	-	64 (2", 3")	B-225	-	94 (2", 3")	B-285	-
33	B-162	-	65	-	B-315	95	-	B-375
34 (2", 3")	B-162	-	66 (2", 3")	-	B-315	96 (2", 3")	-	B-375
35	-	B-255	67	-	B-315	97	-	B-375
36 (2", 3")	-	B-255	68 (2", 3")	-	B-315	98 (2", 3")	-	B-375
37	-	B-255	69	-	B-315	99	-	B-375
38 (2", 3")	-	B-255	70 (2", 3")	-	B-315	100 (2", 3")	-	B-375
39	B-173	-	"0" extension length equals base curve with 14" drive and idler ends - no extensions. *Indicates extension length one end only. Blank = Not Available					
40 (2", 3")	-	B-255						

Style 8 – 30° Curve – 4’-0” IR TT 28”W – 2” or 3” Centers

24” tangents each end is obtained by adding 10” extensions on both the infeed and discharge or a total extension length of 20”. 20” and above can be split between the infeed and discharge ends or extended on one end only. For additional information, see page J - 6 through J - 9.

Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	Total Ext. Length(s)	Standard V-Belt	Dually V-Belt
0	B-103	-	41	-	B-270	71	-	B-330
10* (2", 3")	B-124	-	42 (2", 3")	-	B-270	72 (2", 3")	-	B-330
11*	-	B-205	43	B-190	-	73	-	B-330
12* (2", 3")	B-128	-	44 (2", 3")	-	B-285	74 (2", 3")	-	B-345
13*	-	B-210	45	-	B-285	75	B-255	-
14* (2", 3")	-	B-210	46 (2", 3")	B-195	-	76 (2", 3")	-	B-345
15*	B-133	-	47	-	B-285	77	-	B-345
16* (2", 3")	B-136	-	48 (2", 3")	-	B-285	78 (2", 3")	-	B-345
17*	-	B-225	49	-	B-285	79	-	B-345
18* (2", 3")	B-140	-	50 (2", 3")	-	B-285	80 (2", 3")	-	B-345
19*	-	B-225	51	B-205	-	81	-	B-345
20 (2", 3")	B-144	-	52 (2", 3")	-	B-300	82 (2", 3")	-	B-360
21	-	B-225	53	B-210	-	83	B-270	-
22 (2", 3")	B-148	-	54 (2", 3")	-	B-300	84 (2", 3")	-	B-360
23	B-150	-	55	-	B-300	85	-	B-360
24 (2", 3")	-	B-240	56 (2", 3")	-	B-300	86 (2", 3")	-	B-360
25	B-154	-	57	-	B-300	87	-	B-360
26 (2", 3")	-	B-240	58 (2", 3")	-	B-300	88 (2", 3")	-	B-360
27	B-158	-	59	-	B-315	89	-	B-375
28 (2", 3")	-	B-240	60 (2", 3")	B-225	-	90 (2", 3")	B-285	-
29	B-162	-	61	-	B-315	91	-	B-375
30 (2", 3")	-	B-255	62 (2", 3")	-	B-315	92 (2", 3")	-	B-375
31	-	B-255	63	-	B-315	93	-	B-375
32 (2", 3")	-	B-255	64 (2", 3")	-	B-315	94 (2", 3")	-	B-375
33	-	B-255	65	-	B-315	95	-	B-375
34 (2", 3")	-	B-255	66 (2", 3")	-	B-315	96 (2", 3")	-	B-390
35	B-173	-	67	-	B-330	97	-	B-390
36 (2", 3")	-	B-255	68 (2", 3")	B-240	-	98 (2", 3")	B-300	-
37	-	B-270	69	-	B-330	99	-	B-390
38 (2", 3")	B-180	-	70 (2", 3")	-	B-330	100 (2", 3")	-	B-390
39	-	B-270	"0" extension length equals base curve with 14" drive and idler ends - no extensions. *Indicates extension length one end only. Blank = Not Available					
40 (2", 3")	-	B-270						

Style 8 – 30° Curve – 5'-0" IR TT 34" & 40"W – 2" or 3" Centers

24" tangents each end is obtained by adding 10" extensions on both the infeed and discharge or a total extension length of 20". 20" and above can be split between the infeed and discharge ends or extended on one end only. For additional information, see page J - 6 through J - 9.

Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	
0	B-116	-	41	-	B-285	71	-	B-345	
10* (2", 3")	B-136	-	42 (2", 3")	-	B-285	72 (2", 3")	-	B-345	
11*	-	B-225	43	-	B-285	73	-	B-345	
12* (2", 3")	B-140	-	44 (2", 3")	-	B-285	74 (2", 3")	-	B-345	
13*	-	B-225	45	B-205	-	75	-	B-360	
14* (2", 3")	B-144	-	46 (2", 3")	-	B-300	76 (2", 3")	B-270	-	
15*	-	B-240	47	B-210	-	77	-	B-360	
16* (2", 3")	B-148	-	48 (2", 3")	-	B-300	78 (2", 3")	-	B-360	
17*	B-150	-	49	-	B-300	79	-	B-360	
18* (2", 3")	-	B-240	50 (2", 3")	-	B-300	80 (2", 3")	-	B-360	
19*	B-154	-	51	-	B-300	81	-	B-360	
20 (2", 3")	-	B-240	52 (2", 3")	-	B-300	82 (2", 3")	-	B-360	
21	B-158	-	53	-	B-315	83	-	B-375	
22 (2", 3")	-	B-240	54 (2", 3")	B-225	-	84 (2", 3")	B-285	-	
23	B-162	-	55	-	B-315	85	-	B-375	
24 (2", 3")	-	B-255	56 (2", 3")	-	B-315	86 (2", 3")	-	B-375	
25	-	B-255	57	-	B-315	87	-	B-375	
26 (2", 3")	-	B-255	58 (2", 3")	-	B-315	88 (2", 3")	-	B-375	
27	-	B-255	59	-	B-315	89	-	B-375	
28 (2", 3")	B-173	-	60 (2", 3")	-	B-330	90 (2", 3")	-	B-390	
29	B-173	-	61	B-240	-	91	B-300	-	
30 (2", 3")	-	B-270	62 (2", 3")	-	B-330	92 (2", 3")	-	B-390	
31	-	B-270	63	-	B-330	93	-	B-390	
32 (2", 3")	B-180	-	64 (2", 3")	-	B-330	94 (2", 3")	-	B-390	
33	-	B-270	65	-	B-330	95	-	B-390	
34 (2", 3")	-	B-270	66 (2", 3")	-	B-330	96 (2", 3")	-		
35	-	B-270	67	-	B-330	97	-	B-390	
36 (2", 3")	-	B-270	68 (2", 3")	-	B-345	98 (2", 3")	-	B-405	
37	B-190	-	69	B-255	-	99	B-315	-	
38 (2", 3")	-	B-285	70 (2", 3")	-	B-345	100 (2", 3")	-	B-405	
39	B-195	-	"0" extension length equals base curve with 14" drive and idler ends - no extensions. *Indicates extension length one end only. Blank = Not Available						
40 (2", 3")	B-195	-							

Style 9 or 9P – 180° Curve – 2’-6” IR 16” – 40”W – 2” (16”W Only) or 3” Centers

Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	Total Ext. Length(s)	Standard V-Belt	Dually V-Belt
0	-	B-345	41	-	B-430	71	-	B-490
10	-	B-360	42	-	B-430	72	-	B-490
11	-	B-375	43	-	B-430	73	-	B-490
12	-	B-375	44	B-345	-	74	B-405	-
13	-	B-375	45	-	B-430	75	-	B-490
14	B-285	-	46	-	B-445	76	-	B-500
15	-	B-375	47	-	B-445	77	-	B-500
16	-	B-375	48	-	B-445	78	-	B-500
17	-	B-375	49	-	B-445	79	-	B-500
18	-	B-390	50	-	B-445	80	-	B-500
19	-	B-390	51	B-360	-	81	B-420	-
20	-	B-390	52	-	B-445	82	-	-
21	B-300	-	53	-	B-460	83	-	-
22	-	B-390	54	-	B-460	84	-	-
23	-	B-390	55	-	B-460	85	-	-
24	-	B-390	56	-	B-460	86	B-430	-
25	-	B-390	57	-	B-460	87	-	-
26	-	B-405	58	-	B-460	88	-	-
27	-	B-405	59	B-375	-	89	-	-
28	-	B-405	60	-	B-460	90	-	-
29	B-315	-	61	-	B-470	91	-	-
30	-	B-405	62	-	B-470	92	-	-
31	-	B-405	63	-	B-470	93	-	-
32	-	B-405	64	-	B-470	94	B-445	-
33	-	B-420	65	-	B-470	95	-	-
34	-	B-420	66	B-390	-	96	-	-
35	-	B-420	67	-	B-480	97	-	-
36	B-330	-	68	-	B-480	98	-	-
37	-	B-420	69	-	B-480	99	-	-
38	-	B-420	70	-	B-480	100	-	-
39	-	B-420	"0" extension length equals base curve with 14" drive and idler ends - no extensions.					
40	-	B-420	*Indicates extension length one end only. Blank = Not Available					

Style 9 or 9P – 180° Curve – 3’-4”IR – Close Centers 2” or 3” (22”W Only)

For additional information, see page J - 9 through J - 12.

Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	Total Ext. Length(s)	Standard V-Belt	Dually V-Belt
0	-	B-420	41	-	B-490	71	-	-
10	-	B-430	42	-	B-490	72	-	-
11	B-345	-	43	-	B-500	73	B-470	-
12	-	B-430	44	-	B-500	74	-	-
13	-	B-445	45	-	B-500	75	-	-
14	-	B-445	46	-	B-500	76	-	-
15	-	B-445	47	-	B-500	77	-	-
16	-	B-445	48	B-420	-	78	B-480	-
17	-	B-445	49	-	-	79	-	-
18	B-360	-	50	-	-	80	-	-
19	-	B-445	51	-	-	81	-	-
20	-	B-460	52	-	-	82	-	-
21	-	B-460	53	B-430	-	83	B-490	-
22	-	B-460	54	-	-	84	-	-
23	-	B-460	55	-	-	85	-	-
24	-	B-460	56	-	-	86	-	-
25	B-375	-	57	-	-	87	-	-
26	-	B-460	58	-	-	88	B-500	-
27	-	B-460	59	-	-	89	-	-
28	-	B-470	60	B-445	-	90	-	-
29	-	B-470	61	-	-	91	-	-
30	-	B-470	62	-	-	92	-	-
31	-	B-470	63	-	-	93	-	-
32	-	B-470	64	-	-	94	B-445	-
33	B-390	-	65	-	-	95	-	-
34	-	B-480	66	-	-	96	-	-
35	-	B-480	67	-	-	97	-	-
36	-	B-480	68	B-460	-	98	-	-
37	-	B-480	69	-	-	99	-	-
38	-	B-490	70	-	-	100	-	-
39	-	B-490	"0" extension length equals base curve with 14" drive and idler ends - no extensions.					
40	B-405	-	*Indicates extension length one end only. Blank = Not Available					

Style 9 or 9P – 180° Curve – 4'-0"IR – Close Centers 2" or 3" (28"W Only)

For additional information, see page J - 9 through J - 12.

Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	Total Ext. Length(s)	Standard V-Belt	Dually V-Belt
0	-	B-460	41	B-460	-	71	-	-
10	-	B-480	42	-	-	72	-	-
11	-	B-490	43	-	-	73	-	-
12	-	B-490	44	-	-	74	-	-
13	-	B-490	45	-	-	75	-	-
14	B-405	-	46	B-470	-	76	-	-
15	-	B-490	47	-	-	77	-	-
16	-	B-500	48	-	-	78	-	-
17	-	B-500	49	-	-	79	-	-
18	-	B-500	50	-	-	80	-	-
19	-	B-500	51	B-480	-	81	-	-
20	-	B-500	52	-	-	82	-	-
21	B-420	-	53	-	-	83	-	-
22	-	-	54	-	-	84	-	-
23	-	-	55	-	-	85	-	-
24	-	-	56	B-490	-	86	-	-
25	-	-	57	-	-	87	-	-
26	B-430	-	58	-	-	88	-	-
27	-	-	59	-	-	89	-	-
28	-	-	60	-	-	90	-	-
29	-	-	61	B-500	-	91	-	-
30	-	-	62	-	-	92	-	-
31	-	-	63	-	-	93	-	-
32	-	-	64	-	-	94	-	-
33	-	-	65	-	-	95	-	-
34	B-445	-	66	-	-	96	-	-
35	-	-	67	-	-	97	-	-
36	-	-	68	-	-	98	-	-
37	-	-	69	-	-	99	-	-
38	-	-	70	-	-	100	-	-
39	-	-	"0" extension length equals base curve with 14" drive and idler ends - no extensions.					
40	-	-	*Indicates extension length one end only. Blank = Not Available					

Style 9 or 9P – 180° Curve – 5'-0" IR – Close Centers 2" (34 & 40"W Only)

For additional information, see page J - 9 through J - 12.

Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	Total Ext. Length(s)	Standard V-Belt	Dually V-Belt
0	B-445	-	41	-	-	71	-	-
10	-	-	42	-	-	72	-	-
11	-	-	43	-	-	73	-	-
12	B-470	-	44	-	-	74	-	-
13	-	-	45	-	-	75	-	-
14	-	-	46	-	-	76	-	-
15	-	-	47	-	-	77	-	-
16	-	-	48	-	-	78	-	-
17	B-480	-	49	-	-	79	-	-
18	-	-	50	-	-	80	-	-
19	-	-	51	-	-	81	-	-
20	-	-	52	-	-	82	-	-
21	-	-	53	-	-	83	-	-
22	B-490	-	54	-	-	84	-	-
23	-	-	55	-	-	85	-	-
24	-	-	56	-	-	86	-	-
25	-	-	57	-	-	87	-	-
26	-	-	58	-	-	88	-	-
27	B-500	-	59	-	-	89	-	-
28	-	-	60	-	-	90	-	-
29	-	-	61	-	-	91	-	-
30	-	-	62	-	-	92	-	-
31	-	-	63	-	-	93	-	-
32	-	-	64	-	-	94	-	-
33	-	-	65	-	-	95	-	-
34	-	-	66	-	-	96	-	-
35	-	-	67	-	-	97	-	-
36	-	-	68	-	-	98	-	-
37	-	-	69	-	-	99	-	-
38	-	-	70	-	-	100	-	-
39	-	-	"0" extension length equals base curve with 14" drive and idler ends - no extensions. *Indicates extension length one end only. Blank = Not Available					
40	-	-						

90° S-Curve (One Curve) – 2'-6" IR – 2" (16" TT Only) or 3" Centers

The following chart is for a single Curve. To create a Style 10 S-Curve assembly, you must add an additional curve. For additional information, see page J - 17 through J - 24.

Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	
0	-	B-255	41	-	B-330	71	-	B-390	
10* (2", 3")	-	B-270	42 (2", 3")	-	B-330	72 (2", 3")	-	B-390	
11*	-	B-270	43	-	B-345	73	-	B-405	
12* (2", 3")	-	B-270	44 (2", 3")	-	B-345	74 (2", 3")	-	B-405	
13*	-	B-285	45	-	B-345	75	-	B-405	
14* (2", 3")	-	B-285	46 (2", 3")	-	B-345	76 (2", 3")	-	B-405	
15*	-	B-285	47	-	B-345	77	-	B-405	
16* (2", 3")	-	B-285	48 (2", 3")	-	B-345	78 (2", 3")	-	B-405	
17*	-	B-285	49	-	B-345	79	-	B-405	
18* (2", 3")	-	B-285	50 (2", 3")	-	B-345	80 (2", 3")	-	B-405	
19*	-	B-285	51	-	B-360	81	-	B-420	
20 (2", 3")	-	B-285	52 (2", 3")	-	B-360	82 (2", 3")	-	B-420	
21	-	B-300	53	-	B-360	83	-	B-420	
22 (2", 3")	-	B-300	54 (2", 3")	-	B-360	84 (2", 3")	-	B-420	
23	-	B-300	55	-	B-360	85	-	B-420	
24 (2", 3")	-	B-300	56 (2", 3")	-	B-360	86 (2", 3")	-	B-420	
25	-	B-300	57	-	B-360	87	-	B-420	
26 (2", 3")	-	B-300	58 (2", 3")	-	B-375	88 (2", 3")	-	B-430	
27	-	B-300	59	-	B-375	89	-	B-430	
28 (2", 3")	-	B-315	60 (2", 3")	-	B-375	90 (2", 3")	-	B-430	
29	-	B-315	61	-	B-375	91	-	B-430	
30 (2", 3")	-	B-315	62 (2", 3")	-	B-375	92 (2", 3")	-	B-430	
31	-	B-315	63	-	B-375	93	-	B-445	
32 (2", 3")	-	B-315	64 (2", 3")	-	B-375	94 (2", 3")	-	B-445	
33	-	B-315	65	-	B-375	95	-	B-445	
34 (2", 3")	-	B-315	66 (2", 3")	-	B-390	96 (2", 3")	-	B-445	
35	-	B-315	67	-	B-390	97	-	B-445	
36 (2", 3")	-	B-330	68 (2", 3")	-	B-390	98 (2", 3")	-	B-445	
37	-	B-330	69	-	B-390	99	-	B-445	
38 (2", 3")	-	B-330	70 (2", 3")	-	B-390	100 (2", 3")	-	B-445	
39	-	B-330	"0" extension length equals base curve with 14" idler end - no extension. *Indicates extension length one end only. Blank = Not Available						
40 (2", 3")	-	B-330							

90° S-Curve (One Curve) – 3'-4" IR TT 22"W – 2" or 3" Centers

The following chart is for a single Curve. To create a Style 10 S-Curve assembly, you must add an additional curve. For additional information, see page J - 17 through J - 24.

Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	
0	-	B-285	41	-	B-375	71	-	B-430	
10* (2", 3")	-	B-315	42 (2", 3")	-	B-375	72 (2", 3")	-	B-430	
11*	-	B-315	43	-	B-375	73	-	B-430	
12* (2", 3")	-	B-315	44 (2", 3")	-	B-375	74 (2", 3")	-	B-430	
13*	-	B-315	45	-	B-375	75	-	B-445	
14* (2", 3")	-	B-315	46 (2", 3")	-	B-375	76 (2", 3")	-	B-445	
15*	-	B-315	47	-	B-375	77	-	B-445	
16* (2", 3")	-	B-315	48 (2", 3")	-	B-390	78 (2", 3")	-	B-445	
17*	-	B-315	49	-	B-390	79	-	B-445	
18* (2", 3")	-	B-330	50 (2", 3")	-	B-390	80 (2", 3")	-	B-445	
19*	-	B-330	51	-	B-390	81	-	B-445	
20 (2", 3")	-	B-330	52 (2", 3")	-	B-390	82 (2", 3")	-	B-445	
21	-	B-330	53	-	B-390	83	-	B-460	
22 (2", 3")	-	B-330	54 (2", 3")	-	B-390	84 (2", 3")	-	B-460	
23	-	B-330	55	-	B-405	85	-	B-460	
24 (2", 3")	-	B-330	56 (2", 3")	-	B-405	86 (2", 3")	-	B-460	
25	-	B-345	57	-	B-405	87	-	B-460	
26 (2", 3")	-	B-345	58 (2", 3")	-	B-405	88 (2", 3")	-	B-460	
27	-	B-345	59	-	B-405	89	-	B-460	
28 (2", 3")	-	B-345	60 (2", 3")	-	B-405	90 (2", 3")	-	B-470	
29	-	B-345	61	-	B-405	91	-	B-470	
30 (2", 3")	-	B-345	62 (2", 3")	-	B-405	92 (2", 3")	-	B-470	
31	-	B-345	63	-	B-420	93	-	B-470	
32 (2", 3")	-	B-345	64 (2", 3")	-	B-420	94 (2", 3")	-	B-470	
33	-	B-360	65	-	B-420	95	-	B-480	
34 (2", 3")	-	B-360	66 (2", 3")	-	B-420	96 (2", 3")	-	B-480	
35	-	B-360	67	-	B-420	97	-	B-480	
36 (2", 3")	-	B-360	68 (2", 3")	-	B-420	98 (2", 3")	-	B-480	
37	-	B-360	69	-	B-420	99	-	B-480	
38 (2", 3")	-	B-360	70 (2", 3")	-	B-430	100 (2", 3")	-	B-490	
39	-	B-360	*0" extension length equals base curve with 14" drive and idler ends - no extensions. *Indicates extension length one end only. Blank = Not Available						
40 (2", 3")	-	B-375							

90° S-Curve (One Curve) – 4'-0" IR TT 28"W – 2" or 3" Centers

The following chart is for a single Curve. To create a Style 10 S-Curve assembly, you must add an additional curve. For additional information, see page J - 17 through J - 24.

Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	
0	-	B-315	41	-	B-405	71	-	B-460	
10* (2", 3")	-	B-330	42 (2", 3")	-	B-405	72 (2", 3")	-	B-460	
11*	-	B-345	43	-	B-405	73	-	B-460	
12* (2", 3")	-	B-345	44 (2", 3")	-	B-405	74 (2", 3")	-	B-460	
13*	-	B-345	45	-	B-405	75	-	B-460	
14* (2", 3")	-	B-345	46 (2", 3")	-	B-405	76 (2", 3")	-	B-470	
15*	-	B-345	47	-	B-405	77	-	B-470	
16* (2", 3")	-	B-345	48 (2", 3")	-	B-405	78 (2", 3")	-	B-470	
17*	-	B-345	49	-	B-420	79	-	B-470	
18* (2", 3")	-	B-345	50 (2", 3")	-	B-420	80 (2", 3")	-	B-470	
19*	-	B-360	51	-	B-420	81	-	B-480	
20 (2", 3")	-	B-360	52 (2", 3")	-	B-420	82 (2", 3")	-	B-480	
21	-	B-360	53	-	B-420	83	-	B-480	
22 (2", 3")	-	B-360	54 (2", 3")	-	B-420	84 (2", 3")	-	B-480	
23	-	B-360	55	-	B-420	85	-	B-480	
24 (2", 3")	-	B-360	56 (2", 3")	-	B-430	86 (2", 3")	-	B-490	
25	-	B-360	57	-	B-430	87	-	B-490	
26 (2", 3")	-	B-375	58 (2", 3")	-	B-430	88 (2", 3")	-	B-490	
27	-	B-375	59	-	B-430	89	-	B-490	
28 (2", 3")	-	B-375	60 (2", 3")	-	B-430	90 (2", 3")	-	B-490	
29	-	B-375	61	-	B-445	91	-	B-500	
30 (2", 3")	-	B-375	62 (2", 3")	-	B-445	92 (2", 3")	-	B-500	
31	-	B-375	63	-	B-445	93	-	B-500	
32 (2", 3")	-	B-375	64 (2", 3")	-	B-445	94 (2", 3")	-	B-500	
33	-	B-375	65	-	B-445	95	-	B-500	
34 (2", 3")	-	B-390	66 (2", 3")	-	B-445	96 (2", 3")	-	-	
35	-	B-390	67	-	B-445	97	-	-	
36 (2", 3")	-	B-390	68 (2", 3")	-	B-445	98 (2", 3")	-	-	
37	-	B-390	69	-	B-460	99	-	-	
38 (2", 3")	-	B-390	70 (2", 3")	-	B-460	100 (2", 3")	-	-	
39	-	B-390	"0" extension length equals base curve with 14" drive and idler ends - no extensions. *Indicates extension length one end only. Blank = Not Available						
40 (2", 3")	-	B-390							

90° S-Curve (One Curve) – 5'-0" IR TT – 2" or 3" Centers (34" & 40"W)

The following chart is for a single Curve. To create a Style 10 S-Curve assembly, you must add an additional curve. For additional information, see page J - 17 through J - 24.

Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	Total Ext. Length(s)	Standard V-Belt	Dually V-Belt
0	-	B-345	41	-	B-420	71	-	B-480
10* (2", 3")	-	B-360	42 (2", 3")	-	B-420	72 (2", 3")	-	B-480
11*	-	B-360	43	-	B-420	73	-	B-480
12* (2", 3")	-	B-360	44 (2", 3")	-	B-420	74 (2", 3")	-	B-480
13*	-	B-360	45	-	B-430	75	-	B-490
14* (2", 3")	-	B-360	46 (2", 3")	-	B-430	76 (2", 3")	-	B-490
15	-	B-375	47	-	B-430	77	-	B-490
16 (2", 3")	-	B-375	48 (2", 3")	-	B-430	78 (2", 3")	-	B-490
17	-	B-375	49	-	B-430	79	-	B-490
18 (2", 3")	-	B-375	50 (2", 3")	-	B-445	80 (2", 3")	-	B-500
19	-	B-375	51	-	B-445	81	-	B-500
20 (2", 3")	-	B-375	52 (2", 3")	-	B-445	82 (2", 3")	-	B-500
21	-	B-375	53	-	B-445	83	-	B-500
22 (2", 3")	-	B-390	54 (2", 3")	-	B-445	84 (2", 3")	-	B-500
23	-	B-390	55	-	B-445	85	-	-
24 (2", 3")	-	B-390	56 (2", 3")	-	B-445	86 (2", 3")	-	-
25	-	B-390	57	-	B-460	87	-	-
26 (2", 3")	-	B-390	58 (2", 3")	-	B-460	88 (2", 3")	-	-
27	-	B-390	59	-	B-460	89	-	-
28 (2", 3")	-	B-390	60 (2", 3")	-	B-460	90 (2", 3")	-	-
29	-	B-390	61	-	B-460	91	-	-
30 (2", 3")	-	B-405	62 (2", 3")	-	B-460	92 (2", 3")	-	-
31	-	B-405	63	-	B-460	93	-	-
32 (2", 3")	-	B-405	64 (2", 3")	-	B-460	94 (2", 3")	-	-
33	-	B-405	65	-	B-470	95	-	-
34 (2", 3")	-	B-405	66 (2", 3")	-	B-470	96 (2", 3")	-	-
35	-	B-405	67	-	B-470	97	-	-
36 (2", 3")	-	B-405	68 (2", 3")	-	B-470	98 (2", 3")	-	-
37	-	B-420	69	-	B-470	99	-	-
38 (2", 3")	-	B-420	70 (2", 3")	-	B-480	100 (2", 3")	-	-
39	-	B-420	"0" extension length equals base curve with 14" drive and idler ends - no extensions.					
40 (2", 3")	-	B-420	*Indicates extension length one end only. Blank = Not Available					

60° S-Curve (One Curve) – 2'-6" IR – 2" (16" TT Only) or 3" Centers

The following chart is for a single Curve. To create a Style 11 S-Curve assembly, you must add an additional curve. For additional information, see page J - 17 through J - 24.

Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	Total Ext. Length(s)	Standard V-Belt	Dually V-Belt
0	-	B-205	41	-	B-285	71	-	B-345
10* (2", 3")	-	B-225	42 (2", 3")	-	B-285	72 (2", 3")	-	B-345
11*	-	B-225	43	-	B-300	73	-	B-360
12* (2", 3")	-	B-225	44 (2", 3")	-	B-300	74 (2", 3")	-	B-360
13*	-	B-240	45	-	B-300	75	-	B-360
14* (2", 3")	-	B-240	46 (2", 3")	-	B-300	76 (2", 3")	-	B-360
15*	-	B-240	47	-	B-300	77	-	B-360
16* (2", 3")	-	B-240	48 (2", 3")	-	B-300	78 (2", 3")	-	B-360
17*	-	B-240	49	-	B-300	79	-	B-360
18* (2", 3")	-	B-240	50 (2", 3")	-	B-315	80 (2", 3")	-	B-375
19*	-	B-240	51	-	B-315	81	-	B-375
20 (2", 3")	-	B-255	52 (2", 3")	-	B-315	82 (2", 3")	-	B-375
21	-	B-255	53	-	B-315	83	-	B-375
22 (2", 3")	-	B-255	54 (2", 3")	-	B-315	84 (2", 3")	-	B-375
23	-	B-255	55	-	B-315	85	-	B-375
24 (2", 3")	-	B-255	56 (2", 3")	-	B-315	86 (2", 3")	-	B-375
25	-	B-255	57	-	B-315	87	-	B-390
26 (2", 3")	-	B-255	58 (2", 3")	-	B-330	88 (2", 3")	-	B-390
27	-	B-255	59	-	B-330	89	-	B-390
28 (2", 3")	-	B-270	60 (2", 3")	-	B-330	90 (2", 3")	-	B-390
29	-	B-270	61	-	B-330	91	-	B-390
30 (2", 3")	-	B-270	62 (2", 3")	-	B-330	92 (2", 3")	-	B-390
31	-	B-270	63	-	B-330	93	-	B-390
32 (2", 3")	-	B-270	64 (2", 3")	-	B-330	94 (2", 3")	-	B-390
33	-	B-270	65	-	B-345	95	-	B-405
34 (2", 3")	-	B-270	66 (2", 3")	-	B-345	96 (2", 3")	-	B-405
35	-	B-285	67	-	B-345	97	-	B-405
36 (2", 3")	-	B-285	68 (2", 3")	-	B-345	98 (2", 3")	-	B-405
37	-	B-285	69	-	B-345	99	-	B-405
38 (2", 3")	-	B-285	70 (2", 3")	-	B-345	100 (2", 3")	-	B-405
39	-	B-285	*0" extension length equals base curve with 14" idler end - no extension. *Indicates extension length one end only. Blank = Not Available					
40 (2", 3")	-	B-285						

60° S-Curve (One Curve) – 3'-4" IR TT 22"W – 2" or 3" Centers

The following chart is for a single Curve. To create a Style 11 S-Curve assembly, you must add an additional curve. For additional information, see page J - 17 through J - 24.

Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	Total Ext. Length(s)	Standard V-Belt	Dually V-Belt
0	-	B-225	41	-	B-315	71	-	B-375
10* (2", 3")	-	B-255	42 (2", 3")	-	B-315	72 (2", 3")	-	B-375
11*	-	B-255	43	-	B-315	73	-	B-375
12* (2", 3")	-	B-255	44 (2", 3")	-	B-315	74 (2", 3")	-	B-375
13*	-	B-255	45	-	B-315	75	-	B-375
14* (2", 3")	-	B-255	46 (2", 3")	-	B-315	76 (2", 3")	-	B-390
15*	-	B-255	47	-	B-330	77	-	B-390
16* (2", 3")	-	B-255	48 (2", 3")	-	B-330	78 (2", 3")	-	B-390
17*	-	B-270	49	-	B-330	79	-	B-390
18* (2", 3")	-	B-270	50 (2", 3")	-	B-330	80 (2", 3")	-	B-390
19*	-	B-270	51	-	B-330	81	-	B-390
20 (2", 3")	-	B-270	52 (2", 3")	-	B-330	82 (2", 3")	-	B-390
21	-	B-270	53	-	B-330	83	-	B-390
22 (2", 3")	-	B-270	54 (2", 3")	-	B-345	84 (2", 3")	-	B-405
23	-	B-270	55	-	B-345	85	-	B-405
24 (2", 3")	-	B-285	56 (2", 3")	-	B-345	86 (2", 3")	-	B-405
25	-	B-285	57	-	B-345	87	-	B-405
26 (2", 3")	-	B-285	58 (2", 3")	-	B-345	88 (2", 3")	-	B-405
27	-	B-285	59	-	B-345	89	-	B-405
28 (2", 3")	-	B-285	60 (2", 3")	-	B-345	90 (2", 3")	-	B-405
29	-	B-285	61	-	B-345	91	-	B-420
30 (2", 3")	-	B-285	62 (2", 3")	-	B-360	92 (2", 3")	-	B-420
31	-	B-285	63	-	B-360	93	-	B-420
32 (2", 3")	-	B-300	64 (2", 3")	-	B-360	94 (2", 3")	-	B-420
33	-	B-300	65	-	B-360	95	-	B-420
34 (2", 3")	-	B-300	66 (2", 3")	-	B-360	96 (2", 3")	-	B-420
35	-	B-300	67	-	B-360	97	-	B-420
36 (2", 3")	-	B-300	68 (2", 3")	-	B-360	98 (2", 3")	-	B-420
37	-	B-300	69	-	B-375	99	-	B-430
38 (2", 3")	-	B-300	70 (2", 3")	-	B-375	100 (2", 3")	-	B-430
39	-	B-315	*0" extension length equals base curve with 14" drive and idler ends - no extensions. *Indicates extension length one end only. Blank = Not Available					
40 (2", 3")	-	B-315						

60° S-Curve (One Curve) – TT 28"W – 2" or 3" Centers

The following chart is for a single Curve. To create a Style 11 S-Curve assembly, you must add an additional curve. For additional information, see page J - 17 through J - 24.

Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	
0	-	B-255	41	-	B-330	71	-	B-390	
10* (2", 3")	-	B-270	42 (2", 3")	-	B-330	72 (2", 3")	-	B-390	
11*	-	B-270	43	-	B-330	73	-	B-390	
12* (2", 3")	-	B-270	44 (2", 3")	-	B-330	74 (2", 3")	-	B-390	
13*	-	B-270	45	-	B-345	75	-	B-405	
14* (2", 3")	-	B-270	46 (2", 3")	-	B-345	76 (2", 3")	-	B-405	
15*	-	B-285	47	-	B-345	77	-	B-405	
16* (2", 3")	-	B-285	48 (2", 3")	-	B-345	78 (2", 3")	-	B-405	
17*	-	B-285	49	-	B-345	79	-	B-405	
18* (2", 3")	-	B-285	50 (2", 3")	-	B-345	80 (2", 3")	-	B-405	
19*	-	B-285	51	-	B-345	81	-	B-405	
20 (2", 3")	-	B-285	52 (2", 3")	-	B-345	82 (2", 3")	-	B-405	
21	-	B-285	53	-	B-360	83	-	B-420	
22 (2", 3")	-	B-285	54 (2", 3")	-	B-360	84 (2", 3")	-	B-420	
23	-	B-300	55	-	B-360	85	-	B-420	
24 (2", 3")	-	B-300	56 (2", 3")	-	B-360	86 (2", 3")	-	B-420	
25	-	B-300	57	-	B-360	87	-	B-420	
26 (2", 3")	-	B-300	58 (2", 3")	-	B-360	88 (2", 3")	-	B-420	
27	-	B-300	59	-	B-360	89	-	B-420	
28 (2", 3")	-	B-300	60 (2", 3")	-	B-375	90 (2", 3")	-	B-430	
29	-	B-300	61	-	B-375	91	-	B-430	
30 (2", 3")	-	B-315	62 (2", 3")	-	B-375	92 (2", 3")	-	B-430	
31	-	B-315	63	-	B-375	93	-	B-430	
32 (2", 3")	-	B-315	64 (2", 3")	-	B-375	94 (2", 3")	-	B-430	
33	-	B-315	65	-	B-375	95	-	B-445	
34 (2", 3")	-	B-315	66 (2", 3")	-	B-375	96 (2", 3")	-	B-445	
35	-	B-315	67	-	B-375	97	-	B-445	
36 (2", 3")	-	B-315	68 (2", 3")	-	B-390	98 (2", 3")	-	B-445	
37	-	B-315	69	-	B-390	99	-	B-445	
38 (2", 3")	-	B-330	70 (2", 3")	-	B-390	100 (2", 3")	-	B-445	
39	-	B-330	"0" extension length equals base curve with 14" drive and idler ends - no extensions. *Indicates extension length one end only. Blank = Not Available						
40 (2", 3")	-	B-330							

60° S-Curve (One Curve) – TT – 2” or 3” Centers (34” & 40”W)

The following chart is for a single Curve. To create a Style 11 S-Curve assembly, you must add an additional curve. For additional information, see page J - 17 through J - 24.

Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	
0	-	B-270	41	-	B-360	71	-	B-420	
10* (2", 3")	-	B-300	42 (2", 3")	-	B-360	72 (2", 3")	-	B-420	
11*	-	B-300	43	-	B-360	73	-	B-420	
12* (2", 3")	-	B-300	44 (2", 3")	-	B-360	74 (2", 3")	-	B-420	
13*	-	B-300	45	-	B-360	75	-	B-420	
14* (2", 3")	-	B-300	46 (2", 3")	-	B-360	76 (2", 3")	-	B-420	
15*	-	B-300	47	-	B-375	77	-	B-430	
16* (2", 3")	-	B-300	48 (2", 3")	-	B-375	78 (2", 3")	-	B-430	
17*	-	B-315	49	-	B-375	79	-	B-430	
18* (2", 3")	-	B-315	50 (2", 3")	-	B-375	80 (2", 3")	-	B-430	
19*	-	B-315	51	-	B-375	81	-	B-430	
20 (2", 3")	-	B-315	52 (2", 3")	-	B-375	82 (2", 3")	-	B-445	
21	-	B-315	53	-	B-375	83	-	B-445	
22 (2", 3")	-	B-315	54 (2", 3")	-	B-390	84 (2", 3")	-	B-445	
23	-	B-315	55	-	B-390	85	-	B-445	
24 (2", 3")	-	B-315	56 (2", 3")	-	B-390	86 (2", 3")	-	B-445	
25	-	B-330	57	-	B-390	87	-	B-445	
26 (2", 3")	-	B-330	58 (2", 3")	-	B-390	88 (2", 3")	-	B-445	
27	-	B-330	59	-	B-390	89	-	B-460	
28 (2", 3")	-	B-330	60 (2", 3")	-	B-390	90 (2", 3")	-	B-460	
29	-	B-330	61	-	B-390	91	-	B-460	
30 (2", 3")	-	B-330	62 (2", 3")	-	B-405	92 (2", 3")	-	B-460	
31	-	B-330	63	-	B-405	93	-	B-460	
32 (2", 3")	-	B-345	64 (2", 3")	-	B-405	94 (2", 3")	-	B-460	
33	-	B-345	65	-	B-405	95	-	B-460	
34 (2", 3")	-	B-345	66 (2", 3")	-	B-405	96 (2", 3")	-	B-460	
35	-	B-345	67	-	B-405	97	-	B-470	
36 (2", 3")	-	B-345	68 (2", 3")	-	B-405	98 (2", 3")	-	B-470	
37	-	B-345	69	-	B-420	99	-	B-470	
38 (2", 3")	-	B-345	70 (2", 3")	-	B-420	100 (2", 3")	-	B-470	
39	-	B-345	"0" extension length equals base curve with 14" drive and idler ends - no extensions. *Indicates extension length one end only. Blank = Not Available						
40 (2", 3")	-	B-360							

45° S-Curve (One Curve) – 2'-6" IR – 2" (16" TT Only) or 3" Centers

The following chart is for a single Curve. To create a Style 12 S-Curve assembly, you must add an additional curve. For additional information, see page J - 17 through J - 24.

Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	
0	-	B-190	41	-	B-270	71	-	B-330	
10* (2", 3")	-	B-205	42 (2", 3")	-	B-270	72 (2", 3")	-	B-330	
11*	-	B-205	43	-	B-270	73	-	B-330	
12* (2", 3")	-	B-205	44 (2", 3")	-	B-270	74 (2", 3")	-	B-330	
13*	-	B-210	45	-	B-285	75	-	B-345	
14* (2", 3")	-	B-210	46 (2", 3")	-	B-285	76 (2", 3")	-	B-345	
15*	-	B-225	47	-	B-285	77	-	B-345	
16* (2", 3")	-	B-225	48 (2", 3")	-	B-285	78 (2", 3")	-	B-345	
17*	-	B-225	49	-	B-285	79	-	B-345	
18* (2", 3")	-	B-225	50 (2", 3")	-	B-285	80 (2", 3")	-	B-345	
19*	-	B-225	51	-	B-285	81	-	B-345	
20 (2", 3")	-	B-225	52 (2", 3")	-	B-300	82 (2", 3")	-	B-360	
21	-	B-225	53	-	B-300	83	-	B-360	
22 (2", 3")	-	B-240	54 (2", 3")	-	B-300	84 (2", 3")	-	B-360	
23	-	B-240	55	-	B-300	85	-	B-360	
24 (2", 3")	-	B-240	56 (2", 3")	-	B-300	86 (2", 3")	-	B-360	
25	-	B-240	57	-	B-300	87	-	B-360	
26 (2", 3")	-	B-240	58 (2", 3")	-	B-300	88 (2", 3")	-	B-360	
27	-	B-240	59	-	B-300	89	-	B-360	
28 (2", 3")	-	B-240	60 (2", 3")	-	B-315	90 (2", 3")	-	B-375	
29	-	B-240	61	-	B-315	91	-	B-375	
30 (2", 3")	-	B-255	62 (2", 3")	-	B-315	92 (2", 3")	-	B-375	
31	-	B-255	63	-	B-315	93	-	B-375	
32 (2", 3")	-	B-255	64 (2", 3")	-	B-315	94 (2", 3")	-	B-375	
33	-	B-255	65	-	B-315	95	-	B-375	
34 (2", 3")	-	B-255	66 (2", 3")	-	B-315	96 (2", 3")	-	B-375	
35	-	B-255	67	-	B-330	97	-	B-390	
36 (2", 3")	-	B-255	68 (2", 3")	-	B-330	98 (2", 3")	-	B-390	
37	-	B-270	69	-	B-330	99	-	B-390	
38 (2", 3")	-	B-270	70 (2", 3")	-	B-330	100 (2", 3")	-	B-390	
39	-	B-270	"0" extension length equals base curve with 14" idler end - no extension. *Indicates extension length one end only. Blank = Not Available						
40 (2", 3")	-	B-270							

45° S-Curve (One Curve) – 3'-4" IR TT 22"W – 2" or 3" Centers

The following chart is for a single Curve. To create a Style 12 S-Curve assembly, you must add an additional curve. For additional information, see page J - 17 through J - 24.

Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	Total Ext. Length(s)	Standard V-Belt	Dually V-Belt
0	-	B-205	41	-	B-285	71	-	B-345
10* (2", 3")	-	B-225	42 (2", 3")	-	B-285	72 (2", 3")	-	B-345
11*	-	B-225	43	-	B-285	73	-	B-345
12* (2", 3")	-	B-225	44 (2", 3")	-	B-300	74 (2", 3")	-	B-360
13*	-	B-225	45	-	B-300	75	-	B-360
14* (2", 3")	-	B-240	46 (2", 3")	-	B-300	76 (2", 3")	-	B-360
15*	-	B-240	47	-	B-300	77	-	B-360
16* (2", 3")	-	B-240	48 (2", 3")	-	B-300	78 (2", 3")	-	B-360
17*	-	B-240	49	-	B-300	79	-	B-360
18* (2", 3")	-	B-240	50 (2", 3")	-	B-300	80 (2", 3")	-	B-360
19*	-	B-240	51	-	B-315	81	-	B-375
20 (2", 3")	-	B-240	52 (2", 3")	-	B-315	82 (2", 3")	-	B-375
21	-	B-255	53	-	B-315	83	-	B-375
22 (2", 3")	-	B-255	54 (2", 3")	-	B-315	84 (2", 3")	-	B-375
23	-	B-255	55	-	B-315	85	-	B-375
24 (2", 3")	-	B-255	56 (2", 3")	-	B-315	86 (2", 3")	-	B-375
25	-	B-255	57	-	B-315	87	-	B-375
26 (2", 3")	-	B-255	58 (2", 3")	-	B-315	88 (2", 3")	-	B-375
27	-	B-255	59	-	B-330	89	-	B-390
28 (2", 3")	-	B-255	60 (2", 3")	-	B-330	90 (2", 3")	-	B-390
29	-	B-270	61	-	B-330	91	-	B-390
30 (2", 3")	-	B-270	62 (2", 3")	-	B-330	92 (2", 3")	-	B-390
31	-	B-270	63	-	B-330	93	-	B-390
32 (2", 3")	-	B-270	64 (2", 3")	-	B-330	94 (2", 3")	-	B-390
33	-	B-270	65	-	B-330	95	-	B-390
34 (2", 3")	-	B-270	66 (2", 3")	-	B-345	96 (2", 3")	-	B-405
35	-	B-270	67	-	B-345	97	-	B-405
36 (2", 3")	-	B-285	68 (2", 3")	-	B-345	98 (2", 3")	-	B-405
37	-	B-285	69	-	B-345	99	-	B-405
38 (2", 3")	-	B-285	70 (2", 3")	-	B-345	100 (2", 3")	-	B-405
39	-	B-285	"0" extension length equals base curve with 14" drive and idler ends - no extensions. *Indicates extension length one end only. Blank = Not Available					
40 (2", 3")	-	B-285						

45° S-Curve (One Curve) – 4'-0" IR TT 28"W – 2" or 3" Centers

The following chart is for a single Curve. To create a Style 12 S-Curve assembly, you must add an additional curve. For additional information, see page J - 17 through J - 24.

Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	Total Ext. Length(s)	Standard V-Belt	Dually V-Belt
0	-	B-210	41	-	B-300	71	-	B-360
10* (2", 3")	-	B-240	42 (2", 3")	-	B-300	72 (2", 3")	-	B-360
11*	-	B-240	43	-	B-300	73	-	B-360
12* (2", 3")	-	B-240	44 (2", 3")	-	B-300	74 (2", 3")	-	B-360
13*	-	B-240	45	-	B-315	75	-	B-375
14* (2", 3")	-	B-240	46 (2", 3")	-	B-315	76 (2", 3")	-	B-375
15*	-	B-255	47	-	B-315	77	-	B-375
16* (2", 3")	-	B-255	48 (2", 3")	-	B-315	78 (2", 3")	-	B-375
17*	-	B-255	49	-	B-315	79	-	B-375
18* (2", 3")	-	B-255	50 (2", 3")	-	B-315	80 (2", 3")	-	B-375
19*	-	B-255	51	-	B-315	81	-	B-375
20 (2", 3")	-	B-255	52 (2", 3")	-	B-330	82 (2", 3")	-	B-390
21	-	B-255	53	-	B-330	83	-	B-390
22 (2", 3")	-	B-270	54 (2", 3")	-	B-330	84 (2", 3")	-	B-390
23	-	B-270	55	-	B-330	85	-	B-390
24 (2", 3")	-	B-270	56 (2", 3")	-	B-330	86 (2", 3")	-	B-390
25	-	B-270	57	-	B-330	87	-	B-390
26 (2", 3")	-	B-270	58 (2", 3")	-	B-330	88 (2", 3")	-	B-390
27	-	B-270	59	-	B-330	89	-	B-390
28 (2", 3")	-	B-270	60 (2", 3")	-	B-345	90 (2", 3")	-	B-405
29	-	B-270	61	-	B-345	91	-	B-405
30 (2", 3")	-	B-285	62 (2", 3")	-	B-345	92 (2", 3")	-	B-405
31	-	B-285	63	-	B-345	93	-	B-405
32 (2", 3")	-	B-285	64 (2", 3")	-	B-345	94 (2", 3")	-	B-405
33	-	B-285	65	-	B-345	95	-	B-405
34 (2", 3")	-	B-285	66 (2", 3")	-	B-345	96 (2", 3")	-	B-405
35	-	B-285	67	-	B-360	97	-	B-420
36 (2", 3")	-	B-285	68 (2", 3")	-	B-360	98 (2", 3")	-	B-420
37	-	B-300	69	-	B-360	99	-	B-420
38 (2", 3")	-	B-300	70 (2", 3")	-	B-360	100 (2", 3")	-	B-420
39	-	B-300	"0" extension length equals base curve with 14" drive and idler ends - no extensions. *Indicates extension length one end only. Blank = Not Available					
40 (2", 3")	-	B-300						

45° S-Curve (One Curve) – 5'-0" IR TT – 2" or 3" Centers (34" & 40"W)

The following chart is for a single Curve. To crate a Style 12 S-Curve assembly, you must add an additional curve. For additional information, see page J - 17 through J - 24.

Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	
0	-	B-240	41	-	B-315	71	-	B-375	
10* (2", 3")	-	B-255	42 (2", 3")	-	B-315	72 (2", 3")	-	B-375	
11*	-	B-255	43	-	B-330	73	-	B-390	
12* (2", 3")	-	B-255	44 (2", 3")	-	B-330	74 (2", 3")	-	B-390	
13*	-	B-270	45	-	B-330	75	-	B-390	
14* (2", 3")	-	B-270	46 (2", 3")	-	B-330	76 (2", 3")	-	B-390	
15*	-	B-270	47	-	B-330	77	-	B-390	
16* (2", 3")	-	B-270	48 (2", 3")	-	B-330	78 (2", 3")	-	B-390	
17*	-	B-270	49	-	B-330	79	-	B-390	
18* (2", 3")	-	B-270	50 (2", 3")	-	B-345	80 (2", 3")	-	B-405	
19*	-	B-270	51	-	B-345	81	-	B-405	
20 (2", 3")	-	B-285	52 (2", 3")	-	B-345	82 (2", 3")	-	B-405	
21	-	B-285	53	-	B-345	83	-	B-405	
22 (2", 3")	-	B-285	54 (2", 3")	-	B-345	84 (2", 3")	-	B-405	
23	-	B-285	55	-	B-345	85	-	B-405	
24 (2", 3")	-	B-285	56 (2", 3")	-	B-345	86 (2", 3")	-	B-405	
25	-	B-285	57	-	B-345	87	-	B-405	
26 (2", 3")	-	B-285	58 (2", 3")	-	B-360	88 (2", 3")	-	B-420	
27	-	B-285	59	-	B-360	89	-	B-420	
28 (2", 3")	-	B-300	60 (2", 3")	-	B-360	90 (2", 3")	-	B-420	
29	-	B-300	61	-	B-360	91	-	B-420	
30 (2", 3")	-	B-300	62 (2", 3")	-	B-360	92 (2", 3")	-	B-420	
31	-	B-300	63	-	B-360	93	-	B-420	
32 (2", 3")	-	B-300	64 (2", 3")	-	B-360	94 (2", 3")	-	B-420	
33	-	B-300	65	-	B-375	95	-	B-430	
34 (2", 3")	-	B-300	66 (2", 3")	-	B-375	96 (2", 3")	-	B-430	
35	-	B-315	67	-	B-375	97	-	B-430	
36 (2", 3")	-	B-315	68 (2", 3")	-	B-375	98 (2", 3")	-	B-430	
37	-	B-315	69	-	B-375	99	-	B-430	
38 (2", 3")	-	B-315	70 (2", 3")	-	B-375	100 (2", 3")	-	B-445	
39	-	B-315	"0" extension length equals base curve with 14" drive and idler ends - no extensions. *Indicates extension length one end only. Blank = Not Available						
40 (2", 3")	-	B-315							

30° S-Curve (One Curve) – 2'-6" IR – 2" (16" TT Only) or 3" Centers

The following chart is for a single Curve. To create a Style 13 S-Curve assembly, you must add an additional curve. For additional information, see page J - 17 through J - 24.

Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	Total Ext. Length(s)	Standard V-Belt	Dually V-Belt
0	-	B-173	41	-	B-255	71	-	B-315
10* (2", 3")	-	B-190	42 (2", 3")	-	B-255	72 (2", 3")	-	B-315
11*	-	B-190	43	-	B-255	73	-	B-315
12* (2", 3")	-	B-190	44 (2", 3")	-	B-255	74 (2", 3")	-	B-315
13*	-	B-190	45	-	B-255	75	-	B-315
14* (2", 3")	-	B-195	46 (2", 3")	-	B-270	76 (2", 3")	-	B-330
15*	-	B-195	47	-	B-270	77	-	B-330
16* (2", 3")	-	B-195	48 (2", 3")	-	B-270	78 (2", 3")	-	B-330
17*	-	B-205	49	-	B-270	79	-	B-330
18* (2", 3")	-	B-205	50 (2", 3")	-	B-270	80 (2", 3")	-	B-330
19*	-	B-205	51	-	B-270	81	-	B-330
20 (2", 3")	-	B-205	52 (2", 3")	-	B-270	82 (2", 3")	-	B-330
21	-	B-205	53	-	B-285	83	-	B-345
22 (2", 3")	-	B-210	54 (2", 3")	-	B-285	84 (2", 3")	-	B-345
23	-	B-210	55	-	B-285	85	-	B-345
24 (2", 3")	-	B-225	56 (2", 3")	-	B-285	86 (2", 3")	-	B-345
25	-	B-225	57	-	B-285	87	-	B-345
26 (2", 3")	-	B-225	58 (2", 3")	-	B-285	88 (2", 3")	-	B-345
27	-	B-225	59	-	B-285	89	-	B-345
28 (2", 3")	-	B-225	60 (2", 3")	-	B-285	90 (2", 3")	-	B-345
29	-	B-225	61	-	B-300	91	-	B-360
30 (2", 3")	-	B-225	62 (2", 3")	-	B-300	92 (2", 3")	-	B-360
31	-	B-240	63	-	B-300	93	-	B-360
32 (2", 3")	-	B-240	64 (2", 3")	-	B-300	94 (2", 3")	-	B-360
33	-	B-240	65	-	B-300	95	-	B-360
34 (2", 3")	-	B-240	66 (2", 3")	-	B-300	96 (2", 3")	-	B-360
35	-	B-240	67	-	B-300	97	-	B-360
36 (2", 3")	-	B-240	68 (2", 3")	-	B-315	98 (2", 3")	-	B-375
37	-	B-240	69	-	B-315	99	-	B-375
38 (2", 3")	-	B-255	70 (2", 3")	-	B-315	100 (2", 3")	-	B-375
39	-	B-255	"0" extension length equals base curve with 14" idler end - no extension. *Indicates extension length one end only. Blank = Not Available					
40 (2", 3")	-	B-255						

30° S-Curve (One Curve) – 3'-4" IR TT 22"W – 2" or 3" Centers

The following chart is for a single Curve. To create a Style 13 S-Curve assembly, you must add an additional curve. For additional information, see page J - 17 through J - 24.

Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	
0	-	B-180	41	-	B-270	71	-	B-330	
10* (2", 3")	-	B-195	42 (2", 3")	-	B-270	72 (2", 3")	-	B-330	
11*	-	B-205	43	-	B-270	73	-	B-330	
12* (2", 3")	-	B-205	44 (2", 3")	-	B-270	74 (2", 3")	-	B-330	
13*	-	B-205	45	-	B-270	75	-	B-330	
14* (2", 3")	-	B-205	46 (2", 3")	-	B-270	76 (2", 3")	-	B-330	
15*	-	B-205	47	-	B-270	77	-	B-330	
16* (2", 3")	-	B-210	48 (2", 3")	-	B-285	78 (2", 3")	-	B-345	
17*	-	B-210	49	-	B-285	79	-	B-345	
18* (2", 3")	-	B-210	50 (2", 3")	-	B-285	80 (2", 3")	-	B-345	
19*	-	B-225	51	-	B-285	81	-	B-345	
20 (2", 3")	-	B-225	52 (2", 3")	-	B-285	82 (2", 3")	-	B-345	
21	-	B-225	53	-	B-285	83	-	B-345	
22 (2", 3")	-	B-225	54 (2", 3")	-	B-285	84 (2", 3")	-	B-345	
23	-	B-225	55	-	B-285	85	-	B-345	
24 (2", 3")	-	B-225	56 (2", 3")	-	B-300	86 (2", 3")	-	B-360	
25	-	B-225	57	-	B-300	87	-	B-360	
26 (2", 3")	-	B-240	58 (2", 3")	-	B-300	88 (2", 3")	-	B-360	
27	-	B-240	59	-	B-300	89	-	B-360	
28 (2", 3")	-	B-240	60 (2", 3")	-	B-300	90 (2", 3")	-	B-360	
29	-	B-240	61	-	B-300	91	-	B-360	
30 (2", 3")	-	B-240	62 (2", 3")	-	B-300	92 (2", 3")	-	B-360	
31	-	B-240	63	-	B-315	93	-	B-375	
32 (2", 3")	-	B-240	64 (2", 3")	-	B-315	94 (2", 3")	-	B-375	
33	-	B-255	65	-	B-315	95	-	B-375	
34 (2", 3")	-	B-255	66 (2", 3")	-	B-315	96 (2", 3")	-	B-375	
35	-	B-255	67	-	B-315	97	-	B-375	
36 (2", 3")	-	B-255	68 (2", 3")	-	B-315	98 (2", 3")	-	B-375	
37	-	B-255	69	-	B-315	99	-	B-375	
38 (2", 3")	-	B-255	70 (2", 3")	-	B-315	100 (2", 3")	-	B-390	
39	-	B-255	"0" extension length equals base curve with 14" drive and idler ends - no extensions.						
40 (2", 3")	-	B-255	*Indicates extension length one end only. Blank = Not Available						

30° S-Curve (One Curve) – 4'-0" IR TT 28"W – 2" or 3" Centers

The following chart is for a single Curve. To create a Style 13 S-Curve assembly, you must add an additional curve. For additional information, see page J - 17 through J - 24.

Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	Total Ext. Length(s)	Standard V-Belt	Dually V-Belt
0	-	B-190	41	-	B-270	71	-	B-330
10* (2", 3")	-	B-205	42 (2", 3")	-	B-270	72 (2", 3")	-	B-330
11*	-	B-205	43	-	B-270	73	-	B-330
12* (2", 3")	-	B-210	44 (2", 3")	-	B-285	74 (2", 3")	-	B-345
13*	-	B-210	45	-	B-285	75	-	B-345
14* (2", 3")	-	B-210	46 (2", 3")	-	B-285	76 (2", 3")	-	B-345
15*	-	B-225	47	-	B-285	77	-	B-345
16* (2", 3")	-	B-225	48 (2", 3")	-	B-285	78 (2", 3")	-	B-345
17*	-	B-225	49	-	B-285	79	-	B-345
18* (2", 3")	-	B-225	50 (2", 3")	-	B-285	80 (2", 3")	-	B-345
19*	-	B-225	51	-	B-300	81	-	B-360
20 (2", 3")	-	B-225	52 (2", 3")	-	B-300	82 (2", 3")	-	B-360
21	-	B-240	53	-	B-300	83	-	B-360
22 (2", 3")	-	B-240	54 (2", 3")	-	B-300	84 (2", 3")	-	B-360
23	-	B-240	55	-	B-300	85	-	B-360
24 (2", 3")	-	B-240	56 (2", 3")	-	B-300	86 (2", 3")	-	B-360
25	-	B-240	57	-	B-300	87	-	B-360
26 (2", 3")	-	B-240	58 (2", 3")	-	B-300	88 (2", 3")	-	B-360
27	-	B-240	59	-	B-315	89	-	B-375
28 (2", 3")	-	B-240	60 (2", 3")	-	B-315	90 (2", 3")	-	B-375
29	-	B-255	61	-	B-315	91	-	B-375
30 (2", 3")	-	B-255	62 (2", 3")	-	B-315	92 (2", 3")	-	B-375
31	-	B-255	63	-	B-315	93	-	B-375
32 (2", 3")	-	B-255	64 (2", 3")	-	B-315	94 (2", 3")	-	B-375
33	-	B-255	65	-	B-315	95	-	B-375
34 (2", 3")	-	B-255	66 (2", 3")	-	B-330	96 (2", 3")	-	B-390
35	-	B-255	67	-	B-330	97	-	B-390
36 (2", 3")	-	B-270	68 (2", 3")	-	B-330	98 (2", 3")	-	B-390
37	-	B-270	69	-	B-330	99	-	B-390
38 (2", 3")	-	B-270	70 (2", 3")	-	B-330	100 (2", 3")	-	B-390
39	-	B-270	"0" extension length equals base curve with 14" drive and idler ends - no extensions. *Indicates extension length one end only. Blank = Not Available					
40 (2", 3")	-	B-270						

30° S-Curve (One Curve) – 5'-0" IR TT 34" & 40"W – 2" or 3" Centers

The following chart is for a single Curve. To create a Style 13 S-Curve assembly, you must add an additional curve. For additional information, see page J - 17 through J - 24.

Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	
0	-	B-195	41	-	B-285	71	-	B-345	
10* (2", 3")	-	B-225	42 (2", 3")	-	B-285	72 (2", 3")	-	B-345	
11*	-	B-225	43	-	B-285	73	-	B-345	
12* (2", 3")	-	B-225	44 (2", 3")	-	B-285	74 (2", 3")	-	B-345	
13*	-	B-225	45	-	B-300	75	-	B-360	
14* (2", 3")	-	B-225	46 (2", 3")	-	B-300	76 (2", 3")	-	B-360	
15*	-	B-240	47	-	B-300	77	-	B-360	
16* (2", 3")	-	B-240	48 (2", 3")	-	B-300	78 (2", 3")	-	B-360	
17*	-	B-240	49	-	B-300	79	-	B-360	
18* (2", 3")	-	B-240	50 (2", 3")	-	B-300	80 (2", 3")	-	B-360	
19*	-	B-240	51	-	B-300	81	-	B-360	
20 (2", 3")	-	B-240	52 (2", 3")	-	B-315	82 (2", 3")	-	B-375	
21	-	B-240	53	-	B-315	83	-	B-375	
22 (2", 3")	-	B-255	54 (2", 3")	-	B-315	84 (2", 3")	-	B-375	
23	-	B-255	55	-	B-315	85	-	B-375	
24 (2", 3")	-	B-255	56 (2", 3")	-	B-315	86 (2", 3")	-	B-375	
25	-	B-255	57	-	B-315	87	-	B-375	
26 (2", 3")	-	B-255	58 (2", 3")	-	B-315	88 (2", 3")	-	B-375	
27	-	B-255	59	-	B-315	89	-	B-375	
28 (2", 3")	-	B-255	60 (2", 3")	-	B-330	90 (2", 3")	-	B-390	
29	-	B-255	61	-	B-330	91	-	B-390	
30 (2", 3")	-	B-270	62 (2", 3")	-	B-330	92 (2", 3")	-	B-390	
31	-	B-270	63	-	B-330	93	-	B-390	
32 (2", 3")	-	B-270	64 (2", 3")	-	B-330	94 (2", 3")	-	B-390	
33	-	B-270	65	-	B-330	95	-	B-390	
34 (2", 3")	-	B-270	66 (2", 3")	-	B-330	96 (2", 3")	-	B-390	
35	-	B-270	67	-	B-345	97	-	B-405	
36 (2", 3")	-	B-270	68 (2", 3")	-	B-345	98 (2", 3")	-	B-405	
37	-	B-285	69	-	B-345	99	-	B-405	
38 (2", 3")	-	B-285	70 (2", 3")	-	B-345	100 (2", 3")	-	B-405	
39	-	B-285	"0" extension length equals base curve with 14" drive and idler ends - no extensions. *Indicates extension length one end only. Blank = Not Available						
40 (2", 3")	-	B-285							

Style 14 or 14P 30°, Style 18 or 18P 45° Spur – 2” or 3” Centers (16”, 22” & 28”W)

10” minimum extension length. For additional information, see page J - 13.

Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	Total Ext. Length(s)	Standard V-Belt	Dually V-Belt
0	B-136	-	41	-	B-300	71	-	B-360
10* (2", 3")	-	B-240	42 (2", 3")	-	B-300	72 (2", 3")	-	B-360
11*	B-158	-	43	-	B-315	73	-	B-375
12* (2", 3")	-	B-240	44 (2", 3")	B-225	-	74 (2", 3")	B-285	-
13*	B-162	-	45	-	B-315	75	-	B-375
14* (2", 3")	-	B-255	46 (2", 3")	-	B-315	76 (2", 3")	-	B-375
15*	-	B-255	47	-	B-315	77	-	B-375
16* (2", 3")	-	B-255	48 (2", 3")	-	B-315	78 (2", 3")	-	B-375
17*	-	B-255	49	-	B-315	79	-	B-375
18* (2", 3")	B-173	-	50 (2", 3")	-	B-315	80 (2", 3")	-	B-375
19*	B-173	-	51	B-240	-	81	B-300	-
20 (2", 3")	-	B-255	52 (2", 3")	-	B-330	82 (2", 3")	-	B-390
21	-	B-270	53	-	B-330	83	-	B-390
22 (2", 3")	B-180	-	54 (2", 3")	-	B-330	84 (2", 3")	-	B-390
23	-	B-270	55	-	B-330	85	-	B-390
24 (2", 3")	-	B-270	56 (2", 3")	-	B-330	86 (2", 3")	-	B-390
25	-	B-270	57	-	B-330	87	-	B-390
26 (2", 3")	-	B-270	58 (2", 3")	-	B-345	88 (2", 3")	-	B-405
27	B-190	-	59	B-255	-	89	B-315	-
28 (2", 3")	-	B-285	60 (2", 3")	-	B-345	90 (2", 3")	-	B-405
29	B-195	-	61	-	B-345	91	-	B-405
30 (2", 3")	B-195	-	62 (2", 3")	-	B-345	92 (2", 3")	-	B-405
31	-	B-285	63	-	B-345	93	-	B-405
32 (2", 3")	-	B-285	64 (2", 3")	-	B-345	94 (2", 3")	-	B-405
33	-	B-285	65	-	B-345	95	-	B-405
34 (2", 3")	-	B-285	66 (2", 3")	B-270	-	96 (2", 3")	B-330	-
35	B-205	-	67	-	B-360	97	-	B-420
36 (2", 3")	-	B-300	68 (2", 3")	-	B-360	98 (2", 3")	-	B-420
37	B-210	-	69	-	B-360	99	-	B-420
38 (2", 3")	-	B-300	70 (2", 3")	-	B-360	100 (2", 3")	-	B-420
39	-	B-300	"0" extension length equals base spur with 14" drive idler end - no extensions. *Indicates extension length one end only. Blank = Not Available					
40 (2", 3")	-	B-300						

Style 14 or 14P 30°, Style 18 or 18P 45° Spur – 2” or 3” Centers (34” & 40”W)

10” minimum extension length. For additional information, see page J - 13.

Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	
0	B-195	-	41	-	B-360	71	-	B-420	
10* (2", 3")	-	B-300	42 (2", 3")	-	B-360	72 (2", 3")	-	B-420	
11*	-	B-300	43	-	B-375	73	-	B-430	
12* (2", 3")	-	B-300	44 (2", 3")	B-285	-	74 (2", 3")	B-345	-	
13*	-	B-315	45	-	B-375	75	-	B-430	
14* (2", 3")	B-225	-	46 (2", 3")	-	B-375	76 (2", 3")	-	B-430	
15*	-	B-315	47	-	B-375	77	-	B-430	
16* (2", 3")	-	B-315	48 (2", 3")	-	B-375	78 (2", 3")	-	B-445	
17*	-	B-315	49	-	B-375	79	-	B-445	
18* (2", 3")	-	B-315	50 (2", 3")	-	B-375	80 (2", 3")	-	B-445	
19*	-	B-315	51	B-300	-	81	B-360	-	
20 (2", 3")	-	B-315	52 (2", 3")	-	B-390	82 (2", 3")	-	B-445	
21	B-240	-	53	-	B-390	83	-	B-445	
22 (2", 3")	-	B-330	54 (2", 3")	-	B-390	84 (2", 3")	-	B-445	
23	-	B-330	55	-	B-390	85	-	B-445	
24 (2", 3")	-	B-330	56 (2", 3")	-	B-390	86 (2", 3")	-	B-460	
25	-	B-330	57	-	B-390	87	-	B-460	
26 (2", 3")	-	B-330	58 (2", 3")	-	B-405	88 (2", 3")	-	B-460	
27	-	B-330	59	B-315	-	89	B-375	-	
28 (2", 3")	-	B-345	60 (2", 3")	-	B-405	90 (2", 3")	-	B-460	
29	B-255	-	61	-	B-405	91	-	B-460	
30 (2", 3")	-	B-345	62 (2", 3")	-	B-405	92 (2", 3")	-	B-460	
31	-	B-345	63	-	B-405	93	-	B-470	
32 (2", 3")	-	B-345	64 (2", 3")	-	B-405	94 (2", 3")	-	B-470	
33	-	B-345	65	-	B-405	95	-	B-470	
34 (2", 3")	-	B-345	66 (2", 3")	B-330	-	96 (2", 3")	B-390	-	
35	-	B-345	67	-	B-420	97	-	B-470	
36 (2", 3")	B-270	-	68 (2", 3")	-	B-420	98 (2", 3")	-	B-480	
37	-	B-360	69	-	B-420	99	-	B-480	
38 (2", 3")	-	B-360	70 (2", 3")	-	B-420	100 (2", 3")	-	B-480	
39	-	B-360	"0" extension length equals base spur with 14" drive idler end - no extensions. *Indicates extension length one end only. Blank = Not Available						
40 (2", 3")	-	B-360							

Style 15 or 15P 30° Spur With 60° Curve – 2'-6" IR – 2" (16" - 28"W) or 3" Centers

24" tangents each end is obtained by adding 24" extension on the infeed and 10" extension on the discharge end (Curve). 20" and above can be split between the infeed and discharge ends or extended on one end only. For additional information, see page J - 15. 3" centers available in 16", 22", and 28" widths; 2" centers available in true taper 16" width only. See special note regarding 2" centers on page J - 26.

Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	Total Ext. Length(s)	Standard V-Belt	Dually V-Belt
0	-	B-285	41	-	B-375	71	-	B-430
10* (2", 3")	B-225	-	42 (2", 3")	-	B-375	72 (2", 3")	-	B-430
11*	-	B-315	43	-	B-375	73	-	B-445
12* (2", 3")	-	B-315	44 (2", 3")	-	B-375	74 (2", 3")	-	B-445
13*	-	B-315	45	-	B-390	75	-	B-445
14* (2", 3")	-	B-315	46 (2", 3")	-	B-390	76 (2", 3")	-	B-445
15*	-	B-315	47	B-300	-	77	B-360	-
16* (2", 3")	-	B-330	48 (2", 3")	-	B-390	78 (2", 3")	-	B-445
17*	B-240	-	49	-	B-390	79	-	B-445
18* (2", 3")	-	B-330	50 (2", 3")	-	B-390	80 (2", 3")	-	B-460
19*	-	B-330	51	-	B-390	81	-	B-460
20 (2", 3")	-	B-330	52 (2", 3")	-	B-390	82 (2", 3")	-	B-460
21	-	B-330	53	-	B-405	83	-	B-460
22 (2", 3")	-	B-330	54 (2", 3")	-	B-405	84 (2", 3")	-	B-460
23	-	B-345	55	B-315	-	85	B-375	-
24 (2", 3")	-	B-345	56 (2", 3")	-	B-405	86 (2", 3")	-	B-460
25	B-255	-	57	-	B-405	87	-	B-460
26 (2", 3")	-	B-345	58 (2", 3")	-	B-405	88 (2", 3")	-	B-470
27	-	B-345	59	-	B-405	89	-	B-470
28 (2", 3")	-	B-345	60 (2", 3")	-	B-420	90 (2", 3")	-	B-470
29	-	B-345	61	-	B-420	91	-	B-470
30 (2", 3")	-	B-345	62 (2", 3")	B-330	-	92 (2", 3")	B-390	-
31	-	B-360	63	-	B-420	93	-	B-480
32 (2", 3")	B-270	-	64 (2", 3")	-	B-420	94 (2", 3")	-	B-480
33	-	B-360	65	-	B-420	95	-	B-480
34 (2", 3")	-	B-360	66 (2", 3")	-	B-420	96 (2", 3")	-	B-480
35	-	B-360	67	-	B-420	97	-	B-480
36 (2", 3")	-	B-360	68 (2", 3")	-	B-430	98 (2", 3")	-	B-490
37	-	B-360	69	-	B-430	99	-	B-490
38 (2", 3")	-	B-375	70 (2", 3")	B-345	-	100 (2", 3")	B-405	-
39	-	B-375	"0" extension length equals base curve with 14" drive and idler ends - no extensions.					
40 (2", 3")	B-285	-	*Indicates extension length one end only. Blank = Not Available					

Style 15 or 15P 30° Spur With 60° Curve – 2’-6” IR – 3” Centers (34” & 40”W)

24” tangents each end is obtained by adding 24” extension on the infeed and 10” extension on the discharge end (Curve). 20” and above can be split between the infeed and discharge ends or extended on one end only. For additional information, see page J - 15.

Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	Total Ext. Length(s)	Standard V-Belt	Dually V-Belt		
0	-	B-345	41	-	B-430	71	-	B-490		
10*	B-285	-	42	-	B-430	72	-	B-490		
11	-	B-375	43	-	B-445	73	-	B-500		
12	-	B-375	44	-	B-445	74	-	B-500		
13	-	B-375	45	-	B-445	75	-	B-500		
14	-	B-375	46	-	B-445	76	-	B-500		
15	-	B-390	47	B-360	-	77	B-420	-		
16	-	B-390	48	-	B-445	78	-	-		
17*	B-300	-	49	-	B-445	79	-	-		
18	-	B-390	50	-	B-460	80	-	-		
19	-	B-390	51	-	B-460	81	-	-		
20	-	B-390	52	-	B-460	82	B-430	-		
21	-	B-390	53	-	B-460	83	-	-		
22	-	B-390	54	-	B-460	84	-	-		
23	-	B-405	55	B-375	-	85	-	-		
24	-	B-405	56	-	B-460	86	-	-		
25	B-315	-	57	-	B-460	87	-	-		
26	-	B-405	58	-	B-470	88	-	-		
27	-	B-405	59	-	B-470	89	-	-		
28	-	B-405	60	-	B-470	90	B-445	-		
29	-	B-405	61	-	B-470	91	-	-		
30	-	B-420	62	B-390	-	92	-	-		
31	-	B-420	63	-	B-480	93	-	-		
32	B-330	-	64	-	B-480	94	-	-		
33	-	B-420	65	-	B-480	95	-	-		
34	-	B-420	66	-	B-480	96	-	-		
35	-	B-420	67	-	B-480	97	B-460	-		
36	-	B-420	68	-	B-490	98	-	-		
37	-	B-420	69	-	B-490	99	-	-		
38	-	B-430	70	B-405	-	100	-	-		
39	-	B-430	*0” extension length equals base curve with 14” drive and idler ends - no extensions. *Indicates extension length one end only. Blank = Not Available						-	-
40	B-345	-							-	-

Style 15 or 15P 30° Spur With 60° Curve – 3'-4" IR TT 22"W – 2" or 3" Centers

24" tangents each end is obtained by adding 24" extension on the infeed and 10" extension on the discharge end (Curve). 20" and above can be split between the infeed and discharge ends or extended on one end only. For additional information, see page J - 16.

Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	Total Ext. Length(s)	Standard V-Belt	Dually V-Belt		
0	-	B-315	41	-	B-390	71	-	B-460		
10* (2", 3")	-	B-330	42 (2", 3")	-	B-405	72 (2", 3")	-	B-460		
11*	-	B-330	43	-	B-405	73	-	B-460		
12* (2", 3")	-	B-345	44 (2", 3")	B-315	-	74 (2", 3")	B-375	-		
13*	-	B-345	45	-	B-405	75	-	B-460		
14* (2", 3")	B-255	-	46 (2", 3")	-	B-405	76 (2", 3")	-	B-460		
15*	-	B-345	47	-	B-405	77	-	B-470		
16* (2", 3")	-	B-345	48 (2", 3")	-	B-405	78 (2", 3")	-	B-470		
17*	-	B-345	49	-	B-420	79	-	B-470		
18* (2", 3")	-	B-345	50 (2", 3")	-	B-420	80 (2", 3")	-	B-470		
19*	-	B-345	51	B-330	-	81	B-390	-		
20 (2", 3")	-	B-360	52 (2", 3")	-	B-420	82 (2", 3")	-	B-480		
21	B-270	-	53	-	B-420	83	-	B-480		
22 (2", 3")	-	B-360	54 (2", 3")	-	B-420	84 (2", 3")	-	B-480		
23	-	B-360	55	-	B-420	85	-	B-480		
24 (2", 3")	-	B-360	56 (2", 3")	-	B-420	86 (2", 3")	-	B-480		
25	-	B-360	57	-	B-430	87	-	B-490		
26 (2", 3")	-	B-360	58 (2", 3")	-	B-430	88 (2", 3")	-	B-490		
27	-	B-375	59	B-345	-	89	B-405	-		
28 (2", 3")	-	B-375	60 (2", 3")	-	B-430	90 (2", 3")	-	B-490		
29	B-285	-	61	-	B-430	91	-	B-490		
30 (2", 3")	-	B-375	62 (2", 3")	-	B-445	92 (2", 3")	-	B-500		
31	-	B-375	63	-	B-445	93	-	B-500		
32 (2", 3")	-	B-375	64 (2", 3")	-	B-445	94 (2", 3")	-	B-500		
33	-	B-375	65	-	B-445	95	-	B-500		
34 (2", 3")	-	B-390	66 (2", 3")	B-360	-	96 (2", 3")	B-420	-		
35	-	B-390	67	-	B-445	97	-	-		
36 (2", 3")	B-300	-	68 (2", 3")	-	B-445	98 (2", 3")	-	-		
37	-	B-390	69	-	B-460	99	-	-		
38 (2", 3")	-	B-390	70 (2", 3")	-	B-460	100 (2", 3")	-	-		
39	-	B-390	"0" extension length equals base curve with 14" drive and idler ends - no extensions. *Indicates extension length one end only. Blank = Not Available						-	-
40 (2", 3")	-	B-390							-	-

Style 15 or 15P 30° Spur With 60° Curve – 4'-0" IR TT 28"W – 2" or 3" Centers

24" tangents each end is obtained by adding 24" extension on the infeed and 10" extension on the discharge end (Curve). 20" and above can be split between the infeed and discharge ends or extended on one end only. For additional information, see page J - 16.

Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	Total Ext. Length(s)	Standard V-Belt	Dually V-Belt		
0	-	B-330	41	-	B-420	71	-	B-470		
10* (2", 3")	-	B-345	42 (2", 3")	-	B-420	72 (2", 3")	B-390	-		
11*	-	B-360	43	B-330	-	73	-	B-480		
12* (2", 3")	-	B-360	44 (2", 3")	-	B-420	74 (2", 3")	-	B-480		
13*	B-270	-	45	-	B-420	75	-	B-480		
14* (2", 3")	-	B-360	46 (2", 3")	-	B-420	76 (2", 3")	-	B-480		
15*	-	B-360	47	-	B-420	77	-	B-480		
16* (2", 3")	-	B-360	48 (2", 3")	-	B-430	78 (2", 3")	-	B-490		
17*	-	B-360	49	-	B-430	79	-	B-490		
18 (2", 3")	-	B-375	50 (2", 3")	B-345	-	80 (2", 3")	B-405	-		
19	-	B-375	51	-	B-430	81	-	B-490		
20 (2", 3")	B-285	-	52 (2", 3")	-	B-430	82 (2", 3")	-	B-490		
21	-	B-375	53	-	B-445	83	-	B-500		
22 (2", 3")	-	B-375	54 (2", 3")	-	B-445	84 (2", 3")	-	B-500		
23	-	B-375	55	-	B-445	85	-	B-500		
24 (2", 3")	-	B-375	56 (2", 3")	-	B-445	86 (2", 3")	-	B-500		
25	-	B-375	57	-	B-445	87	B-420	-		
26 (2", 3")	-	B-390	58 (2", 3")	B-360	-	88 (2", 3")	-	-		
27	-	B-390	59	-	B-445	89	-	-		
28 (2", 3")	B-300	-	60 (2", 3")	-	B-445	90 (2", 3")	-	-		
29	-	B-390	61	-	B-460	91	-	-		
30 (2", 3")	-	B-390	62 (2", 3")	-	B-460	92 (2", 3")	B-430	-		
31	-	B-390	63	-	B-460	93	-	-		
32 (2", 3")	-	B-390	64 (2", 3")	-	B-460	94 (2", 3")	-	-		
33	-	B-405	65	B-375	-	95	-	-		
34 (2", 3")	-	B-405	66 (2", 3")	-	B-460	96 (2", 3")	-	-		
35	B-315	-	67	-	B-460	97	-	-		
36 (2", 3")	-	B-405	68 (2", 3")	-	B-470	98 (2", 3")	-	-		
37	-	B-405	69	-	B-470	99	-	-		
38 (2", 3")	-	B-405	70 (2", 3")	-	B-470	100 (2", 3")	-	-		
39	-	B-405	*0" extension length equals base curve with 14" drive and idler ends - no extensions. *Indicates extension length one end only. Blank = Not Available							
40 (2", 3")	-	B-405								

Style 15 or 15P 30° Spur With 60° Curve – 5'-0" IR TT 34" & 40"W – 2" or 3" Centers

24" tangents each end is obtained by adding 24" extension on the infeed and 10" extension on the discharge end (Curve). 20" and above can be split between the infeed and discharge ends or extended on one end only. For additional information, see page J - 16.

Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	Total Ext. Length(s)	Standard V-Belt	Dually V-Belt		
0	-	B-420	41	-	B-500	71	-	-		
10 (2", 3")	-	B-445	42 (2", 3")	-	B-500	72 (2", 3")	-	-		
11	-	B-445	43	-	B-500	73	-	-		
12 (2", 3")	-	B-445	44 (2", 3")	B-420	-	74 (2", 3")	B-480	-		
13	-	B-445	45	-	-	75	-	-		
14* (2", 3")	B-360	-	46 (2", 3")	-	-	76 (2", 3")	-	-		
15	-	B-445	47	-	-	77	-	-		
16 (2", 3")	-	B-445	48 (2", 3")	-	-	78 (2", 3")	-	-		
17	-	B-460	49	B-430	-	79	B-490	-		
18 (2", 3")	-	B-460	50 (2", 3")	-	-	80 (2", 3")	-	-		
19	-	B-460	51	-	-	81	-	-		
20 (2", 3")	-	B-460	52 (2", 3")	-	-	82 (2", 3")	-	-		
21	-	B-460	53	-	-	83	-	-		
22 (2", 3")	B-375	-	54 (2", 3")	-	-	84 (2", 3")	B-500	-		
23	-	B-460	55	-	-	85	-	-		
24 (2", 3")	-	B-460	56 (2", 3")	-	-	86 (2", 3")	-	-		
25	-	B-470	57	B-445	-	87	-	-		
26 (2", 3")	-	B-470	58 (2", 3")	-	-	88 (2", 3")	-	-		
27	-	B-470	59	-	-	89	-	-		
28 (2", 3")	-	B-470	60 (2", 3")	-	-	90 (2", 3")	-	-		
29	B-390	-	61	-	-	91	-	-		
30 (2", 3")	-	B-480	62 (2", 3")	-	-	92 (2", 3")	-	-		
31	-	B-480	63	-	-	93	-	-		
32 (2", 3")	-	B-480	64 (2", 3")	B-460	-	94 (2", 3")	-	-		
33	-	B-480	65	-	-	95	-	-		
34 (2", 3")	-	B-480	66 (2", 3")	-	-	96 (2", 3")	-	-		
35	-	B-490	67	-	-	97	-	-		
36 (2", 3")	-	B-490	68 (2", 3")	-	-	98 (2", 3")	-	-		
37	B-405	-	69	B-470	-	99	-	-		
38 (2", 3")	-	B-490	70 (2", 3")	-	-	100 (2", 3")	-	-		
39	-	B-490	"0" extension length equals base curve with 14" drive and idler ends - no extensions. *Indicates extension length one end only. Blank = Not Available						-	-
40 (2", 3")	-	B-500							-	-

Junction Section of Style 16 or 20 – 16”, 22” & 28”W – 2” or 3” Centers

The following chart is for a 30° or 45° Spur with extended V-belt for power transfer. To create a parallel junction, Style 16 or 20, you must add a curve. For additional information, see page J - 25.

Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	
0	-	B-225	41	-	B-300	71	-	B-360	
10* (2", 3")	-	B-240	42 (2", 3")	-	B-300	72 (2", 3")	-	B-360	
11*	-	B-240	43	-	B-315	73	-	B-375	
12* (2", 3")	-	B-240	44 (2", 3")	-	B-315	74 (2", 3")	-	B-375	
13*	-	B-255	45	-	B-315	75	-	B-375	
14* (2", 3")	-	B-255	46 (2", 3")	-	B-315	76 (2", 3")	-	B-375	
15*	-	B-255	47	-	B-315	77	-	B-375	
16* (2", 3")	-	B-255	48 (2", 3")	-	B-315	78 (2", 3")	-	B-375	
17*	-	B-255	49	-	B-315	79	-	B-375	
18* (2", 3")	-	B-255	50 (2", 3")	-	B-315	80 (2", 3")	-	B-390	
19*	-	B-255	51	-	B-330	81	-	B-390	
20 (2", 3")	-	B-255	52 (2", 3")	-	B-330	82 (2", 3")	-	B-390	
21	-	B-270	53	-	B-330	83	-	B-390	
22 (2", 3")	-	B-270	54 (2", 3")	-	B-330	84 (2", 3")	-	B-390	
23	-	B-270	55	-	B-330	85	-	B-390	
24 (2", 3")	-	B-270	56 (2", 3")	-	B-330	86 (2", 3")	-	B-390	
25	-	B-270	57	-	B-330	87	-	B-390	
26 (2", 3")	-	B-270	58 (2", 3")	-	B-345	88 (2", 3")	-	B-405	
27	-	B-270	59	-	B-345	89	-	B-405	
28 (2", 3")	-	B-285	60 (2", 3")	-	B-345	90 (2", 3")	-	B-405	
29	-	B-285	61	-	B-345	91	-	B-405	
30 (2", 3")	-	B-285	62 (2", 3")	-	B-345	92 (2", 3")	-	B-405	
31	-	B-285	63	-	B-345	93	-	B-405	
32 (2", 3")	-	B-285	64 (2", 3")	-	B-345	94 (2", 3")	-	B-405	
33	-	B-285	65	-	B-345	95	-	B-420	
34 (2", 3")	-	B-285	66 (2", 3")	-	B-360	96 (2", 3")	-	B-420	
35	-	B-285	67	-	B-360	97	-	B-420	
36 (2", 3")	-	B-300	68 (2", 3")	-	B-360	98 (2", 3")	-	B-420	
37	-	B-300	69	-	B-360	99	-	B-420	
38 (2", 3")	-	B-300	70 (2", 3")	-	B-360	100 (2", 3")	-	B-420	
39	-	B-300	"0" extension length equals base curve with 14" drive and idler ends - no extensions. *Indicates extension length one end only. Blank = Not Available						
40 (2", 3")	-	B-300							

Junction Section of Style 16 or 20 – 34” & 40”W – 2” or 3” Centers

The following chart is for a 30° or 45° Spur with extended V-belt for power transfer. To create a parallel junction, Style 16 or 20, you must add a curve. For additional information, see page J - 25.

Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	Total Ext. Length(s)	Standard V-Belt	Dually V-Belt		
0	-	B-285	41	-	B-360	71	-	B-420		
10* (2", 3")	-	B-300	42 (2", 3")	-	B-360	72 (2", 3")	-	B-420		
11*	-	B-300	43	-	B-375	73	-	B-430		
12* (2", 3")	-	B-300	44 (2", 3")	-	B-375	74 (2", 3")	-	B-430		
13*	-	B-315	45	-	B-375	75	-	B-430		
14* (2", 3")	-	B-315	46 (2", 3")	-	B-375	76 (2", 3")	-	B-430		
15*	-	B-315	47	-	B-375	77	-	B-430		
16* (2", 3")	-	B-315	48 (2", 3")	-	B-375	78 (2", 3")	-	B-445		
17*	-	B-315	49	-	B-375	79	-	B-445		
18* (2", 3")	-	B-315	50 (2", 3")	-	B-390	80 (2", 3")	-	B-445		
19*	-	B-315	51	-	B-390	81	-	B-445		
20 (2", 3")	-	B-315	52 (2", 3")	-	B-390	82 (2", 3")	-	B-445		
21	-	B-330	53	-	B-390	83	-	B-445		
22 (2", 3")	-	B-330	54 (2", 3")	-	B-390	84 (2", 3")	-	B-445		
23	-	B-330	55	-	B-390	85	-	B-460		
24 (2", 3")	-	B-330	56 (2", 3")	-	B-390	86 (2", 3")	-	B-460		
25	-	B-330	57	-	B-390	87	-	B-460		
26 (2", 3")	-	B-330	58 (2", 3")	-	B-405	88 (2", 3")	-	B-460		
27	-	B-330	59	-	B-405	89	-	B-460		
28 (2", 3")	-	B-345	60 (2", 3")	-	B-405	90 (2", 3")	-	B-460		
29	-	B-345	61	-	B-405	91	-	B-460		
30 (2", 3")	-	B-345	62 (2", 3")	-	B-405	92 (2", 3")	-	B-460		
31	-	B-345	63	-	B-405	93	-	B-470		
32 (2", 3")	-	B-345	64 (2", 3")	-	B-405	94 (2", 3")	-	B-470		
33	-	B-345	65	-	B-420	95	-	B-470		
34 (2", 3")	-	B-345	66 (2", 3")	-	B-420	96 (2", 3")	-	B-470		
35	-	B-345	67	-	B-420	97	-	B-470		
36 (2", 3")	-	B-360	68 (2", 3")	-	B-420	98 (2", 3")	-	B-480		
37	-	B-360	69	-	B-420	99	-	B-480		
38 (2", 3")	-	B-360	70 (2", 3")	-	B-420	100 (2", 3")	-	B-480		
39	-	B-360	"0" extension length equals base curve with 14" drive and idler ends - no extensions.							
40 (2", 3")	-	B-360	*Indicates extension length one end only. Blank = Not Available							

Style 19 or 19P 45° Spur Curve 45°– 2’-6” IR 16” - 28”W – 2” or 3” Centers

24” tangents one end is obtained by adding 10” extension. 20” and above can be split between the infeed and discharge ends or extended on one end only. For additional information, see page J - 15. 3” centers available in 16”, 22”, and 28” widths; 2” centers available in true taper 16” width only. See special note regarding 2” centers on page J - 26.

Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	Total Ext. Length(s)	Standard V-Belt	Dually V-Belt
0	-	B-270	41	B-270	-	71	B-330	-
10* (2", 3")	B-205	-	42 (2", 3")	-	B-360	72 (2", 3")	-	B-420
11*	-	B-300	43	-	B-360	73	-	B-420
12* (2", 3")	B-210	-	44 (2", 3")	-	B-360	74 (2", 3")	-	B-420
13*	-	B-300	45	-	B-360	75	-	B-420
14* (2", 3")	-	B-300	46 (2", 3")	-	B-360	76 (2", 3")	-	B-420
15*	-	B-300	47	-	B-360	77	-	B-430
16* (2", 3")	-	B-300	48 (2", 3")	-	B-375	78 (2", 3")	-	B-430
17*	-	B-300	49	B-285	-	79	B-345	-
18* (2", 3")	-	B-315	50 (2", 3")	-	B-375	80 (2", 3")	-	B-430
19*	B-225	-	51	-	B-375	81	-	B-430
20 (2", 3")	-	B-315	52 (2", 3")	-	B-375	82 (2", 3")	-	B-445
21	-	B-315	53	-	B-375	83	-	B-445
22 (2", 3")	-	B-315	54 (2", 3")	-	B-375	84 (2", 3")	-	B-445
23	-	B-315	55	-	B-390	85	-	B-445
24 (2", 3")	-	B-315	56 (2", 3")	B-300	-	86 (2", 3")	B-360	-
25	-	B-330	57	-	B-390	87	-	B-445
26 (2", 3")	B-240	-	58 (2", 3")	-	B-390	88 (2", 3")	-	B-445
27	-	B-330	59	-	B-390	89	-	B-445
28 (2", 3")	-	B-330	60 (2", 3")	-	B-390	90 (2", 3")	-	B-460
29	-	B-330	61	-	B-390	91	-	B-460
30 (2", 3")	-	B-330	62 (2", 3")	-	B-405	92 (2", 3")	-	B-460
31	-	B-330	63	-	B-405	93	-	B-460
32 (2", 3")	-	B-330	64 (2", 3")	B-315	-	94 (2", 3")	B-375	-
33	-	B-345	65	-	B-405	95	-	B-460
34 (2", 3")	B-255	-	66 (2", 3")	-	B-405	96 (2", 3")	-	B-460
35	-	B-345	67	-	B-405	97	-	B-470
36 (2", 3")	-	B-345	68 (2", 3")	-	B-405	98 (2", 3")	-	B-470
37	-	B-345	69	-	B-405	99	-	B-470
38 (2", 3")	-	B-345	70 (2", 3")	-	B-420	100 (2", 3")	-	B-470
39	-	B-345	"0" extension length equals base curve with 14" end - no extension. *Indicates extension length one end only. Blank = Not Available					
40 (2", 3")	-	B-360						

Style 19 or 19P 45° Spur With 45° Curve – 2’-6” IR 34” & 40”W – 3” Centers

24” tangents one end is obtained by adding 10” extension. 20” and above can be split between the infeed and discharge ends or extended on one end only. For additional information, see page J - 15.

Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	Total Ext. Length(s)	Standard V-Belt	Dually V-Belt		
0	-	B-330	41	B-330	-	71	B-390	-		
10*	-	B-360	42	-	B-420	72	-	B-480		
11*	B-270	-	43	-	B-420	73	-	B-480		
12*	-	B-360	44	-	B-420	74	-	B-480		
13*	-	B-360	45	-	B-420	75	-	B-480		
14*	-	B-360	46	-	B-420	76	-	B-480		
15*	-	B-360	47	-	B-430	77	-	B-490		
16*	-	B-360	48	-	B-430	78	-	B-490		
17*	-	B-360	49	B-345	-	79	B-405	-		
18	-	B-375	50	-	B-430	80	-	B-490		
19*	B-285	-	51	-	B-430	81	-	B-490		
20	-	B-375	52	-	B-445	82	-	B-500		
21	-	B-375	53	-	B-445	83	-	B-500		
22	-	B-375	54	-	B-445	84	-	B-500		
23	-	B-375	55	-	B-445	85	-	B-500		
24	-	B-375	56	B-360	-	86	B-420	-		
25	-	B-390	57	-	B-445	87	-	-		
26	B-300	-	58	-	B-445	88	-	-		
27	-	B-390	59	-	B-445	89	-	-		
28	-	B-390	60	-	B-460	90	-	-		
29	-	B-390	61	-	B-460	91	B-430	-		
30	-	B-390	62	-	B-460	92	-	-		
31	-	B-390	63	-	B-460	93	-	-		
32	-	B-405	64	B-375	-	94	-	-		
33	-	B-405	65	-	B-460	95	-	-		
34	B-315	-	66	-	B-460	96	-	-		
35	-	B-405	67	-	B-470	97	-	-		
36	-	B-405	68	-	B-470	98	-	-		
37	-	B-405	69	-	B-470	99	B-445	-		
38	-	B-405	70	-	B-470	100	-	-		
39	-	B-405	"0" extension length equals base curve with 14" end - no extension. *Indicates extension length one end only. Blank = Not Available						-	-
40	-	B-420							-	-

Style 19 – 45° Spur With 45° Curve – 3'-4" IR TT 22"W – 2" or 3" Centers

24" tangents one end is obtained by adding 10" extension. 20" and above can be split between the infeed and discharge ends or extended on one end only. For additional information, see page J - 16.

Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	Total Ext. Length(s)	Standard V-Belt	Dually V-Belt
0	-	B-285	41	B-285	-	71	B-345	-
10* (2", 3")	-	B-315	42 (2", 3")	-	B-375	72 (2", 3")	-	B-430
11*	B-225	0	43	-	B-375	73	-	B-430
12* (2", 3")	-	B-315	44 (2", 3")	-	B-375	74 (2", 3")	-	B-445
13*	-	B-315	45	-	B-375	75	-	B-445
14* (2", 3")	-	B-315	46 (2", 3")	-	B-375	76 (2", 3")	-	B-445
15*	-	B-315	47	-	B-390	77	-	B-445
16* (2", 3")	-	B-315	48 (2", 3")	B-300	-	78 (2", 3")	B-360	-
17*	-	B-330	49	-	B-390	79	-	B-445
18* (2", 3")	B-240	-	50 (2", 3")	-	B-390	80 (2", 3")	-	B-445
19*	-	B-330	51	-	B-390	81	-	B-445
20 (2", 3")	-	B-330	52 (2", 3")	-	B-390	82 (2", 3")	-	B-460
21	-	B-330	53	-	B-390	83	-	B-460
22 (2", 3")	-	B-330	54 (2", 3")	-	B-405	84 (2", 3")	-	B-460
23	-	B-330	55	-	B-405	85	-	B-460
24 (2", 3")	-	B-345	56 (2", 3")	B-315	-	86 (2", 3")	B-375	-
25	-	B-345	57	-	B-405	87	-	B-460
26 (2", 3")	B-255	-	58 (2", 3")	-	B-405	88 (2", 3")	-	B-460
27	-	B-345	59	-	B-405	89	-	B-470
28 (2", 3")	-	B-345	60 (2", 3")	-	B-405	90 (2", 3")	-	B-470
29	-	B-345	61	-	B-405	91	-	B-470
30 (2", 3")	-	B-345	62 (2", 3")	-	B-420	92 (2", 3")	-	B-470
31	-	B-345	63	B-330	-	93	B-390	-
32 (2", 3")	-	B-360	64 (2", 3")	-	B-420	94 (2", 3")	-	B-480
33	B-270	-	65	-	B-420	95	-	B-480
34 (2", 3")	-	B-360	66 (2", 3")	-	B-420	96 (2", 3")	-	B-480
35	-	B-360	67	-	B-420	97	-	B-480
36 (2", 3")	-	B-360	68 (2", 3")	-	B-420	98 (2", 3")	-	B-480
37	-	B-360	69	-	B-430	99	-	B-490
38 (2", 3")	-	B-360	70 (2", 3")	-	B-430	100 (2", 3")	-	B-490
39	-		"0" extension length equals base curve with 14" end - no extension.					
40 (2", 3")	-		*Indicates extension length one end only. Blank = Not Available					

Style 19 – 45° Spur With 45° Curve – 4'-0" IR – TT – 28"W – 2" or 3" Centers

24" tangents one end is obtained by adding 10" extension. 20" and above can be split between the infeed and discharge ends or extended on one end only. For additional information, see page J - 16.

Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	Total Ext. Length(s)	Standard V-Belt	Dually V-Belt		
0	-	B-300	41	-	B-390	71	-	B-445		
10* (2", 3")	-	B-330	42 (2", 3")	B-300	-	72 (2", 3")	B-360	-		
11*	-	B-330	43	-	B-390	73	-	B-445		
12* (2", 3")	B-240	-	44 (2", 3")	-	B-390	74 (2", 3")	-	B-445		
13*	-	B-330	45	-	B-390	75	-	B-460		
14* (2", 3")	-	B-330	46 (2", 3")	-	B-390	76 (2", 3")	-	B-460		
15*	-	B-330	47	-	B-390	77	-	B-460		
16* (2", 3")	-	B-330	48 (2", 3")	-	B-405	78 (2", 3")	-	B-460		
17*	-	B-330	49	B-315	-	79	B-375	-		
18* (2", 3")	-	B-345	50 (2", 3")	-	B-405	80 (2", 3")	-	B-460		
19*	B-255	-	51	-	B-405	81	-	B-460		
20 (2", 3")	-	B-345	52 (2", 3")	-	B-405	82 (2", 3")	-	B-460		
21	-	B-345	53	-	B-405	83	-	B-470		
22 (2", 3")	-	B-345	54 (2", 3")	-	B-405	84 (2", 3")	-	B-470		
23	-	B-345	55	-	B-420	85	-	B-470		
24 (2", 3")	-	B-345	56 (2", 3")	-	B-420	86 (2", 3")	-	B-470		
25	-	B-360	57	B-330	-	87	B-390	-		
26 (2", 3")	-	B-360	58 (2", 3")	-	B-420	88 (2", 3")	-	B-480		
27	B-270	-	59	-	B-420	89	-	B-480		
28 (2", 3")	-	B-360	60 (2", 3")	-	B-420	90 (2", 3")	-	B-480		
29	-	B-360	61	-	B-420	91	-	B-480		
30 (2", 3")	-	B-360	62 (2", 3")	-	B-420	92 (2", 3")	-	B-480		
31	-	B-360	63	-	B-430	93	-	B-490		
32 (2", 3")	-	B-360	64 (2", 3")	B-345	-	94 (2", 3")	B-405	-		
33	-	B-375	65	-	B-430	95	-	B-490		
34 (2", 3")	B-285	-	66 (2", 3")	-	B-430	96 (2", 3")	-	B-490		
35	-	B-375	67	-	B-430	97	-	B-490		
36 (2", 3")	-	B-375	68 (2", 3")	-	B-445	98 (2", 3")	-	B-500		
37	-	B-375	69	-	B-445	99	-	B-500		
38 (2", 3")	-	B-375	70 (2", 3")	-	B-445	100 (2", 3")	-	B-500		
39	-	B-375	"0" extension length equals base curve with 14" end - no extensions. *Indicates extension length one end only. Blank = Not Available							
40 (2", 3")	-	B-390								

Style 19 – 45° Spur With 45° Curve – 5'-0" IR TT 34" & 40"W – 2" or 3" Centers

24" tangents one end is obtained by adding 10" extension. 20" and above can be split between the infeed and discharge ends or extended on one end only. For additional information, see page J - 16.

Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	Total Ext. Length(s)	Standard V-Belt	Dually V-Belt		
0	-	B-375	41	-	B-460	71	-	-		
10* (2", 3")	B-315	-	42 (2", 3")	-	B-460	72 (2", 3")	-	-		
11	-	B-405	43	-	B-470	73	-	-		
12 (2", 3")	-	B-405	44 (2", 3")	-	B-470	74 (2", 3")	-	-		
13	-	B-405	45	-	B-470	75	B-445	-		
14 (2", 3")	-	B-405	46 (2", 3")	-	B-470	76 (2", 3")	-	-		
15	-	B-405	47	B-390	-	77	-	-		
16 (2", 3")	-	B-420	48 (2", 3")	-	B-480	78 (2", 3")	-	-		
17*	B-330	-	49	-	B-480	79	-	-		
18 (2", 3")	-	B-420	50 (2", 3")	-	B-480	80 (2", 3")	-	-		
19	-	B-420	51	-	B-480	81	-	-		
20 (2", 3")	-	B-420	52 (2", 3")	-	B-480	82 (2", 3")	B-460	-		
21	-	B-420	53	-	B-490	83	-	-		
22 (2", 3")	-	B-420	54 (2", 3")	-	B-490	84 (2", 3")	-	-		
23	-	B-430	55	B-405	-	85	-	-		
24 (2", 3")	-	B-430	56 (2", 3")	-	B-490	86 (2", 3")	-	-		
25	B-345	-	57	-	B-490	87	B-470	-		
26 (2", 3")	-	B-430	58 (2", 3")	-	B-500	88 (2", 3")	-	-		
27	-	B-430	59	-	B-500	89	-	-		
28 (2", 3")	-	B-445	60 (2", 3")	-	B-500	90 (2", 3")	-	-		
29	-	B-445	61	-	B-500	91	-	-		
30 (2", 3")	-	B-445	62 (2", 3")	B-420	-	92 (2", 3")	B-480	-		
31	-	B-445	63	-	-	93	-	-		
32 (2", 3")	B-360	-	64 (2", 3")	-	-	94 (2", 3")	-	-		
33	-	B-445	65	-	-	95	-	-		
34 (2", 3")	-	B-445	66 (2", 3")	-	-	96 (2", 3")	-	-		
35	-	B-445	67	B-430	-	97	B-490	-		
36 (2", 3")	-	B-460	68 (2", 3")	-	-	98 (2", 3")	-	-		
37	-	B-460	69	-	-	99	-	-		
38 (2", 3")	-	B-460	70 (2", 3")	-	-	100 (2", 3")	-	-		
39	-	B-460	*0" extension length equals base curve with 14" end - no extensions. *Indicates extension length one end only. Blank = Not Available							
40 (2", 3")	B-375	-								

Style 21 or 21P – 90° Curve Junction – 2’-6” IR – 2” (16”W Only) or 3” Centers

24” tangents one end is obtained by adding 10” extension. Extension can be added to one end only. For additional information, see page J - 14.

Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	
0	B-120	-	41	-	B-285	71	-	B-345	
10	B-140	-	42	-	B-285	72	-	B-345	
11	-	B-225	43	B-205	-	73	-	B-360	
12	B-144	-	44	-	B-300	74	B-270	-	
13	-	B-240	45	B-210	-	75	-	B-360	
14	B-148	-	46	-	B-300	76	-	B-360	
15	B-150	-	47	-	B-300	77	-	B-360	
16	-	B-240	48	-	B-300	78	-	B-360	
17	B-154	-	49	-	B-300	79	-	B-360	
18	-	B-240	50	-	B-315	80	-	B-375	
19	B-158	-	51	-	B-315	81	-	B-375	
20	-	B-255	52	B-255	-	82	B-285	-	
21	B-162	-	53	-	B-315	83	-	B-375	
22	-	B-255	54	-	B-315	84	-	B-375	
23	-	B-255	55	-	B-315	85	-	B-375	
24	-	B-255	56	-	B-315	86	-	B-375	
25	-	B-255	57	-	B-315	87	-	B-390	
26	B-173	-	58	-	B-330	88	-	B-390	
27	B-173	-	59	B-240	-	89	B-300	-	
28	-	B-270	60	-	B-330	90	-	B-390	
29	-	B-270	61	-	B-330	91	-	B-390	
30	B-180	-	62	-	B-330	92	-	B-390	
31	-	B-270	63	-	B-330	93	-	B-390	
32	-	B-270	64	-	B-330	94	-	B-390	
33	-	B-270	65	-	B-345	95	-	B-405	
34	-	B-270	66	-	B-345	96	-	B-405	
35	B-190	-	67	B-255	-	97	B-315	-	
36	-	B-285	68	-	B-345	98	-	B-405	
37	B-195	-	69	-	B-345	99	-	B-405	
38	B-195	-	70	-	B-345	100	-	B-405	
39	-	B-285	"0" extension length equals base curve with 14" end - no extension.						
40	-	B-285							

Style 21 or 21P – 90° Curve Junction – 3'-4" IR – TT 22"W – 2" or 3" Centers

24" tangents one end is obtained by adding 10" extension. Extension can be added to either end of the curve only. For additional information, see page J - 14.

Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	
0	-	B-225	41	B-225	-	71	B-285	-	
10	B-162	-	42	-	B-315	72	-	B-375	
11	-	B-255	43	-	B-315	73	-	B-375	
12	-	B-255	44	-	B-315	74	-	B-375	
13	-	B-255	45	-	B-315	75	-	B-375	
14	-	B-255	46	-	B-315	76	-	B-390	
15	B-173	-	47	-	B-330	77	-	B-390	
16	B-173	-	48	B-240	-	78	B-300	-	
17	-	B-270	49	-	B-330	79	-	B-390	
18	-	B-270	50	-	B-330	80	-	B-390	
19	B-180	-	51	-	B-330	81	-	B-390	
20	-	B-270	52	-	B-330	82	-	B-390	
21	-	B-270	53	-	B-330	83	-	B-390	
22	-	B-270	54	-	B-345	84	-	B-405	
23	-	B-270	55	-	B-345	85	-	B-405	
24	B-190	-	56	B-255	-	86	B-315	-	
25	-	B-285	57	-	B-345	87	-	B-405	
26	B-195	-	58	-	B-345	88	-	B-405	
27	B-195	-	59	-	B-345	89	-	B-405	
28	-	B-285	60	-	B-345	90	-	B-405	
29	-	B-285	61	-	B-345	91	-	B-420	
30	-	B-285	62	-	B-360	92	-	B-420	
31	-	B-285	63	B-270	-	93	B-330	-	
32	B-205	-	64	-	B-360	94	-	B-420	
33	-	B-300	65	-	B-360	95	-	B-420	
34	B-210	-	66	-	B-360	96	-	B-420	
35	-	B-300	67	-	B-360	97	-	B-420	
36	-	B-300	68	-	B-360	98	-	B-420	
37	-	B-300	69	-	B-375	99	-	B-430	
38	-	B-300	70	-	B-375	100	-	B-430	
39	-	B-315	"0" extension length equals base curve with 14" end - no extension.						
40	-	B-315							

Style 21 or 21P – 90° Curve Junction – 4'-0" IR TT 28"W – 2" or 3" Centers

24" tangents one end is obtained by adding 10" extension. Extension can be added to either end of the curve only. For additional information, see page J - 14.

Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	
0	-	B-255	41	-	B-330	71	-	B-390	
10	B-180	-	42	-	B-330	72	-	B-390	
11	-	B-270	43	-	B-330	73	-	B-390	
12	-	B-270	44	-	B-330	74	-	B-390	
13	-	B-270	45	-	B-345	75	-	B-405	
14	-	B-270	46	-	B-345	76	-	B-405	
15	B-190	-	47	B-255	-	77	B-315	-	
16	-	B-285	48	-	B-345	78	-	B-405	
17	B-195	-	49	-	B-345	79	-	B-405	
18	B-195	-	50	-	B-345	80	-	B-405	
19	-	B-285	51	-	B-345	81	-	B-405	
20	-	B-285	52	-	B-345	82	-	B-405	
21	-	B-285	53	-	B-360	83	-	B-420	
22	-	B-285	54	-	B-360	84	-	B-420	
23	B-205	-	55	B-270	-	85	B-330	-	
24	-	B-300	56	-	B-360	86	-	B-420	
25	B-210	-	57	-	B-360	87	-	B-420	
26	-	B-300	58	-	B-360	88	-	B-420	
27	-	B-300	59	-	B-360	89	-	B-420	
28	-	B-300	60	-	B-375	90	-	B-430	
29	-	B-300	61	-	B-375	91	-	B-430	
30	-	B-315	62	B-285	-	92	B-345	-	
31	-	B-315	63	-	B-375	93	-	B-430	
32	B-225	-	64	-	B-375	94	-	B-430	
33	-	B-315	65	-	B-375	95	-	B-445	
34	-	B-315	66	-	B-375	96	-	B-445	
35	-	B-315	67	-	B-375	97	-	B-445	
36	-	B-315	68	-	B-390	98	-	B-445	
37	-	B-315	69	-	B-390	99	-	B-445	
38	-	B-330	70	B-300	-	100	B-360	-	
39	-	B-330	"0" extension length equals base curve with 14" end - no extension.						
40	B-240	-							

Style 21 or 21P – 90° Curve Junction – 5'-0" IR TT 34" & 40"W – 2" or 3" Centers

24" tangents one end is obtained by adding 10" extension. Extension can be added to either end of the curve only. For additional information, see page J - 14.

Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	Total Ext. Length(s)	Standard V-Belt	Dually V-Belt	Total Ext. Length(s)	Standard V-Belt	Dually V-Belt
0	-	B-270	41	B-270	-	71	B-330	-
10	B-205	-	42	-	B-360	72	-	B-420
11	-	B-300	43	-	B-360	73	-	B-420
12	B-210	-	44	-	B-360	74	-	B-420
13	-	B-300	45	-	B-360	75	-	B-420
14	-	B-300	46	-	B-360	76	-	B-420
15	-	B-300	47	-	B-375	77	-	B-430
16	-	B-300	48	-	B-375	78	-	B-430
17	-	B-315	49	B-285	-	79	B-345	-
18	-	B-315	50	-	B-375	80	-	B-430
19	B-225	-	51	-	B-375	81	-	B-430
20	-	B-315	52	-	B-375	82	-	B-445
21	-	B-315	53	-	B-375	83	-	B-445
22	-	B-315	54	-	B-390	84	-	B-445
23	-	B-315	55	-	B-390	85	-	B-445
24	-	B-315	56	B-300	-	86	B-360	-
25	-	B-330	57	-	B-390	87	-	B-445
26	B-240	-	58	-	B-390	88	-	B-445
27	-	B-330	59	-	B-390	89	-	B-460
28	-	B-330	60	-	B-390	90	-	B-460
29	-	B-330	61	-	B-390	91	-	B-460
30	-	B-330	62	-	B-405	92	-	B-460
31	-	B-330	63	-	B-405	93	-	B-460
32	-	B-345	64	B-315	-	94	B-375	-
33	-	B-345	65	-	B-405	95	-	B-460
34	B-255	-	66	-	B-405	96	-	B-460
35	-	B-345	67	-	B-405	97	-	B-470
36	-	B-345	68	-	B-405	98	-	B-470
37	-	B-345	69	-	B-420	99	-	B-470
38	-	B-345	70	-	B-420	100	-	B-470
39	-	B-345	"0" extension length equals base curve with 14" end - no extension.					
40	-	B-360						

